



SERVICE MANUAL 1-10DS Global & TS

VERSION 3.4

Index

| | |
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Inspection comments

| | |
|---|-------|
| Inspection before initial operation on: | _____ |
| By: | _____ |
| Date of initial operation: | _____ |
| Serial number & Year of manufacture: | _____ |

Recurring inspections / maintenance log

| Date / Hour counter | Findings | Repairs / Cleaning | Test on | By* |
|---------------------|----------|--------------------|------------|-----|
| | | | | |

*competent person

1. Spare Parts

Fig. 01 Blasthousing

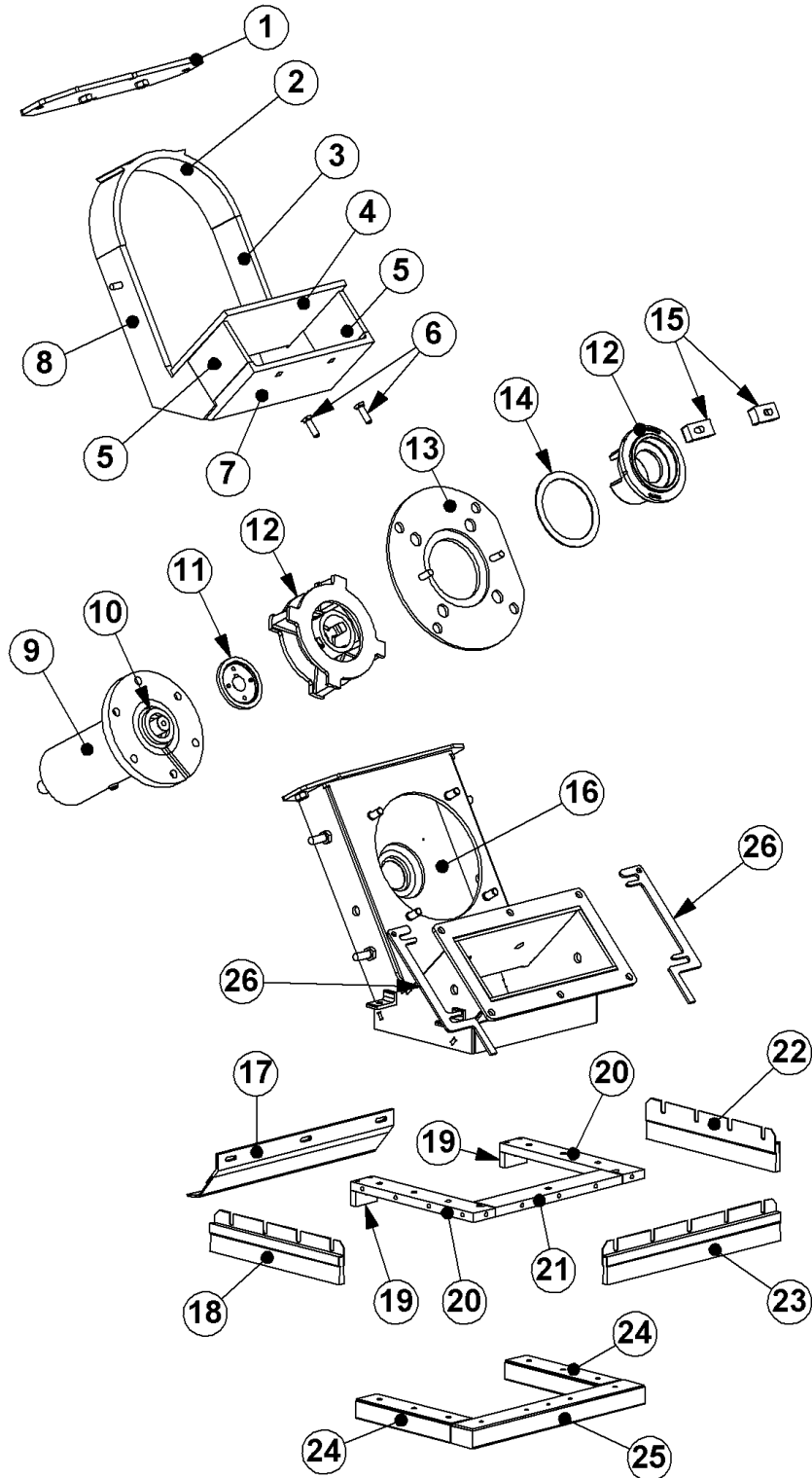




Fig. 01 Blasthousing

| Item | Blastrac PN | HQV PN | Description | Qty. |
|------|-------------|-----------|-------------------------|------|
| 1 | E00766 | 533463701 | Blasthousing cover | 1 |
| 2 | B20325 | 533768101 | Top liner | 1 |
| 3 | B20399 | 533688501 | Side liner RH | 1 |
| 4 | 490044 | 534766601 | Plenum top liner | 1 |
| 5 | 972275 | 534766201 | Plenum side liner | 2 |
| 6 | 969579 | 534669101 | Liner screw M10 x 35 | 2 |
| 7 | 969572 | 534763501 | Plenum bottom liner | 1 |
| 8 | B20398 | 533712801 | Side liner LH | 1 |
| 9 | E00842 | 533807401 | Bearing unit | 1 |
| 10 | B20295 | 533442501 | Felt seal BU flange | 1 |
| 11 | B20397 | 533762001 | Hub s/sided wheel | 1 |
| 12 | B20536K | 531459001 | Tune-up kit | 1 |
| 13 | 979644 | 534340601 | Blastwheel cover plate | 1 |
| 14 | 972781 | 534411101 | Control cage shim | 1 |
| 15 | 969803 | 534410801 | Control cage clamp | 2 |
| 16 | E00762 | 533644201 | Blasthousing 1-10DS MK4 | 1 |
| 17 | 679674 | 534844801 | Skid seal | 1 |
| 18 | B20411 | 533717001 | Side strip brush RH | 1 |
| 19 | 481350 | 534857401 | Spacer side magnet rear | 2 |
| 20 | E00968 | 533265201 | Insulator side | 2 |
| 21 | E00969 | 533797901 | Insulator front | 1 |
| 22 | B20423 | 533702601 | Side strip brush LH | 1 |
| 23 | B20410 | 533683201 | Front strip brush | 1 |
| 24 | 490047 | 534697301 | Magnet side | 2 |
| 25 | 970030 | 534697101 | Magnet front | 1 |
| 26 | P003047 | 534079501 | Blast pattern indicator | 2 |



