



SERVICE MANUAL 1-15DS Global

VERSION 3.4



Inspection comments

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

Recurring inspections / maintenance log

Date	Findings	Repairs / Cleaning	Test on	By*

*competent person



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1. Spare parts

Fig. 01 Blasthousing

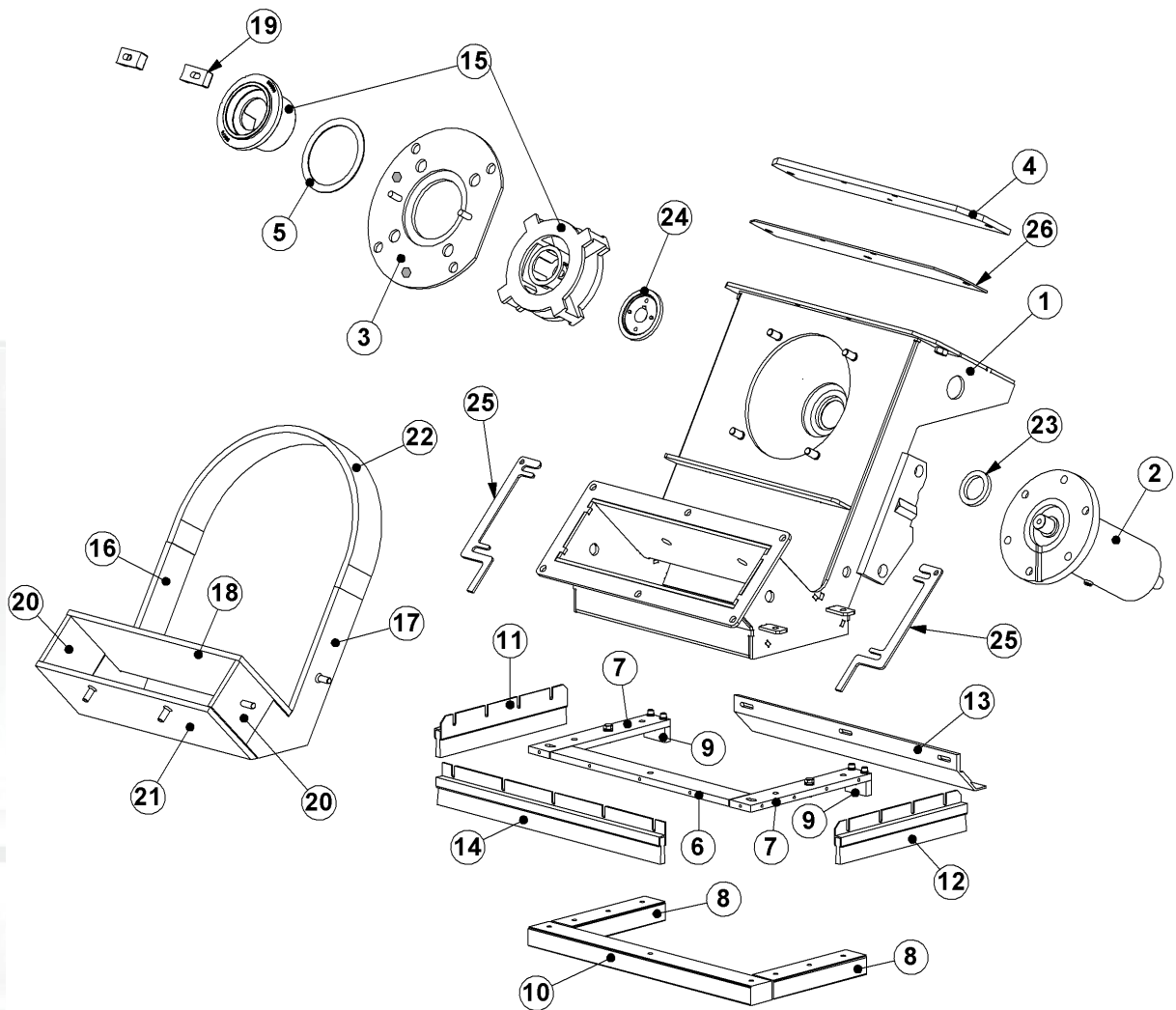




Fig. 01

Item	Blastrac PN	HQV PN	Description	Qty.
1	E00751	533335201	Blasthousing 1-15DS Global	1
2	E00842	533807401	Bearing unit complete	1
3	979644	534340601	Blastwheel cover plate	1
4	B20458	533495501	Blasthousing cover	1
5	972781	534411101	Control cage shim	1
6	971851	533357901	Insulator front	1
7	489945	534644801	Insulator side	2
8	490047	534697301	Magnet side	2
9	481350	534857401	Spacer side magnet rear	2
10	971884	533500801	Magnet front	1
11	E00458	533806501	Side brush LH	1
12	E00457	533805801	Side brush RH	1
13	682652	534845001	Skid seal	1
14	B20412	533393401	Front brush	1
15	B20536K	531459001	Tune up kit	1
16	B20394	533713101	Side liner left hand	1
17	B20395	533722401	Side liner right hand	1
18	970151	533539101	Plenum top liner	1
19	969803	534410801	Control cage clamp	2
20	970153	533572901	Plenum bottom side liner	2
21	970152	533626601	Plenum bottom	1
22	B20907	533611101	Top liner	1
23	B20295	533442501	Felt seal Ø60x8	1
24	B20397	533762001	Hub	1
25	P003047	534079501	Blast pattern indicator	2
26	B20454	533660601	Gasket blast housing cover	1



