



SERVICE MANUAL 2-20DT

VERSION 3.5



Index

Inspection comments	3
1. Spare parts	4
2. Maintenance box Contact	16



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

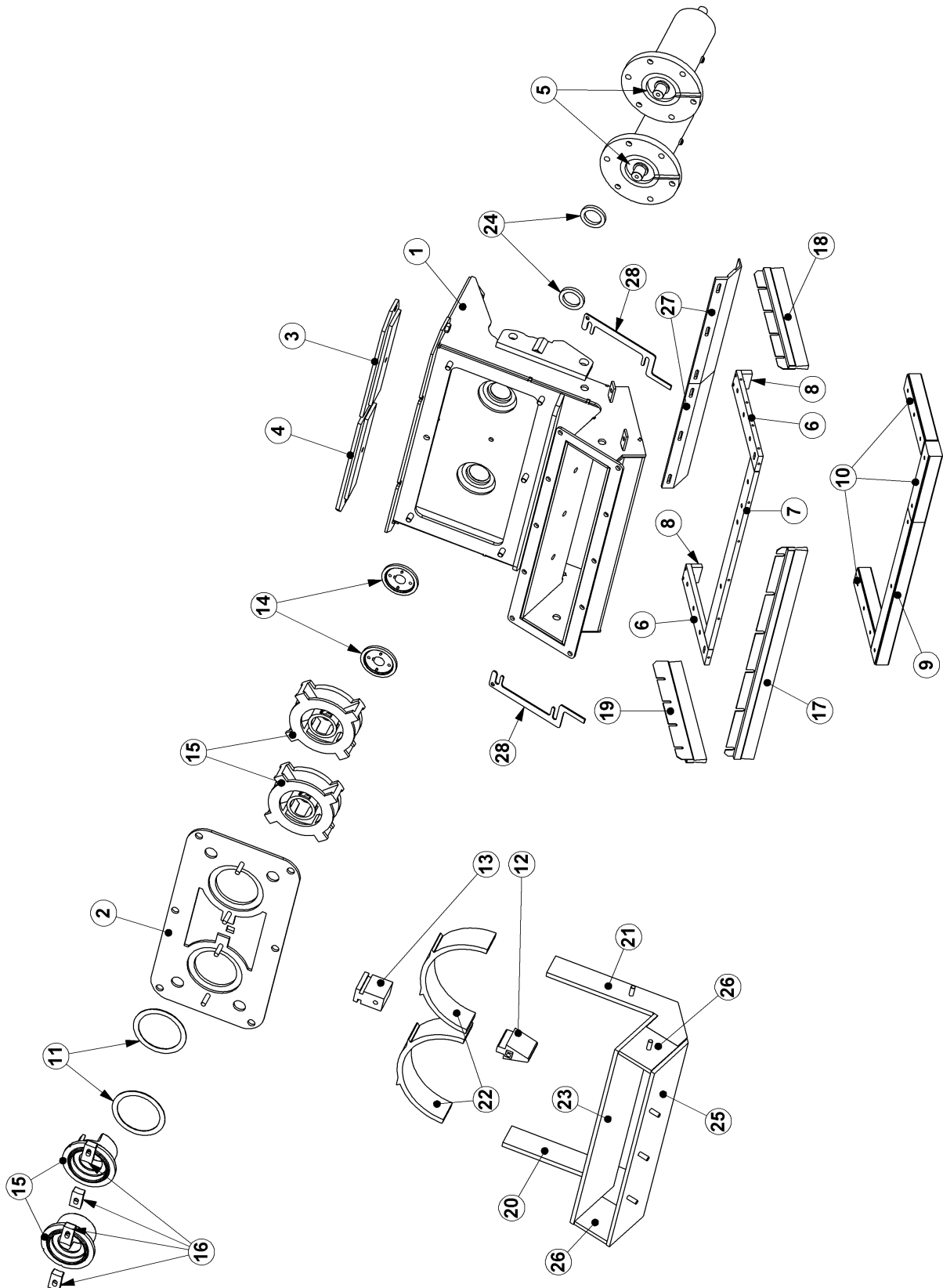




Fig. 01 Blasthousing

Item	Blastrac PN	HQV PN	Description	Qty.
1	E03022	533148701	Blasthousing 2-20DT	1
2	B21317	534076901	Blastwheel cover plate	1
3	B21319	534333101	Blasthousing cover RH	1
4	B21318	534333001	Blasthousing cover LH	1
5	E00842	533807401	Bearing unit complete	2
6	489945	534644801	Insulator side	2
7	B21309	534644701	Insulator front	1
8	481350	534857401	Spacer side magnet rear	2
9	B20804	534696701	Magnet side	1
10	490047	534697301	Magnet side	3
11	972781	534411101	Control cage shim	2
12	B21316-1	533733101	Centerliner bottom part	1
13	B21316-2	533532601	Center liner top part	1
14	B20397	533762001	Hub	2
15	B20536K	531459001	Tune up kit	2
16	969803	534410801	Control cage clamp	4
17	B21330	533533901	Front brush	1
18	E00457	533805801	Side strip brush LH	1
19	E00458	533806501	Side strip brush LH	1
20	B21313	534840401	Side liner LH	1
21	B21312	534841001	Side liner RH	1
22	B20325	533768101	Top liner	2
23	B21315	534766901	Plenum top liner	1
24	B20295	533442501	Felt seal Ø60x8	2
25	B21314	534765501	Plenum bottom liner	1
26	970153	533572901	Plenum bottom side liner	2
27	B21320	533626001	Skid seal	2
28	P003047	534079501	Blast pattern indicator	2

