⚠ WARNING

This section only identifies conditions and problems. It does not show repair procedure and does not identify safety hazards needed to safely service related equipment. Always refer to the appropriate manual and review the service process before servicing equipment.

BLAST MACHINE and REMOTE CONTROLS

PROBLEM	CAUSE	SOLUTION
1. Neither Abrasive Nor Air Exits the Nozzle While the Machine is Under Pressure.	Nozzle plugged.	Depressurize the blast machine. After the pop-up valve has dropped, remove the nozzle, and check it for obstruction.
	Metering valve and choke valve closed.	Make sure that both the abrasive metering valve and choke valve are open.
2. Air Only (no abrasive) Exits the Nozzle.	Metering valve closed.	Adjust metering valve.
	Optional abrasive cut-off (ACS) switch closed.	Make sure ACS switch is in the "on" position.
	Blast machine empty.	Check abrasive level in blast machine and/or storage hopper.
	Damp abrasive.	While blasting, close choke valve to clear obstruction. Also, see Problem No. 5 and No. 6.
	Obstruction in metering valve.	Depressurize the blast machine, lockout and tagout the compressed air supply and check metering valve for obstruction.
3. Heavy Abrasive Flow.	Choke valve closed.	Make sure the choke valve is open. The valve is open when the handle is in-line with the piping.
	Abrasive metering valve open too far.	Adjust metering valve.
4. Abrasive Surging. NOTE: A certain amount of surge is normal at start-up.	Excessively rich media mixture.	Adjust metering valve.
	Blockage in abrasive trap or exhaust muffler.	Depressurize the blast machine, check the abrasive trap, and exhaust muffler for blockage. Slow depressurization will load the blast hose with abrasive, and cause surging at start-up. Also, see Problem No. 7.
5. Intermittent Abrasive Flow.	Moisture in the blast machine or air supply.	Drain moisture from the compressor's receiver tank, and the blast machine's filter. If moisture continues, a dryer or after cooler may be required in the air supply line. See problem No. 8.
	Media worn from recycling.	Replace media.

BLAST MACHINE and REMOTE CONTROLS CONTINUED

6. Media Bridging.	Damp media can cause frequent bridging or blockages in the metering valve.	Media becomes damp by blasting parts that are slightly oily, from moisture in the compressed air line, or from absorption.
	When reusing media, look for contamination from the workpiece.	All parts should be clean and dry. If parts are oily or greasy, degrease and dry them prior to blasting.
	Moist compressed air. Faulty compressor pumping moisture into the air line, or from humidity.	Drain the moisture separator and receiver tank regularly. If the problem persists, it may be necessary to change media more often or install an aftercooler or air dryer.
	Absorption.	Some media tends to absorb moisture from the air, especially fine-mesh media in high humidity areas. Store media in a dry area. Store opened media in an airtight container.

7. Blast Machine Does Not Pressurize.	Compressed air supply shut off.	Make sure the compressor is on and all air supply valves to the machine are open.
	Optional door interlocks not engaging.	Check the mechanical and electrical functions of the door interlocks.
	Safety petcock open	Make sure the safety petcock is closed.
	Remote control handle leaking.	Check the rubber button on the control handle for wear or damage, and make sure the opening on the control handle seals when the handle is pressed.
		Press the control handle lever. Feel and listen for air leaks any place on the handle. If there is a leak, it must be located and corrected.
	Leaks in control lines or control line fittings.	Check control lines and fittings for leaks or breaks. All leaks must be located and corrected.
	Blockage in control lines.	Check for air escaping through the opening under the control handle lever. If no air is escaping, check for blockage in the orifice on the inlet valve, or blockage in the control line from the orifice to the control handle. Remove blockage.
		Open the safety petcock, and press the control handle lever; If air does not escape from the petcock, Check the line from the control handle to the return fitting on the inlet valve for blockage. Remove blockage.
	Diaphragm leaking in optional diaphragm outlet valve.	Inspect diaphragm for wear or damage. Replace faulty diaphragm.
	Internal leak in the inlet valve.	Inlet valve requires service. Depressurize the air supply line, lockout and tagout the compressed air supply and service the valve.
	Insufficient-size air supply line.	Check size of supply line. Air supply line should be at least four times the diameter of the nozzle orifice.
	Dirty filter element in air filter.	Depressurize the air supply line, lockout and tagout the compressed air supply and inspect filter element. Replace as necessary.
	Pop-up valve stuck, or internal piping worn, or out of alignment.	Turn off the compressed air supply and inspect internal piping. Replace and realign parts as necessary.

BLAST MACHINE and REMOTE CONTROLS CONTINUED

8. Blast Machine Does Not Depressurize, Or Depressurizes Too Slowly.	Abrasive trap screen blocked, or abrasive trap is full of abrasive.	Make sure machine is depressurized before cleaning the trap at least twice daily.
	Exhaust muffler blocked.	Make sure machine is depressurized before replacing exhaust muffler element.
	Adaptor gasket on the control handle swollen, restricting air flow through the handle.	Inspect gasket, and replace as necessary.
	Blockage in the return line from the inlet valve to the control handle.	Check for blockage in the control hose. Remove blockage or replace hose.
	Check the control handle supply fitting on the inlet valve. It must have a .052" orifice.	Depressurize the air supply line, lockout and tagout the compressed air supply and replace fitting with correct fitting.
	Make sure the inlet valve closes If air can be heard entering the blast machine when it is depressurized, the inlet valve is malfunctioning.	Depressurize the air supply line, lockout and tagout the compressed air supply and service the inlet valve.
	If the outlet valve does not fully exhaust air from the blast machine, the outlet valve is malfunctioning.	Turn off the compressed air supply and service the outlet valve.

9. Outlet Valve Does Not Seal.	Outlet valve requires service.	Turn off the compressed air supply and service the valve.

10. RLX Control Handle Lever Fails to Return to the Up (Non-Blast) Position When Released.	Handle lever binding against the RLX body.	Check the handle lever for interference or damage that prevents it from returning to full "up" position. Replace the handle lever as necessary.
	Return spring damaged or fatigued.	Replace spring.

11. RLX Safety Lever Lock Fails to Pop Up When the Handle is Released.	Lever lock binding.	Check the lever lock for interference or damage that prevents it from returning to full "up" position. Replace the lever lock as necessary.
	Return spring damaged or fatigued.	Replace spring.
12. Abrasive Flow Does Not Stop When the Optional ACS Toggle is Moved to the "OFF" Position.	Exhaust filter on ACS switch clogged.	Replace filter.
	Metering valve requires service.	Depressurize the blast machine, lockout and tagout the air supply and service the metering valve.

BLAST MACHINE and REMOTE CONTROLS CONTINUED

13. No Abrasive When the Optional ACS Toggle is Moved to "ON" Position.	Metering valve closed.	Adjust metering valve.
	Obstruction in abrasive valve or valve requires service	Depressurize blast machine and check metering valve for obstruction. If no obstruction found, service metering valve.
	Air leak or blockage in the single line hose or fittings from the ACS switch to the metering valve	Check control lines and fittings for leaks or breaks. All leaks must be located and corrected. If leaks are not found check for blockage in the control hose. Remove blockage or replace hose.
	Blast machine empty.	Check abrasive level in blast machine and/or storage hopper.