Fig. 02 Motor and wheel bracket

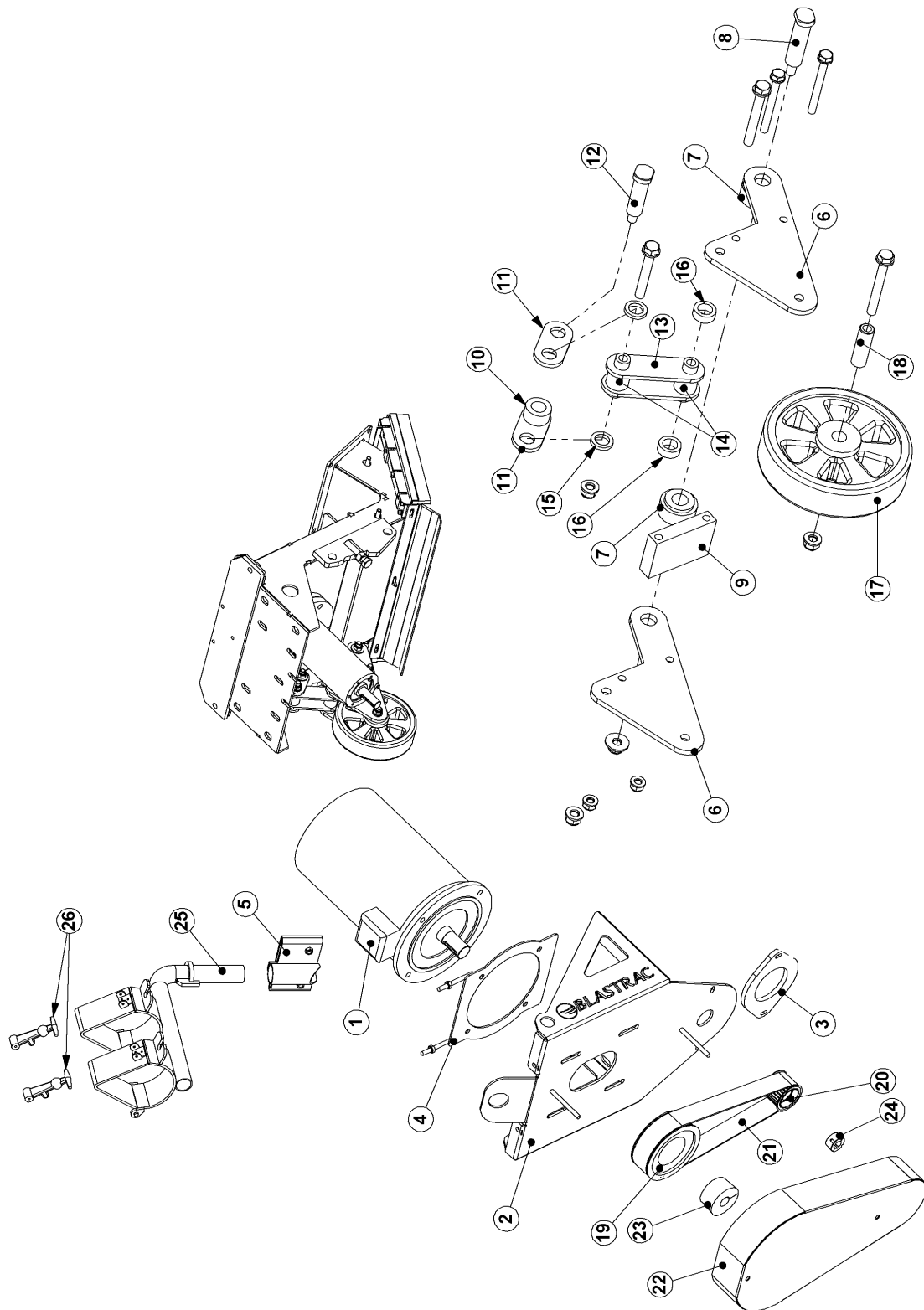




Fig. 02 Motor and wheel bracket

Item	Blastrac PN	HQV PN	Description	Remarks	Qty.
1	E06511-IE2	533724201	Blastmotor 15 kW		1
2	E06512	533368901	Motorbracket		1
3	E06940	531484801	Dust plate		1
4	E06513	533725901	Fill up plate blastmotor		1
5	E00745	533493201	Cable guide bracket		1
6	E06465	533721101	Wheel bracket side plate		4
7	E06472	533733701	Wheel bracket bush		4
8	E06468	533212101	Bottom bolt		2
9	E06475	533318701	Distance plate		2
10	E06474	533264801	Lever bush top		4
11	E06467	533470801	Top lever		4
12	E06469	533220401	Top bolt		2
13	E06466	533212001	Bottom lever		4
14	E06471	533540001	Lever shaft		4
15	E06855	533513501	Lever bush middle		4
16	E06473	533483201	Lever bush bottom		4
17	B20842	533845201	Wheel		2
18	E06470	533493301	Idler wheel bush		2
19	B20429/1	534906401	Pulley	50Hz	1
	B21340	533695601	Pulley	60Hz	1
20	B20430/1	534361701	Pulley	50Hz	1
	B21341	533697901	Pulley	60Hz	1
21	B20428	533471901	Belt	50Hz	1
	E04009	533843101	Belt	60Hz	
22	B20224ST	534322501	Belt guard		1
23	E00425	533378101	Taperlock		1
24	222-2172-V	533782401	Taper lock		1
25	E00746	534077001	Cable guide		1
26	E11255	533420701	Hinge 60x60		2
	500-1195	531471201	Rubber latch assy		2