Fig. 02 Motors and wheel bracket
Till serial number 33103B

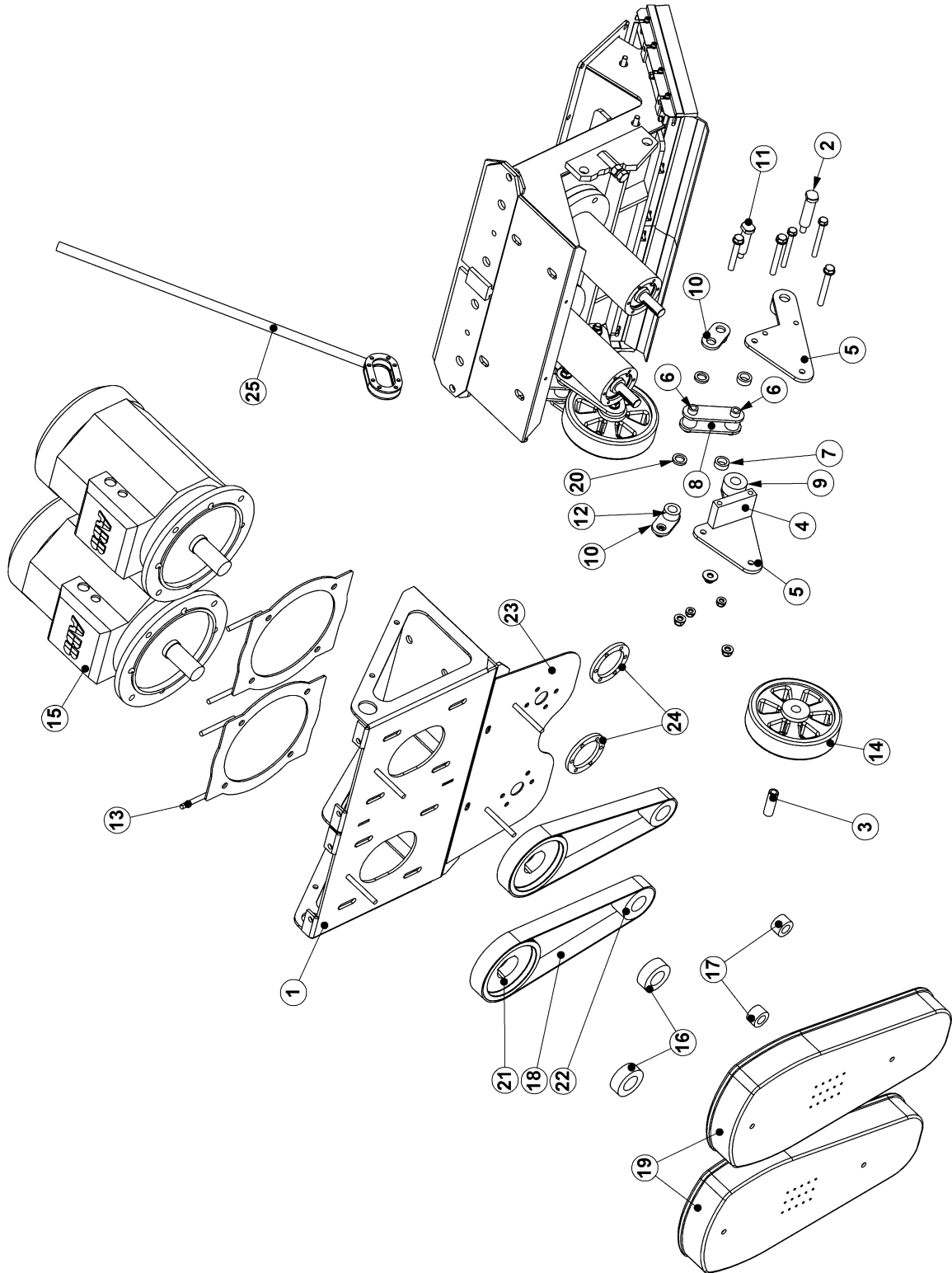




Fig. 02 Motors and wheel bracket
Till serial number 33103B

Item	Blastrac PN	HQV PN	Description	Remarks	Qty.
1	E00836	535260201	Motor bracket ABB twin		1
2	E06468	533212101	Bottom bolt		2
3	E06470	533493301	Idler wheel bush		2
4	E06475	533318701	Distance plate		2
5	E06465	533721101	Wheel bracket side plate		4
6	E06471	533540001	Lever shaft		4
7	E06473	533483201	Lever bush bottom		4
8	E06466	533212001	Bottom lever		4
9	E06472	533733701	Wheel bracket bush		4
10	E06467	533470801	Top lever		4
11	E06469	533220401	Top bolt		2
12	E06474	533264801	Lever bush top		4
13	E00769	533776101	Fill up plate blastmotor		2
14	B20842	533845201	wheel		2
15	E04642-IE2	534029501	Blastmotor 11 kW		2
16*	DG15	533778901	Taper lock		2
17*	976873	533807201	Taper lock		2
18*	491522	534771101	Poly V belt	50Hz	2
	E00468	533277101	Poly V belt	60Hz	2