Fig. 02 Motor bracket
Till serial number 33106B

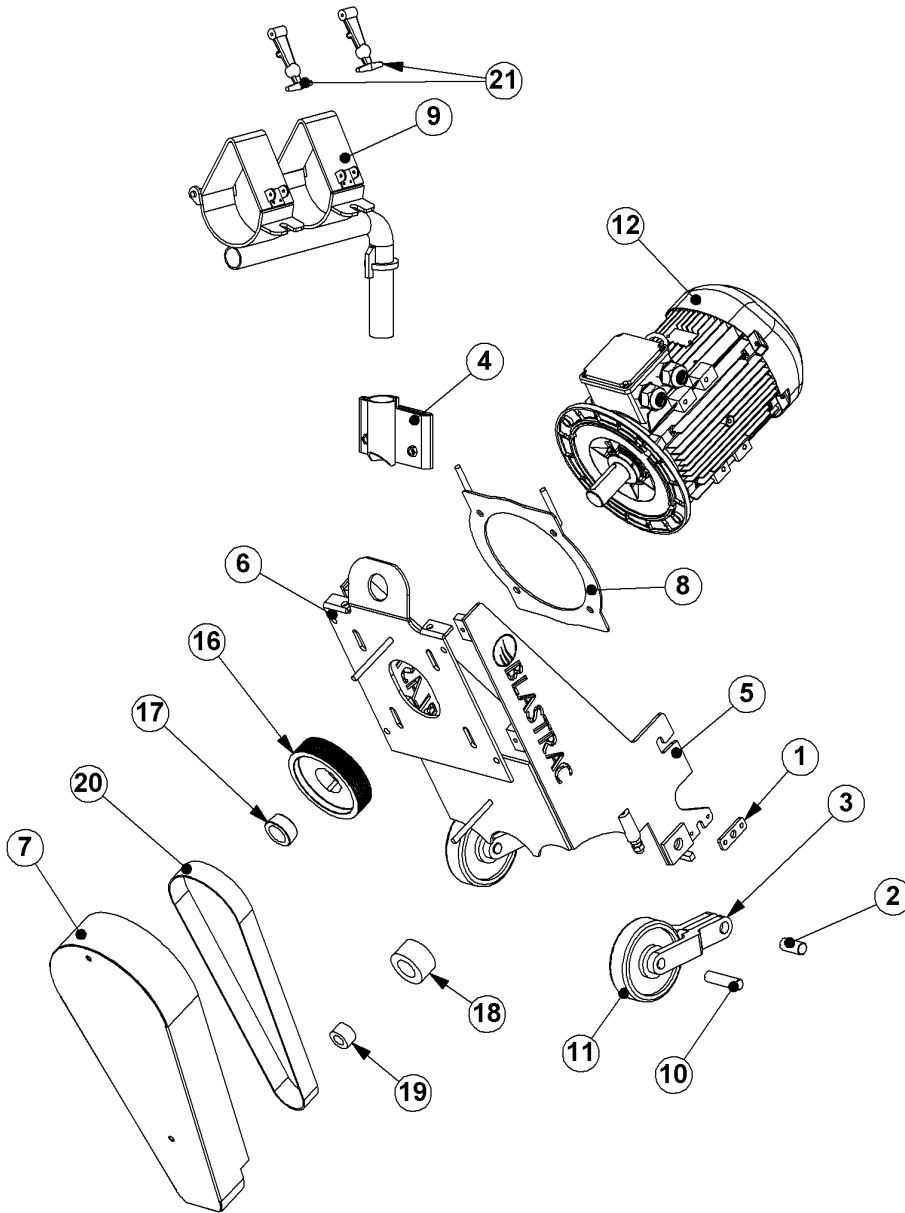


Fig. 02 Motor bracket
Till serial number 33106B

| Item | Blastrac PN | HQV PN | Description | Remarks | Qty. |
|------|-------------|-----------|-----------------------------|---------|------|
| 1 | 970171 | 531483101 | Keep plate | | 2 |
| 2 | 970256 | 534767401 | Pivot pin | | 2 |
| 3 | E00714 | 533489101 | Idler wheel support bracket | | 2 |
| 4 | E00745 | 533493201 | Cable guide bracket | | 1 |
| 5 | E00760 | 533089701 | Motor bracket | | 1 |
| 6 | E00767 | 533044401 | Front plate top | | 1 |
| 7 | E00768 | 531472701 | Pulley guard | | 1 |
| 8 | E00769 | 533776101 | Fill up plate blastmotor | | 1 |
| 9 | E00835 | 533642901 | Hose guide | | 1 |
| 10 | 970258 | 534303901 | Axle pin | | 2 |
| 11 | 001228 | 534943501 | Idler wheel | | 2 |
| 12 | E04642-IE2 | 534029501 | Blastmotor 11kW | | 1 |
| 16 | 491523/1 | 533847501 | Poly-V pulley | | 1 |
| 17 | DG15 | 533778901 | Taper lock bush | | 1 |
| 18 | 2613-501 | 533444701 | Poly-V pulley | | 1 |
| | E00466-1 | 533672001 | Bottom pulley | 60Hz | 1 |
| 19 | 976873 | 533807201 | Taperlock bush | | 1 |
| | 222-2172-V | 533782401 | Taper lock bush | 60Hz | 1 |
| 20 | E00852 | 531474101 | Poly-V belt | | 1 |
| 21 | 500-1195 | 531471201 | Rubber latch assy | | 2 |