Fig. 03 Drive wheel
From serial number 32012B & up

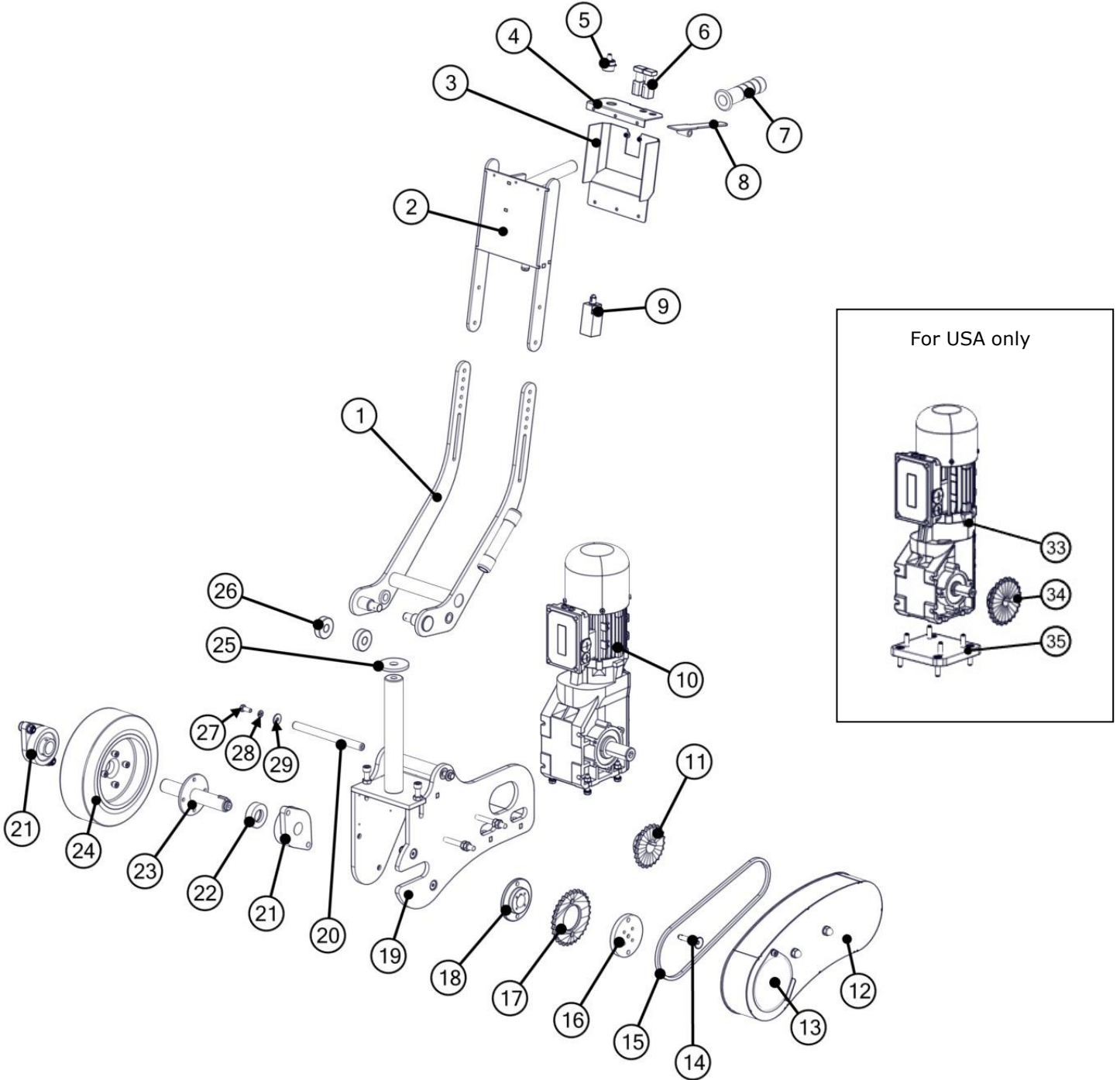




Fig. 03 Drive wheel
From serial number 32012B & up

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	Potentiometer complete (item 4.1 & 4.2)		1
5.1	E00866/1	533963001	Potentiometer only with soldered contact block		1
5.2	E00866/2	533994301	Potentiometer 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	E00664-2/120Hz	534439301	Drive motor 1,1 kW		1
	E19083	534365601	Brake complete for drive motor		1
	E19085	534567001	Fan cover 1.1kW 120Hz		1
	E19084	534566701	Cooling fan for 1.1kW 120Hz drive motor		1
11	B21311-1	534862901	Sprocket		1
12	E00744	533068001	Chain guard		1
13	979971	534387301	Cover plate chain guard		1
14	478198	533256401	Quick release pin		1
15	E00237	534024701	Chain		0.9m
15.1	E00238	533930301	Chain link		1
16	477630	534863101	Sprocket retainer		1
17	477631	534640601	Idler sprocket		1
18	488551	534642001	Hub		1
19	E14626	534528201	Drive wheel bracket		1
20	E15554	534681501	Locking shaft		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	971860	533843701	Washer for yoke shaft		1
26	B20517	533809801	Bearing		2
27		-	M8x20 Hex bolt		2
28		-	M8 Spring lock washer		2
29	BE0318	533821001	M8 Washer 3xd		2
33	E00646-2/120Hz	534445101	Drive motor 0.75kW 120Hz	USA	1
34	E14970	534862701	Sprocket	USA	1
35	E15555	534262101	Adapter	USA	1