19	970168	534321201	Pulley guard		2
20	E06855	533513501	Lever bush middle		4
21*	491523/1	533847501	Poly V pulley		2
22*	2613-501	533444701	Poly V pulley (50Hz)	50Hz	2
	E00466	535888401	Poly V pulley (60 Hz)	60Hz	2
23	E00837	534305001	Back plate belt guard twin		1
24	E00864	533725801	Fill up ring bearing unit		2
25	B21917	531472201	Lever		1

***For machines with an adjustable drive option, see next page**

Fig. 2.1 Adjustable drive option

Only for machines with an adjustable drive option

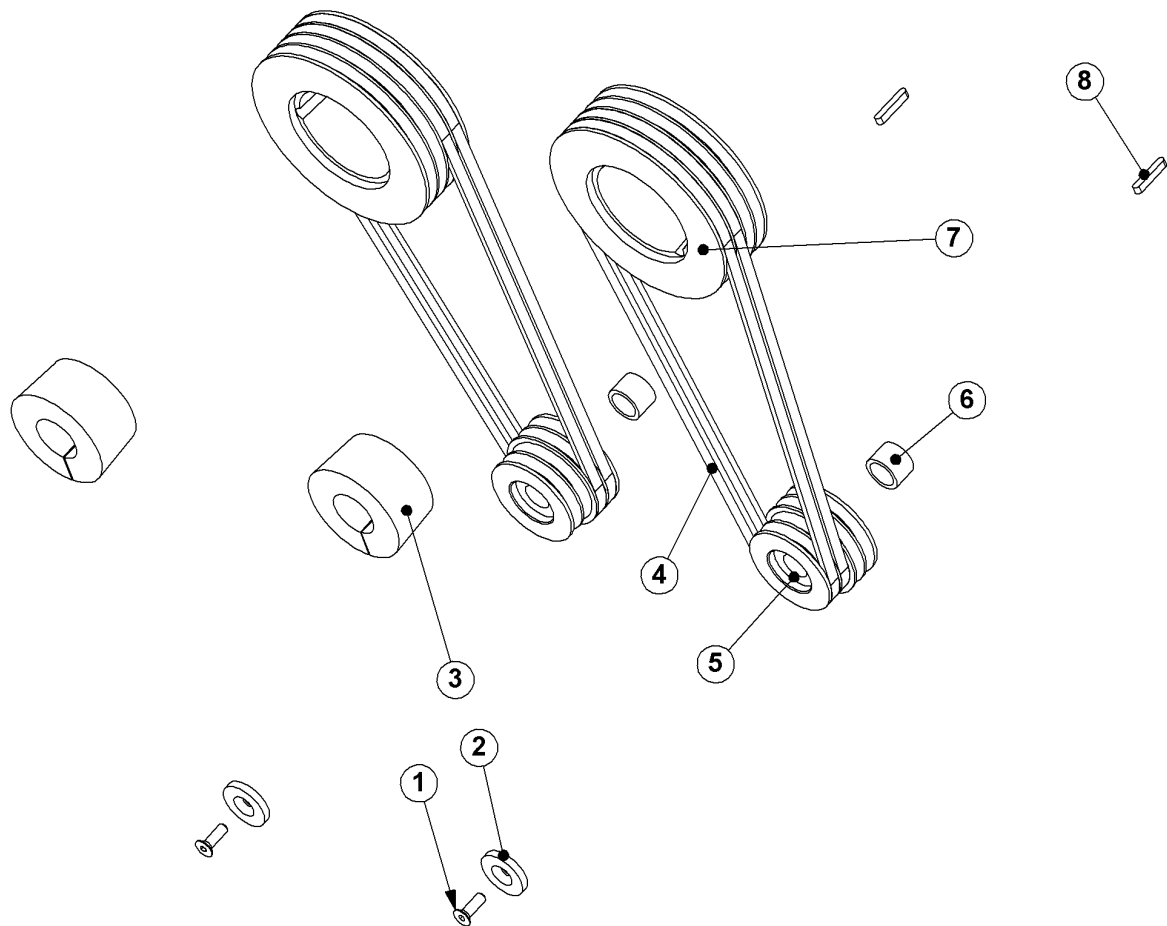




Fig. 02.1 Adjustable drive option

Only for machines with an adjustable drive option

Item	Blastrac PN	HQV PN	Description	Qty.
1	BE0458	533802401	M8x25 countersunk head screw	2
2	E08857	534581201	Fixing ring	2
3	E00425	533378101	Taper lock bush	2
4	E08867	534926401	V-belt	4
5	E08852	534324701	Bottom pulley	2
6	E08853	534514701	Distance bush	2
7	E08858	534324801	Top pulley	2
8			Key 6x6x35	2