Fig. 02.1 Motor bracket 50 & 60Hz adjustable

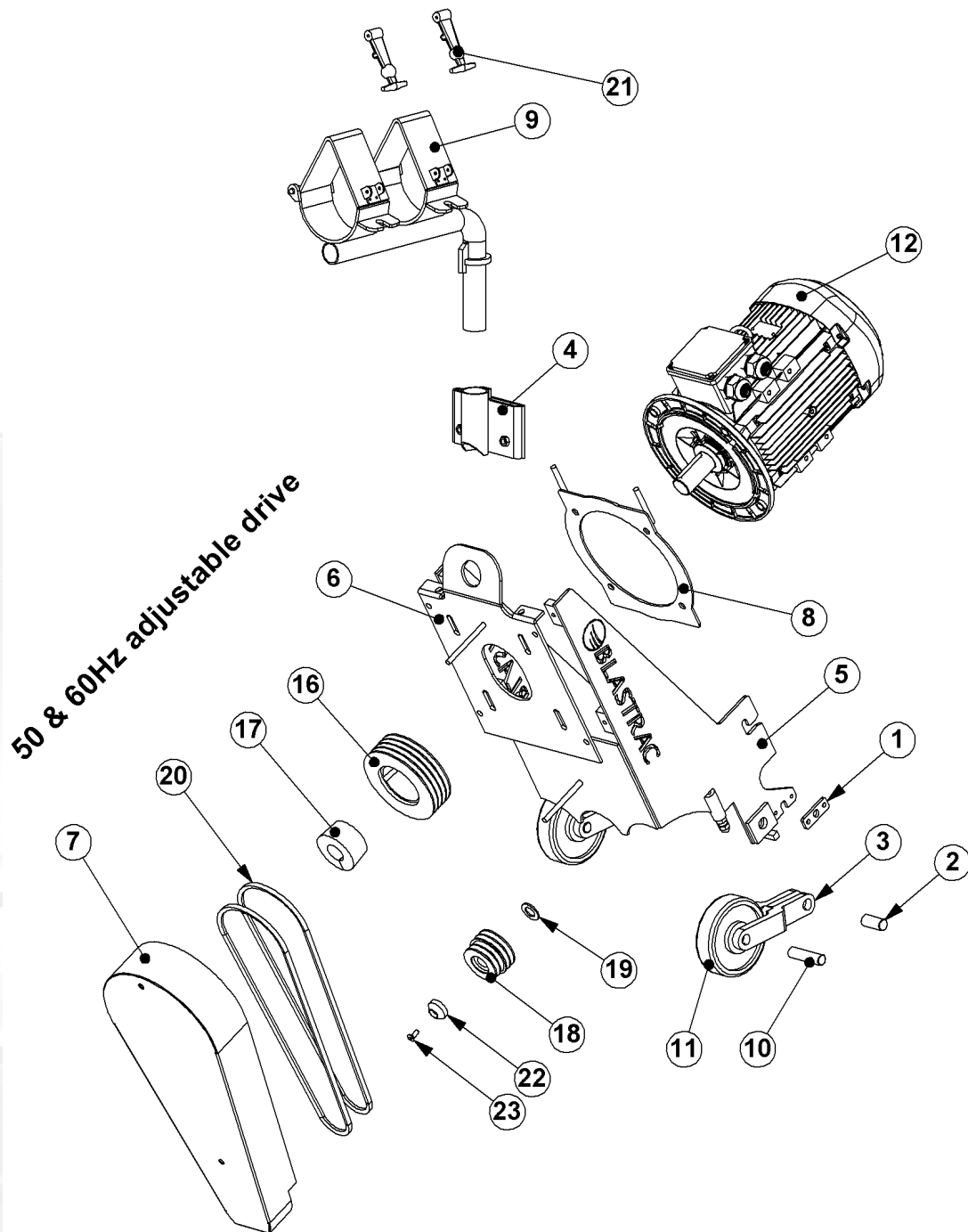


Fig. 02.1 Motor bracket 50 & 60Hz adjustable

| Item | Blastrac PN | HQV PN | Description | Remarks | Qty. |
|------|-------------|-----------|-----------------------------|---------|------|
| 1 | 970171 | 531483101 | Keep plate | | 2 |
| 2 | 970256 | 534767401 | Pivot pin | | 2 |
| 3 | E00714 | 533489101 | Idler wheel support bracket | | 2 |
| 4 | E00745 | 533493201 | Cable guide bracket | | 1 |
| 5 | E00760 | 533089701 | Motor bracket | | 1 |
| 6 | E00767 | 533044401 | Front plate top | | 1 |
| 7 | E00768 | 531472701 | Pulley guard | | 1 |
| 8 | E00769 | 533776101 | Fill up plate blastmotor | | 1 |
| 9 | E00835 | 533642901 | Hose guide | | 1 |
| 10 | 970258 | 534303901 | Axle pin | | 2 |
| 11 | 001228 | 534943501 | Idler wheel | | 2 |
| 12 | E04642-IE2 | 534029501 | Blastmotor 11kW | | 1 |
| 16 | E08858 | 534324801 | Top pulley | 50/60Hz | 1 |
| 17 | E00425 | 533378101 | Taper lock bush | | 1 |
| 18 | E08852 | 534324701 | Bottom pulley | 50/60Hz | 1 |
| 19 | | | M22 washer | | 1 |
| 20 | E07561 | 533437501 | V belt | | 2 |
| 21 | 500-1195 | 531471201 | Rubber latch assy | | 2 |
| 22 | E08855 | 534580801 | Fixing bush | | 2 |
| 23 | | | M8x20 countersunk bolt | | 1 |