Fig. 04 Separator

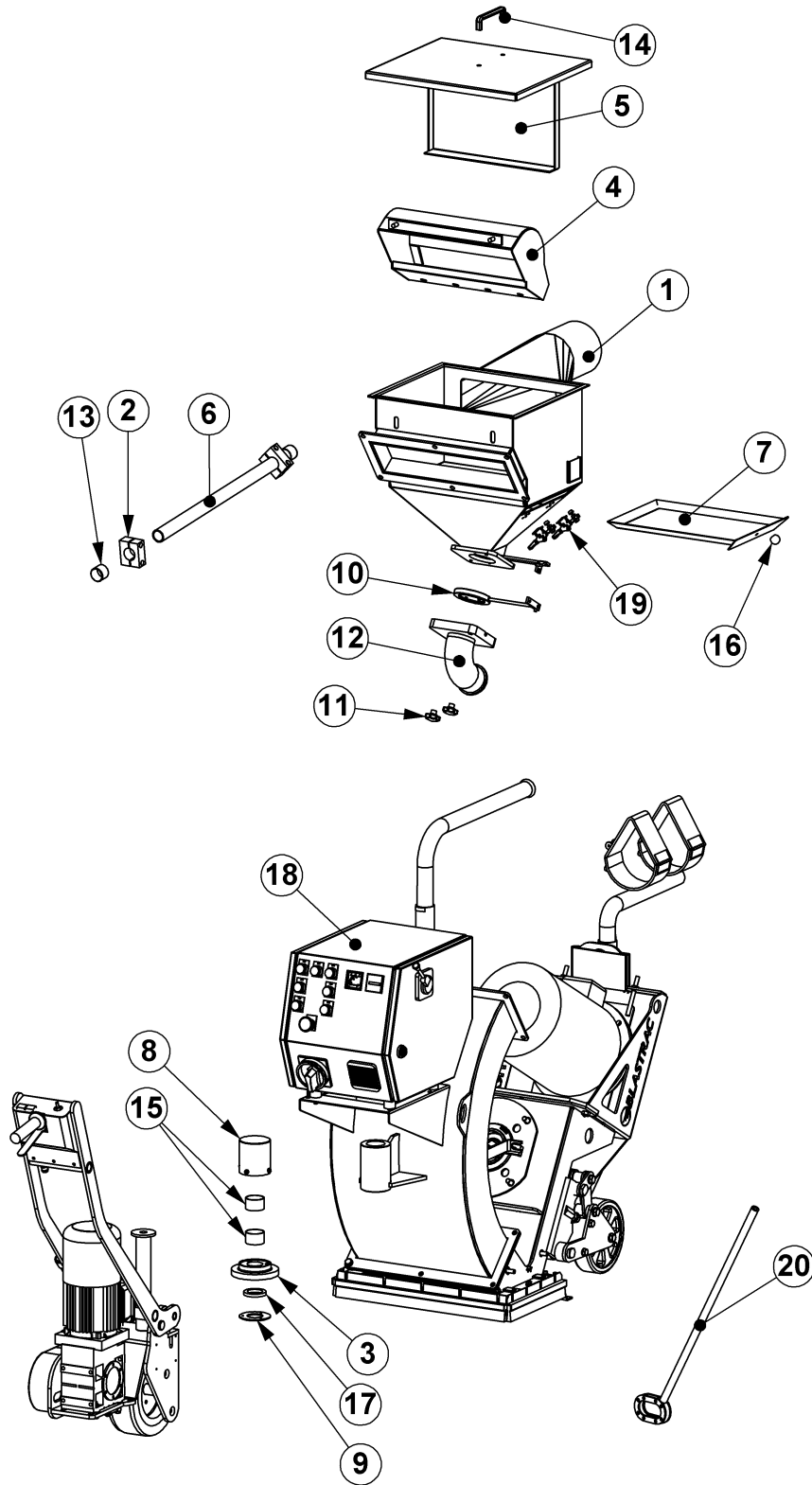
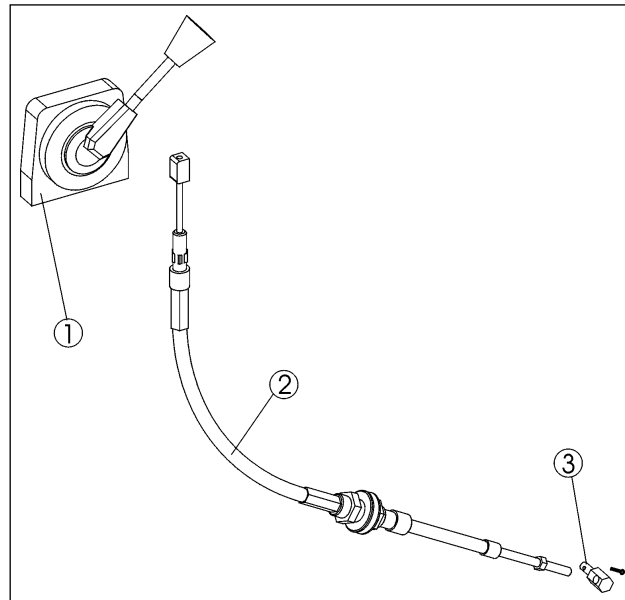