Fig. 02.2 Motors and wheel bracket
From serial number 33103B & up

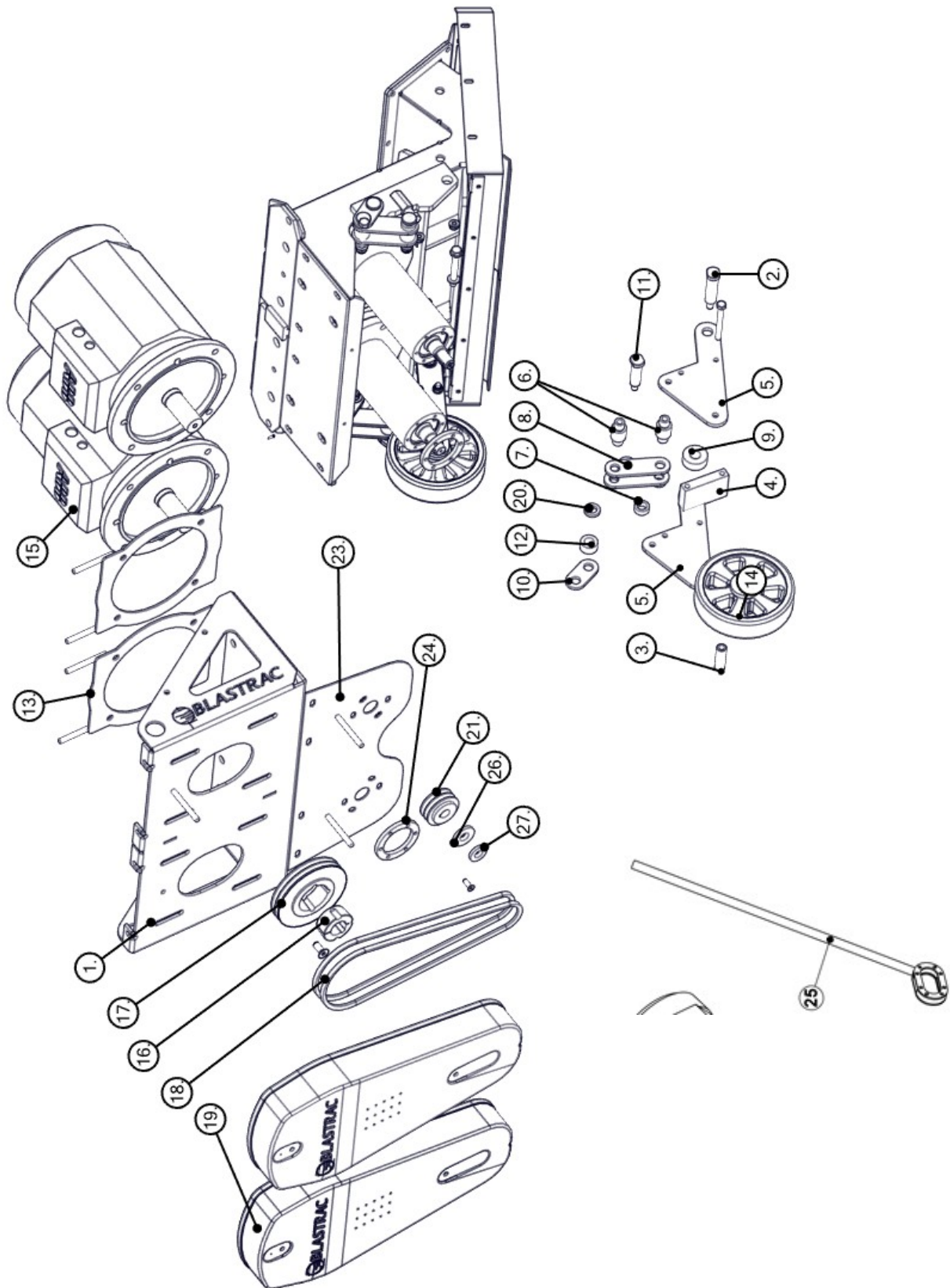




Fig. 02.2 Motors and wheel bracket
From serial number 33103B & up

Item	Blastrac PN	HQV PN	Description	Remarks	Qty.
1	E00836	535260201	Motor bracket ABB twin		1
2	E06468	533212101	Bottom bolt		2
3	E06470	533493301	Idler wheel bush		2
4	E06475	533318701	Distance plate		2
5	E06465	533721101	Wheel bracket side plate		4
6	E06471	533540001	Lever shaft		4
7	E06473	533483201	Lever bush bottom		4
8	E06466	533212001	Bottom lever		4
9	E06472	533733701	Wheel bracket bush		4
10	E06467	533470801	Top lever		4
11	E06469	533220401	Top bolt		2
12	E06474	533264801	Lever bush top		4
13	E00769	533776101	Fill up plate blastmotor		2
14	B20842	533845201	wheel		2
15	E04642-IE2	534029501	Blastmotor 11 kW		2
16	222-2171	533702501	Taper lock bush TL2012-38		2
17	E00268	534323801	Belt pulley		2
18	E19420	535652001	High power XPZ-1112		4
19	970168	534321201	Pulley guard		2
20	E06855	533513501	Lever bush middle		4
21	E19071	534785101	Pulley 50Hz		2
	E19080	534785201	Pulley 60Hz		2
23	E00837	534305001	Back plate belt guard twin		1
24	E00864	533725801	Fill up ring bearing unit		2
25	B21917	531472201	Lever		1