Fig. 02.2 Motor bracket
From serial number 33106B & up

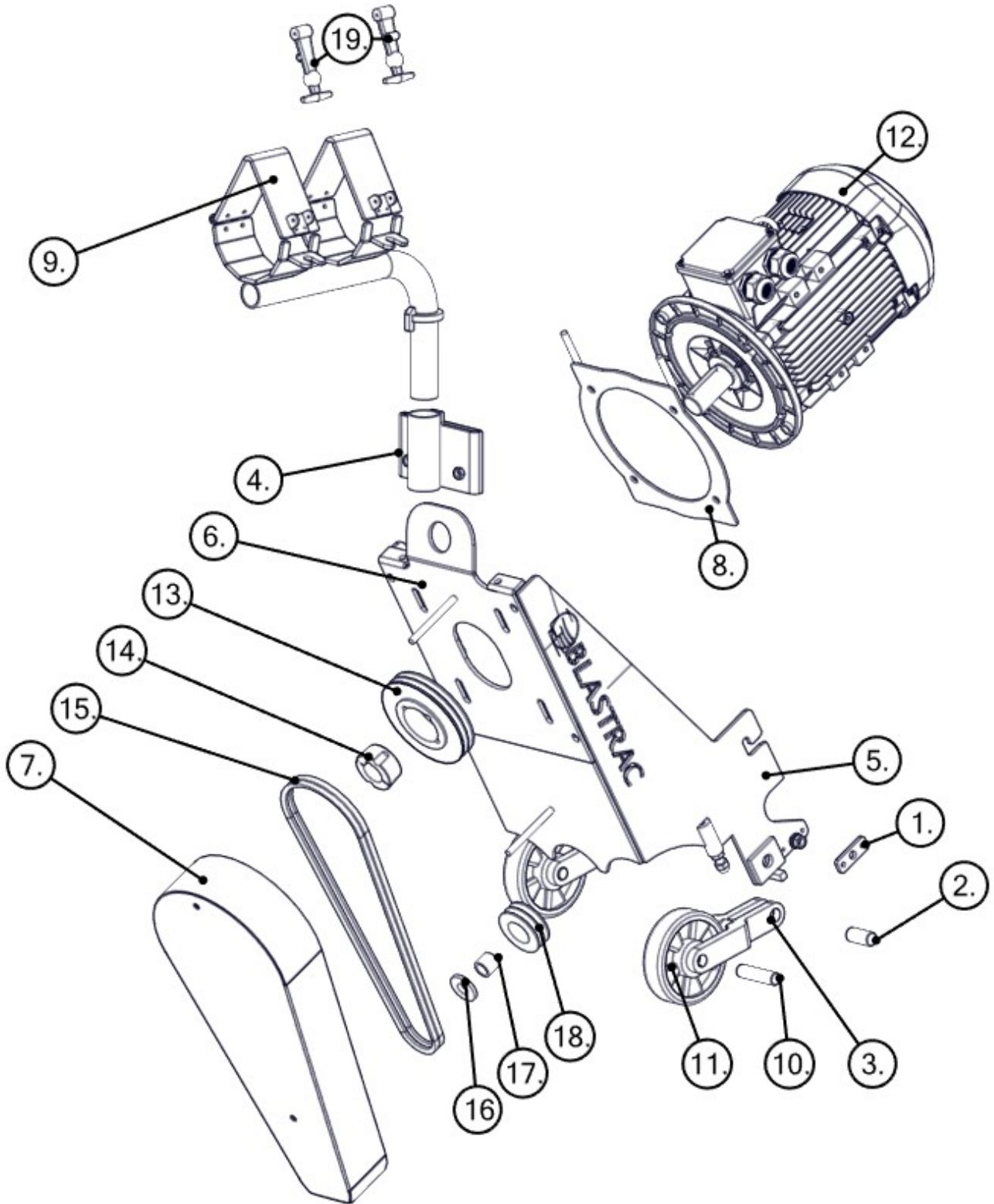




Fig. 02.2 Motor bracket
From serial number 33106B & up

| Item | Blastrac PN | HQV PN | Description | Remarks | Qty. |
|------|-------------|-----------|-----------------------------|---------|------|
| 1 | 970171 | 531483101 | Keep plate | | 2 |
| 2 | 970256 | 534767401 | Pivot pin | | 2 |
| 3 | E00714 | 533489101 | Idler wheel support bracket | | 2 |
| 4 | E00745 | 533493201 | Cable guide bracket | | 1 |
| 5 | E00760 | 533089701 | Motor bracket | | 1 |
| 6 | E00767 | 533044401 | Front plate top | | 1 |
| 7 | E00768 | 531472701 | Pulley guard | | 1 |
| 8 | E00769 | 533776101 | Fill up plate blastmotor | | 1 |
| 9 | E00835 | 533642901 | Hose guide | | 1 |
| 10 | 970258 | 534303901 | Axle pin | | 2 |
| 11 | 001228 | 534943501 | Idler wheel | | 2 |
| 12 | E04642-IE2 | 534029501 | Blastmotor 11kW | | 1 |
| 13 | E00268 | 534323801 | Belt Pulley | | 1 |
| 14 | 222-2171 | 533702501 | Taper lock bush TL2012-38 | | 1 |
| 15 | E19392 | 535652101 | High power XPZ-1270 | | 2 |
| 16 | BE0032 | 534683001 | M12 washer | | 1 |
| 17 | E19021 | 534514901 | Distance bush | | 1 |
| 18 | E19071 | 534785101 | Pulley 50Hz | | 1 |
| | E19021 | 534514901 | Pulley 60Hz | | 1 |
| 19 | 500-1195 | 531471201 | Rubber latch assy | | 2 |