Fig. 04 Separator

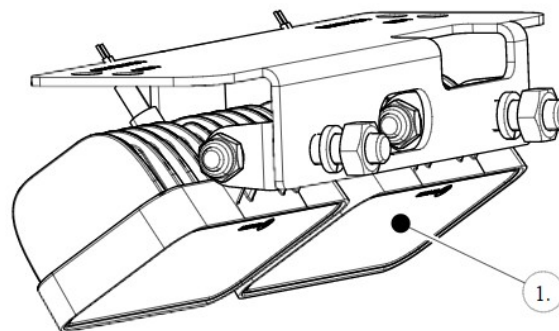
Item	Blastrac PN	HQV PN	Description	Qty.
1	B20393	533672401	Separator	1
2	B21338	533073401	Pipe clamp.35mm (set of 2)	2
3	B20511	533783501	Lifting plate	1
4	B20262	533661201	Deflector	1
5	B20263	533828201	Separator cover	1
6	B21969	533521801	Cable tube	1
7	B20264	533348801	Separator tray	1
8	B20515	533224801	Shaft cover	1
9	B20512	533783201	Seal retainer	1
10	B20444	533707101	Magnetic valve assembly	1
11	000213	533656201	Clamp knob	2
12	B20443	533806601	Feed spout	1
13	E00337	533329001	Cable protection cap	2
14	970385	533170201	Handle	1
15	971341	533194601	Sleeve-bearing bush	2
16	B21325	533592601	Ball head for separator	1
17	B20295	533442501	Felt seal	1
18	E06540	534555201	Electrobox 1-15DS Global	1
19	001084	534391301	Clamp for separator tray	2
20	B21917	531472201	Lever	1

Fig. 05 Abrasive control lever



Item	Blastrac PN	HQV PN	Description	Qty.
1	B20519	533839501	Abrasive control lever	1
2	B20520	533879301	Abrasive control cable	1
3	B20521	534028801	Pivot for abrasive control cable	1

Fig. 06 Options



Item	Blastrac PN	HQV PN	Description	Qty.
1	E14819	534662601	LED light set for shotblasters	1



2. Maintenance box

Item	Blastrac PN	HQV PN	Description	Qty.
1	CFA-TLC-285F	534900001	T-LOC CASE 4 380x270x285 mm with FOAMS. (Box)	1
2	B20536K	531459001	Tune-up kit	3
3	B20394	533713101	Left liner	1
4	B20395	533722401	Right liner	1
5	B20907	533611101	Top liner	1
6	B20520	533879301	Abrasive control cable	1
7	B20428	533471901	Belt	1
8	E00457	533805801	Side brush right	2
9	E00458	533806501	Side brush left	2
10	B20412	533393401	Front brush	2
11	682652	534845001	Skid seal	1
12	001017	535752901	Open-end spanner 10 x 11	1
13	001018	535753001	Open-end spanner 13 x 15	1
14	001019	535753101	Open-end spanner 17 x 19	1
15	001042	534735401	Open-end spanner 24 x 26	1
16	001036	-	Ring spanner 8 x 9	1
17	000114	-	Ratchet spanner ½"	1
18	000146	535752001	Box spanner 13	1
19	000147	535752101	Box spanner 17	1
20	000148	535752301	Box spanner 19	1
21	000149	-	Box spanner 24	1
22	000150	535752501	Box spanner SW 8mm 120lg	1
23	001033	535753601	Allenkey 3	1
24	001016	535752801	Allenkey 6	1
25	001032	535753501	Screwdriver 5,5 x 100	1
26	001035	535753701	Insulated screwdriver	1
27	001056	535753901	Water pump pliers	1
28	000151	535752601	Hammer	1
29	001031	535753401	Safety glasses	1
30	000117	534362501	Maintenance box complete	1