Fig. 03 Drive wheel
From serial number 33102B & up

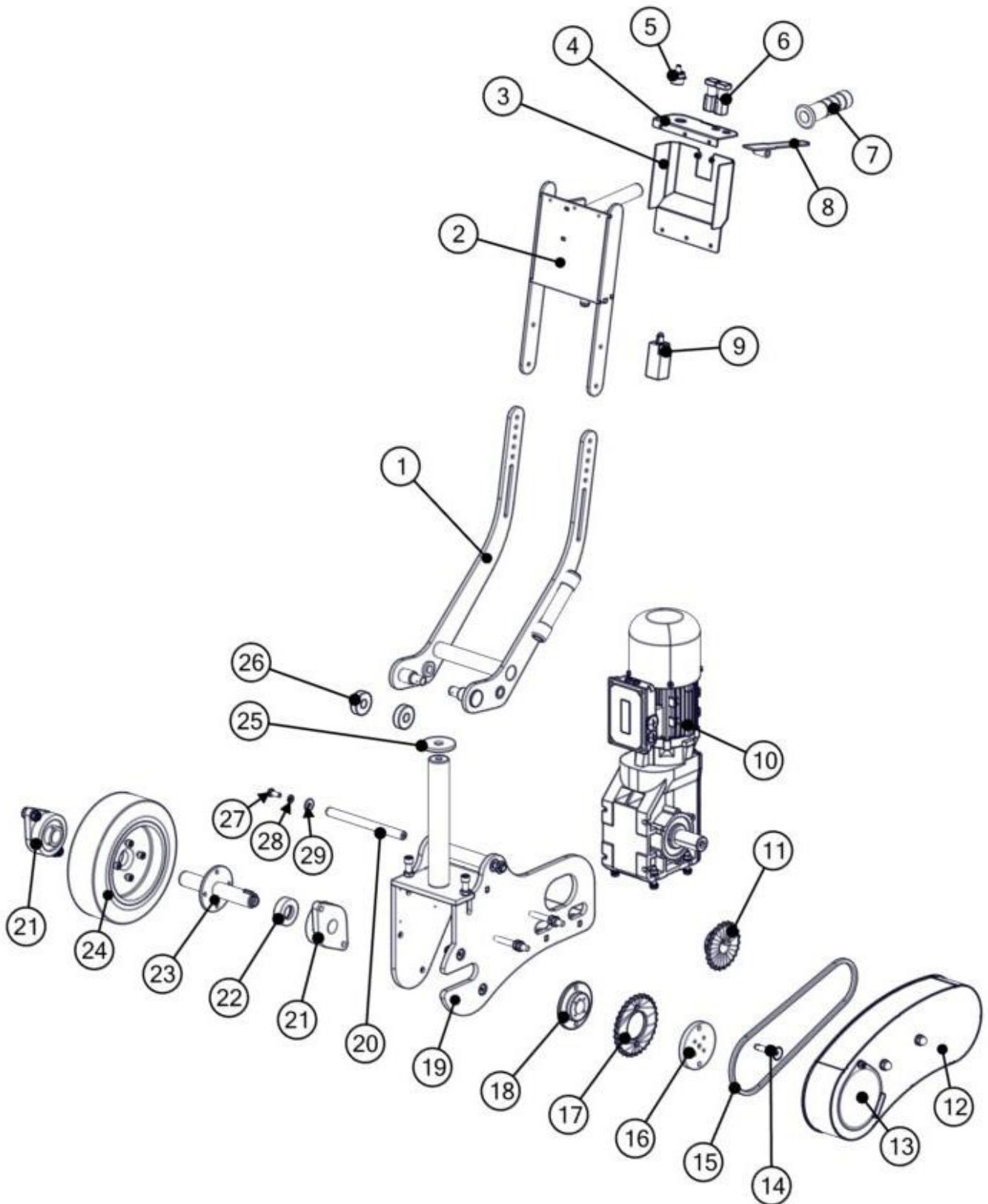




Fig. 03 Drive wheel
From serial number 33102B & up

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	E00664-2/120Hz	534439301	Drive motor 1,1 kW		1
	E19084	534566701	Fan 1,1kW 120Hz		1
	E19085	534567001	Fan cover 1.1kW 120Hz		1
	E19083	534365601	Brake complete		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