Fig. 03 Drive wheel
From serial number 33106B & up

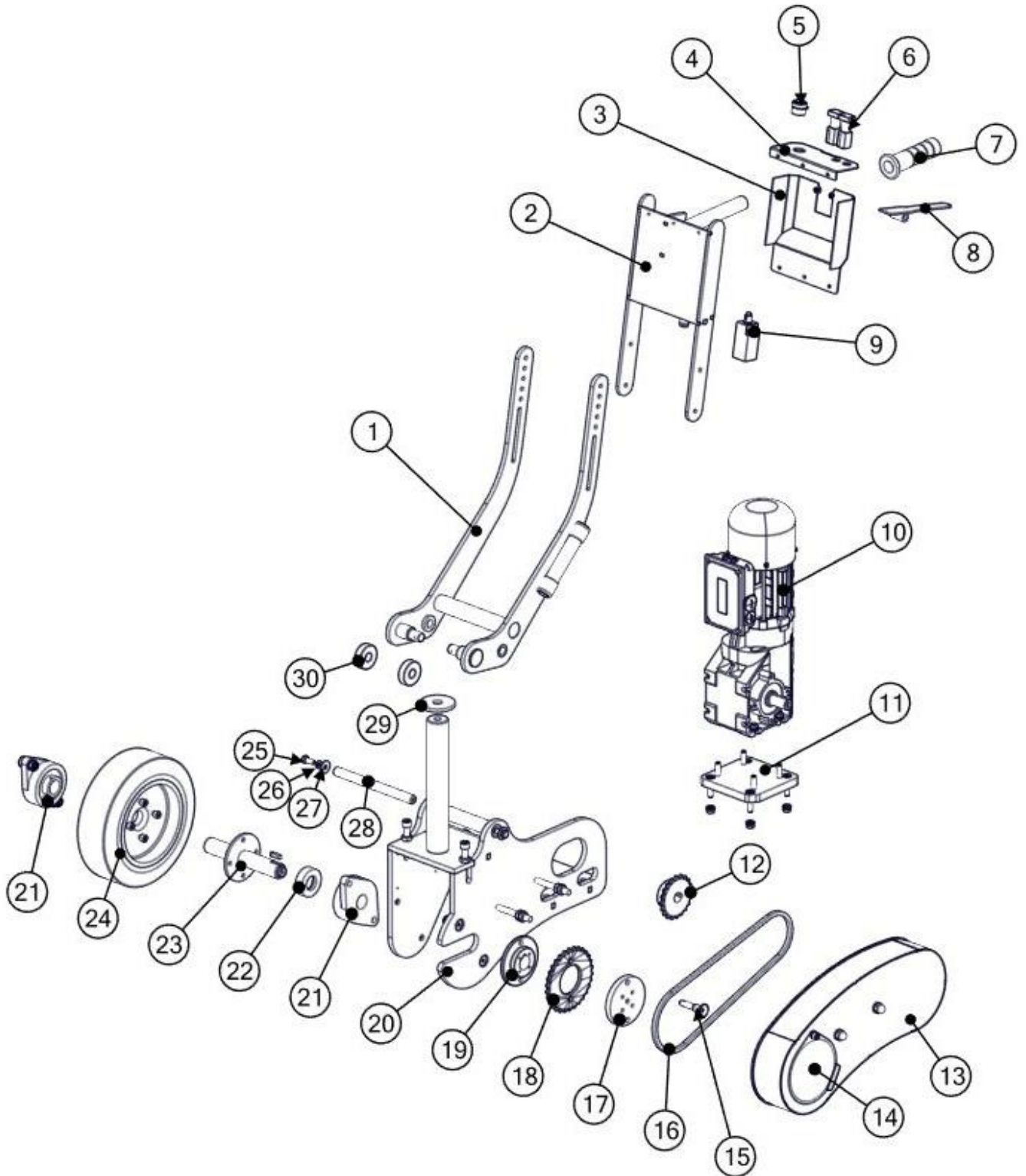




Fig. 03 Drive wheel
From serial number 33106B & up

| Item | Blastrac PN | HQV PN | Description | Remarks | Qty. |
|------|----------------|-----------|--|---------|------|
| 1 | E10579 | 534042501 | Handle lower part | | 1 |
| 2 | E06143 | 534031901 | Handle top part | | 1 |
| 3 | E00740 | 533241401 | Control box | | 1 |
| 4 | E00741 | 533571401 | Control box top plate | | 1 |
| 5 | E00866 | 533613001 | Potential meter complete (item 4.1 & 4.2) | | 1 |
| 5.1 | E00866/1 | 533963001 | Potmeter only with soldered contact block | | 1 |
| 5.2 | E00866/2 | 533994301 | Potmeter holder only | | 1 |
| 6 | E00867 | 533850701 | Switch | | 2 |
| 7 | 453290 | 534612901 | Handle grip | | 1 |
| 8 | E00743 | 533783701 | Switch lever | | 1 |
| 9 | 454796 | 534668101 | Limit switch | | 1 |
| 10 | E00639-2/120Hz | 534721801 | Drive motor 0,55 kW | | 1 |
| | E19081 | 534566601 | Fan 0.55 & 0.75kW 120Hz | | 1 |
| | E19082 | 534566901 | Fan cover 0.55 & 0.75kW 120Hz | | 1 |