BLASTRAC EUROPE

WE'RE READY TO ASSIST YOU!

BLASTRAC THE NETHERLANDS

EUROPEAN HEAD OFFICE

Utrechthaven 12
 NL - 3433 PN Nieuwegein
 Tel.: +31 (0)30 601 88 66
 Fax: +31 (0)30 601 83 33
 Email: info@blastrac.nl
WWW.BLASTRAC.EU

BLASTRAC POLAND

SALES & SERVICE CENTRE

Golina, ul. Dworcowa 47E
 63-200 Jarocin
 Tel.: +48 (0)62 740-41-50
 Fax: +48(0)62 740-41-51
 Email: info@blastrac.pl
WWW.BLASTRAC.PL

BLASTRAC FRANCE

SALES & SERVICE CENTRE

ZI - 29, Av. des Temps Modernes
 F - 86360 Chasseneuil du Poitou
 Tel.: +33 (0)5 49 00 49 20
 Fax: +33 (0)5 49 00 49 21
 Email: info@blastrac.fr
WWW.BLASTRAC.FR

BLASTRAC ITALY

SALES & SERVICE CENTRE

S.S. 10 Padana Inferiore, 41
 IT - 29012 Caorso (PC)
 Tel.: +39 0523 814241
 Fax: +39 0523 814245
 Email: info@blastrac.it
WWW.BLASTRAC.IT

BLASTRAC GERMANY

SALES & SERVICE CENTRE

Richard-Byrd-Str. 15
 50829 Köln
 Tel.: +49 (0) 221 709032-0
 Fax: +49 (0) 221 709032-22
 Email: info@blastrac.de
WWW.BLASTRAC.DE

BLASTRAC UKRAINE

SALES & SERVICE CENTRE

Nezalezhnosti 14, of. 21
 07400 Brovary
 Tel.: +38 (0)44 222 51 28
 Fax: +38 (0)44 277 98 29
 Email: info@blastrac.com.ua
WWW.BLASTRAC.COM.UA

BLASTRAC SPAIN

SALES & SERVICE CENTRE

Calle del Estío, 9
 E - 28500
 Arganda del Rey, Madrid
 Tel.: +34 91 660 10 65
 Fax: +34 91 672 72 11
 Email: info@blastrac.es
WWW.BLASTRAC.ES

BLASTRAC UNITED KINGDOM

SALES & SERVICE CENTRE

Unit 2a, Outgang Lane, Dinnington
 Sheffield, South Yorkshire
 GB - S25 3QY
 Tel.: +44 (0) 1909 / 569 118
 Fax: + 44 (0) 1909 / 567 570
 Email: info@blastrac.co.uk
WWW.BLASTRAC.CO.UK

BLASTRAC MIDDLE EAST

SALES & SERVICE CENTRE

P.O. box 29424
 Dubai / United Arab Emirates
 Tel.: +971 4 3245760
 Fax: +971 4 3245761
 Email: info@blastracdxb.ae
WWW.BLASTRAC.AE

BLASTRAC NORDIC

SALES & SERVICE CENTRE

Lekstorps Industriväg 13D,
 443 41, Gråbo
 Sweden
 Tel.: +46 (0) 31 30 333 55
 Email: info@blastrac.se
WWW.BLASTRAC.SE

BLASTRAC INDIA

SALES & SERVICE CENTRE

G.B. Warehousing, GAT NO- 523,
 Pune- Nagar Road, Wagholi
 Pune- 412 207
 Tel.: +91 99213 98109
 Email: info.blastrac.in
WWW.BLASTRAC.IN