Fig. 04 Separator

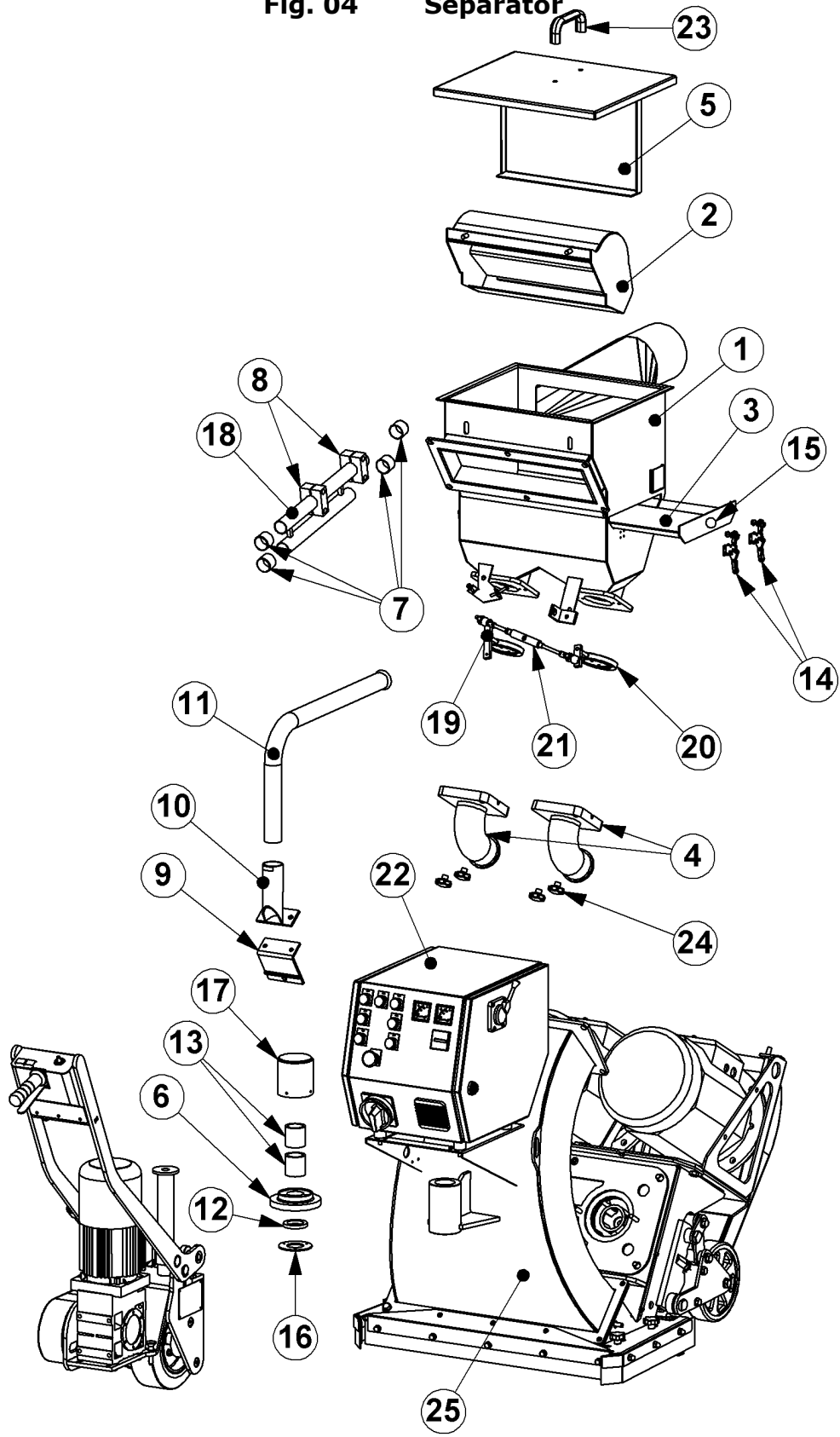


Fig. 04 Separator

Item	Blastrac PN	HQV PN	Description	Qty.
1	B21303	533117901	Separator	1
2	B21297	534435101	Deflector	1
3	B21304	534829301	Separator tray	1
4	970192	533910601	Feed spout	2
5	B20263	533828201	Separator cover	1
6	B20511	533783501	Lifting plate	1
7	E00337	533329001	Cable protection cap	4
8	B21338	533073401	Pipe clamp.35mm (set of 2)	2
9	979994	533547601	Cable pillar bracket	1
10	B20426	533718101	Cable guide support	1
11	B20425	533622401	Cable guide	1
12	B20295	533442501	Felt seal	1
13	971341	533194601	Oilite bush	2
14	001084	534391301	Clamp for separator tray	2
15	B21325	533592601	Ball head for separator	1
16	B20512	533783201	Seal retainer	1
17	B20515	533224801	Shaft cover	1
18	E00839	535145001	Cable guide twin & cable adaption plate	1
19	B21295	533406601	Magnetic valve assembly	1
20	B21295R	533437701	Magnetic valve assembly	1
21	B21329	534912901	Turnbuckle	1
22	E00652	534544801	Electrobox 2-20DT MKII	1
23	970385	533170201	Handle	1
24	000213	533656201	Clamp knob M8	4
25	B21307	534794501	Rebound plenum	1