| | E19083 | 534365601 | Brake complete 120Hz | | 1 |
| 11 | E15555 | 534262101 | Adapter plate | | |
| 12 | E14787 | 534861801 | Sprocket | | 1 |
| 13 | E00744 | 533068001 | Chain guard | | 1 |
| 14 | 979971 | 534387301 | Cover plate chain guard | | 1 |
| 15 | 478198 | 533256401 | Quick release pin | | 1 |
| 16 | E00237 | 534024701 | Chain | | 0.9m |
| 16.1 | E00238 | 533930301 | Chain link | | 1 |
| 17 | 477630 | 534863101 | Sprocket retainer | | 1 |
| 18 | 477631 | 534640601 | Idler sprocket | | 1 |
| 19 | 488551 | 534642001 | Hub | | 1 |
| 20 | E14626 | 534528201 | Drive wheel bracket | | 1 |
| 21 | 976682 | 531474201 | Bearing drive wheel | | 2 |
| 22 | E07293 | 533318901 | Distance bush drive wheel | | 1 |
| 23 | E00742 | 533956301 | Drive wheel shaft | | 1 |
| 24 | 476405 | 534907101 | Traction wheel | | 1 |
| 25 | | | M8x20 Hex bolt | | 2 |
| 26 | | | M8 Spring lock washer | | 2 |
| 27 | BE0318 | 533821001 | M8 Washer 3xd | | 2 |
| 28 | E15554 | 534681501 | Locking shaft | | 1 |
| 29 | 971860 | 533843701 | Washer for yoke shaft | | 1 |
| 30 | B20517 | 533809801 | Bearing | | 2 |