Fig. 05 Control lever

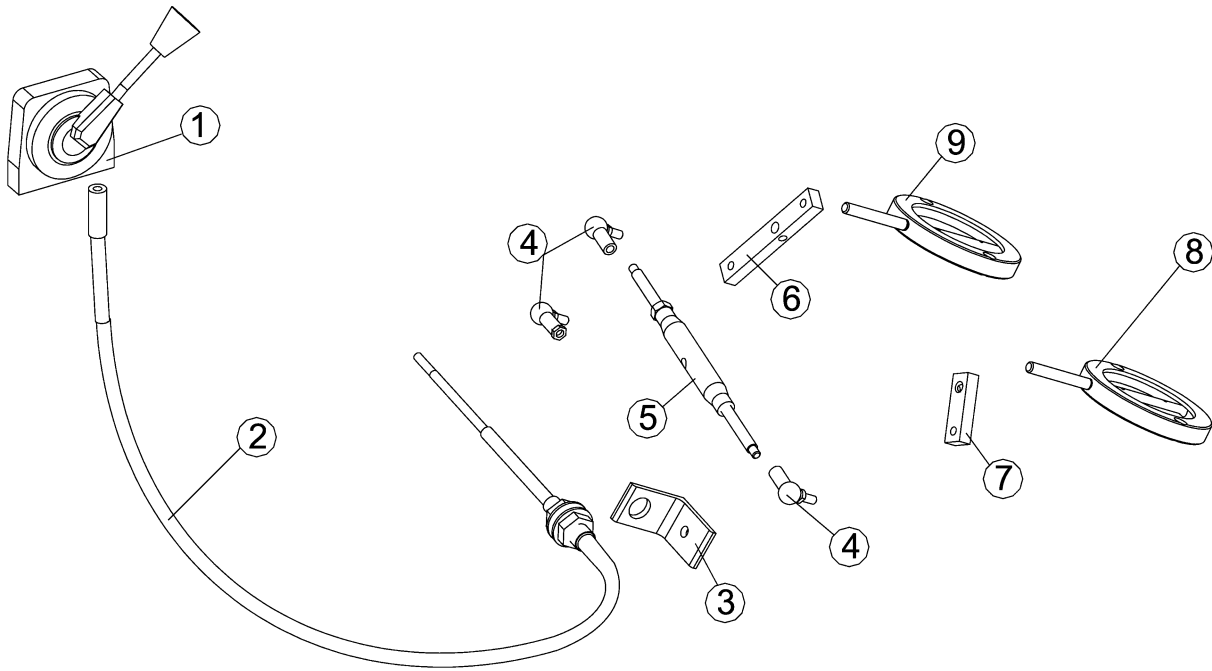


Fig. 05 Control lever

Item	Blastrac PN	HQV PN	Description	Qty.
1	B20519	533839501	Lever for control cable	1
2	B20520	533879301	Control cable	1
3	B21327	534625601	Hold angle	1
4	COZ9/1	534298201	Angle joint	3
5	B21329	534912901	Turnbuckle	1
6	B21326	534664001	Lever magnetic valve long	1
7	B21346	533115401	Lever magnetic valve	1
8	B21295R	533437701	Magnetic valve assembly	1
9	B21295	533406601	Magnetic valve assembly	1

Fig. 06 Options

Fig. 6.1 Protection seal kit (06510)