Fig. 04 Rebound & Separator

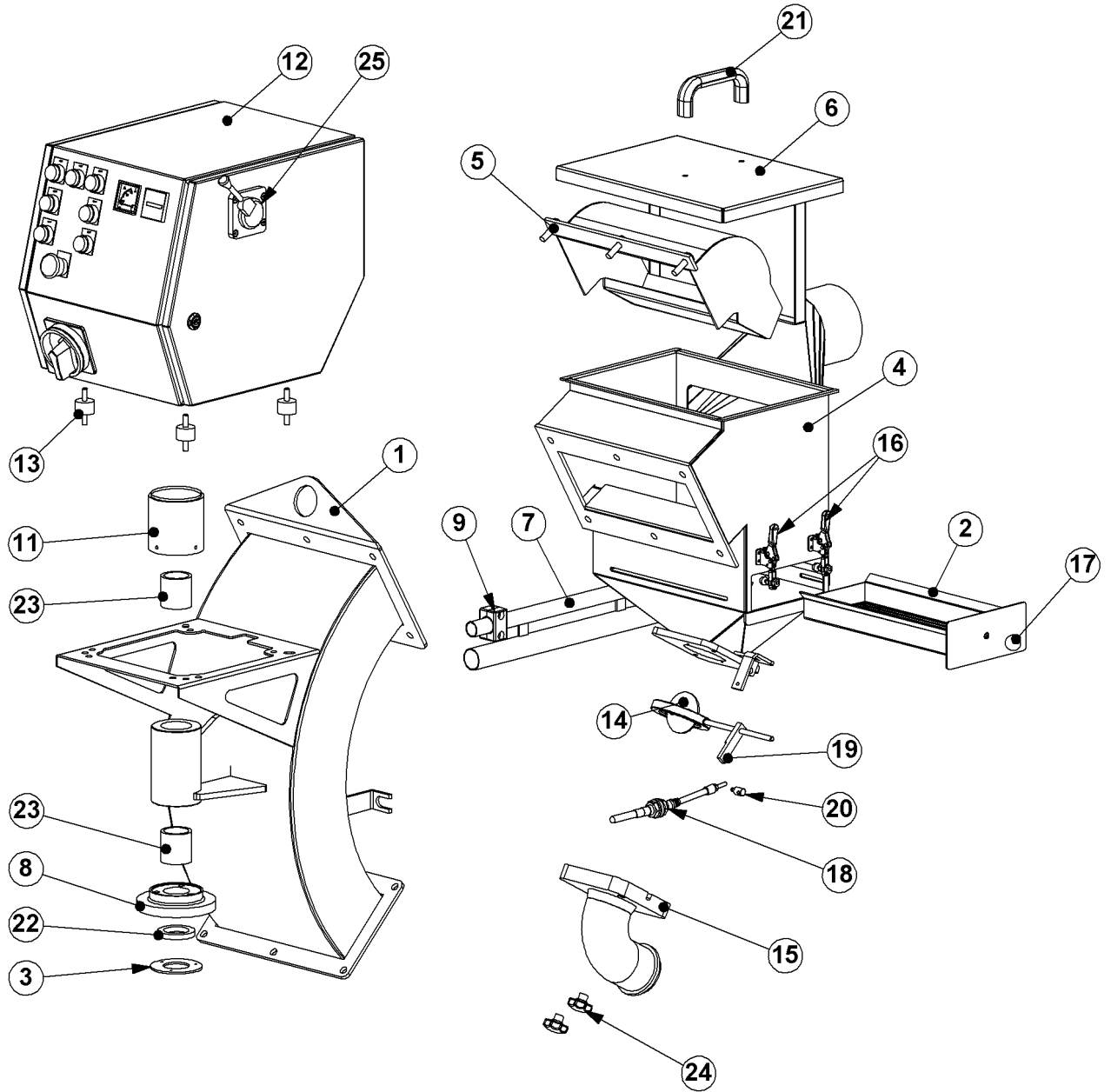
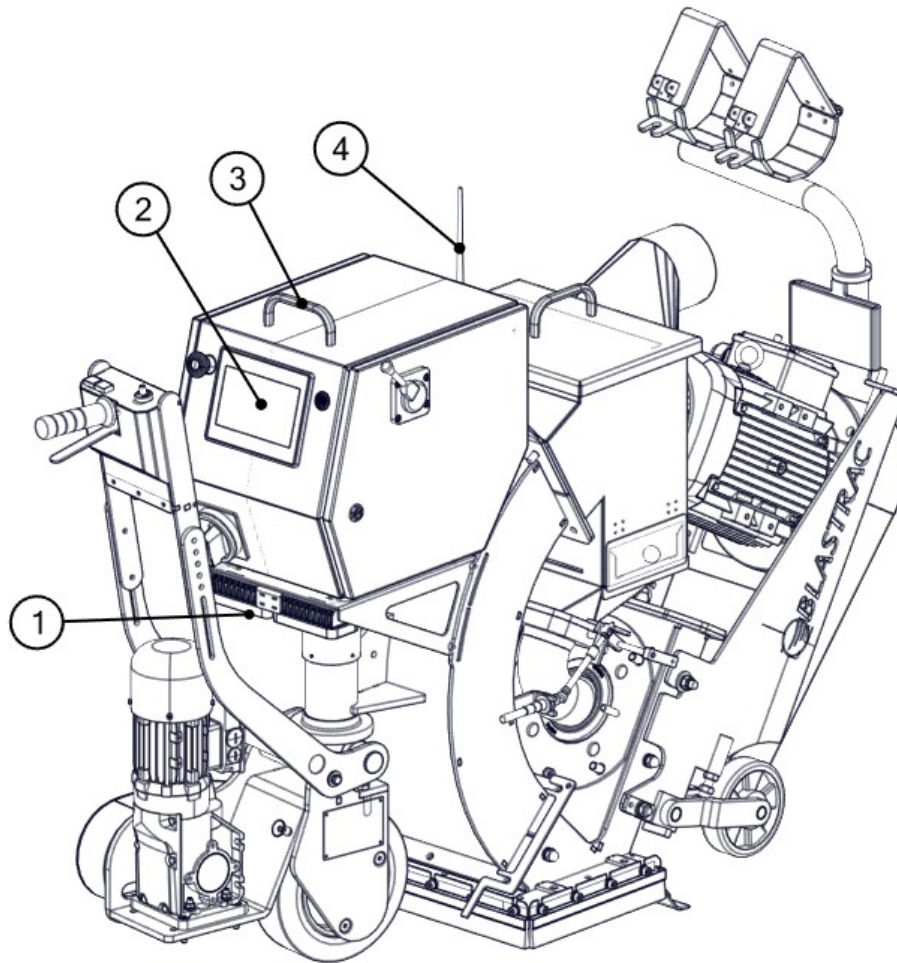


Fig. 04 Rebound & Separator

| Item | Blastrac PN | HQV PN | Description | Remarks | Qty. |
|------|-------------|-----------|---|--------------|------|
| 1 | E00763 | 533589401 | Rebound | | 1 |
| 2 | 970117 | 534829101 | Separator tray | | 1 |
| 3 | B20512 | 533783201 | Seal retainer | | 1 |
| 4 | E03057 | 533607701 | Separator | | 1 |
| 5 | 980012 | 534434801 | Deflector | | 1 |
| 6 | 980011 | 533035601 | Separator lid | | 1 |
| 7 | E03166 | 534377701 | Cable guide | | 1 |
| | E06903 | 533518301 | Cable guide | Dual voltage | 1 |
| 8 | B20511 | 533783501 | Lifting plate | | 1 |
| 9 | DG39 | 533414301 | Pipe clamp Ø25 (set of 2) | | 2 |
| 11 | B20515 | 533224801 | Shaft cover | | 1 |
| 12 | E00659 | 535607001 | Electrobox 1-10DS Global | | 1 |
| | E05019 | 535607601 | Electro box 1-10DS Global Dual Voltage UL | Dual voltage | 1 |
| 13 | 456550 | 534836101 | Shock absorber | | 4 |
| 14 | B20444 | 533707101 | Magnetic valve assembly | | 1 |
| 15 | B20443 | 533806601 | Feed spout | | 1 |
| 16 | 001084 | 534391301 | Clamp for separator tray | | 2 |
| 17 | B21325 | 533592601 | Ball head for separator | | 1 |
| 18 | B20520 | 533879301 | Control cable | | 1 |
| 19 | B20446 | 533513401 | Lever magnetic valve | | 1 |
| 20 | B20521 | 534028801 | Pivot for abrasive control cable | | 1 |
| 21 | 970385 | 533170201 | Handle | | 1 |
| 22 | B20595 | 535781201 | Felt seal | | 1 |
| 23 | 971341 | 533194601 | Oilite bush | | 2 |
| 24 | 000213 | 533656201 | Clamp knob M8 | | 2 |
| 25 | B20519 | 533839501 | Cable control unit | | 1 |

Fig. 05 Options



| Item | Blastrac PN | HQV PN | Description | Remarks | Qty. |
|------|-------------|-----------|--------------------------------|----------------------|------|
| 1 | E17685 | - | Touch screen | (for TS-models only) | 1 |
| 2 | E14819 | 534662601 | LED light set for shotblasters | | 1 |
| 3 | 970385 | 533170201 | Handle | | 1 |
| 4 | E17720 | - | Antenna WiFi | (for TS-models only) | 1 |



2. Maintenance box 1-10DS Global E03187

| Item | Blastrac PN | HQV PN | Description | Qty. |
|------|--------------|------------|---|------|
| 1 | CFA-TLC-285F | 534900001 | T-LOC CASE 4 380x270x285 mm with FOAMS. (Box) | 1 |
| 2 | B20398 | 533712801 | Left liner | 1 |
| 3 | B20399 | 533688501 | Right liner | 1 |
| 4 | B20325 | 533768101 | Top liner | 1 |
| 5 | B20536K | 531459001 | Tune-up kit | 3 |
| 6 | B20520 | 533879301 | Abrasive control cable | 1 |
| 7 | 679674 | 534844801 | Skid seal | 1 |
| 8 | B20423 | 533702601 | Side brush left | 2 |
| 9 | B20411 | 533717001 | Side brush right | 2 |
| 10 | B20410 | 533683201 | Front brush | 2 |
| 11 | E00852 | 531474101 | Belt | 3 |
| 12 | 001017 | 535752901 | Open-end spanner 10/11 | 1 |
| 13 | 001018 | 535753001 | Open-end spanner 13/15 | 1 |
| 14 | 001019 | 535753101 | Open-end spanner 17/19 | 1 |
| 15 | 001042 | 534735401 | Open-end spanner 24/26 | 1 |
| 16 | 001033 | 535753601 | Allenkey 3 | 1 |
| 17 | 001016 | 535752801 | Allenkey 6 | 1 |
| 18 | 000151 | 535752601 | Hammer | 1 |
| 19 | 000144 | 535751901 | Ratchet spanner 1/2" | 1 |
| 20 | 000150 | 535752501 | Box spanner SW 8 mm | 1 |
| 21 | 000146 | 535752001 | Box spanner SW 13mm | 1 |
| 22 | 000147 | 535752101 | Box spanner SW 17mm | 1 |
| 23 | 000148 | 535752301 | Box spanner SW 19mm | 1 |
| 24 | 001037 | not loaded | Screwdriver 6 x 25 | 1 |
| 25 | 001032 | 535753501 | Screwdriver 5,5 x 100 | 1 |
| 26 | 001035 | 535753701 | Insulated screwdriver | 1 |
| 27 | 001056 | 535753901 | Water pump pliers | 1 |
| 28 | 001031 | 535753401 | Safety glasses | 1 |



3. Maintenance box 1-10DS 60 Hz(S/N 10522B and up)

| Item | Blastrac PN | HQV PN | Description | Qty. |
|-------------|----------------------|------------------|---|----------|
| | E06361-1/60 | 534488901 | Maintenance box | 1 |
| 1-13 | | | Content of Maintenance box | |
| 1 | 000142_1 | 534901601 | Tool kit for small maintenance box | 1 |
| 2 | CFA-TLC-285-F | 534900001 | T-LOC CAS 4 380x270x285MM with Foams | 1 |
| 3 | CFA-TLC-TI | 534900601 | T-LOC Tools insert | 1 |
| 4 | CFA | - | Side liner LH | 1 |
| 5 | E06154 | 533655401 | Side liner RH | 1 |
| 6 | E06155 | 533650701 | Top liner | 1 |
| 7 | B21637K | 534912101 | Tune up kit 6-1/2 | 2 |
| 8 | 975100 | 533016801 | Control cable | 1 |
| 9 | B21164-1 | 533675901 | Seal for skid 80° | 2 |
| 10 | B21137 | 533798201 | Skid seal | 1 |
| 11 | E06161 | 533633401 | Front brush | 2 |
| 12 | E06162 | 533628901 | Side brush | 4 |
| 13 | 350-2431-V | 533623501 | V-belt | 2 |



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