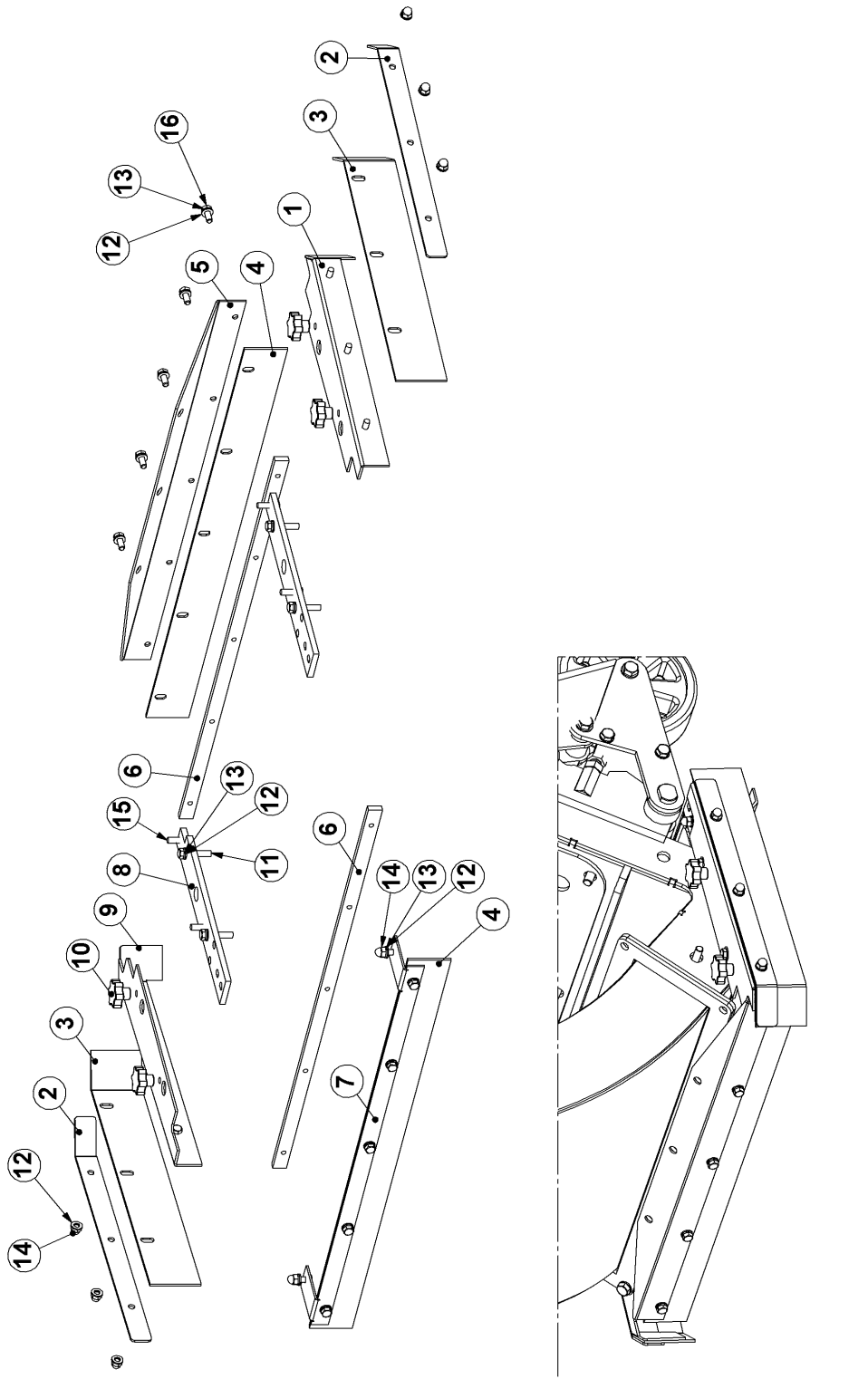
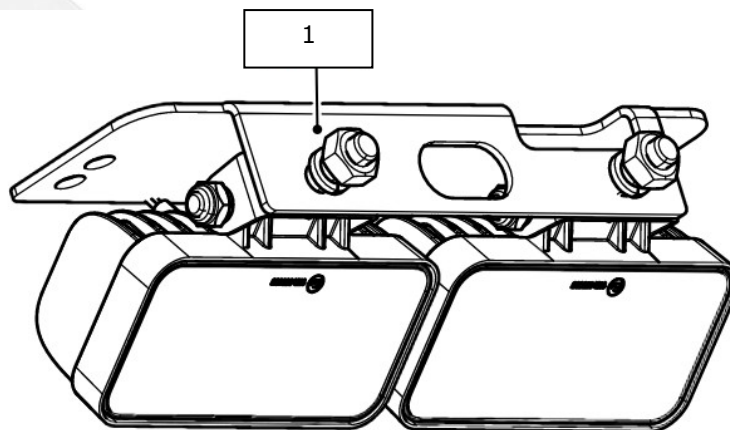


Fig. 6.1 Protection seal kit E06510

Item	Blastrac PN	HQV PN	Description	Qty.
1	E06501	-	Seal plate left	1
2	E06505	535149601	Clamp strip side	2
3	E06508	534841701	Side seal	2
4	E06509	534592101	Front / rear seal	2
5	E06503	-	Angle profile front	1
6	E06506	-	Clamp strip front	2
7	E06504	-	Angle profile rear	1
8	E06507	-	Mounting plate	2
9	E06502	-	Seal plate right	1
10	E03693	534513401	Disc knob plastic M8	4
11	BE0015	534695301	M8 x 40 hexagon bolt	4
12	BE0003	533808601	M8 washer	22
13	BE0005	534693901	M8 spring lock washer	16
14	BE0001	534693601	M8 hexagon domed cap nut	8
15	BE0204	533676101	Hexagon socket thin head cap	4
16	BE0009	534694701	M8x20 hexagon bolt	10

Fig. 6.2 LED light set for shotblasters



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



2. Maintenance box complete E02035

Item	Blastrac PN	HQV PN	Description	Qty.
1	001071	-	Metal box	1
2	B20536K	531459001	Tune up kit	6
3	B21313	534840401	Side liner LH	1
4	B21312	534841001	Side liner RH	1
5	B21316-1	533733101	Centre liner top part	1
6	B20325	533768101	Top liner	2
7	B20520	533879301	Control cable	1
8	491522	534771101	Belt	2
9	E00457	533805801	Side strip brush RH	1
10	E00458	533806501	Side strip brush LH	1
11	B21330	533533901	Front brush	1
12	B21320	533626001	Skid seal	1
13	000117_1	534905001	Tools for maintenance box	1



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