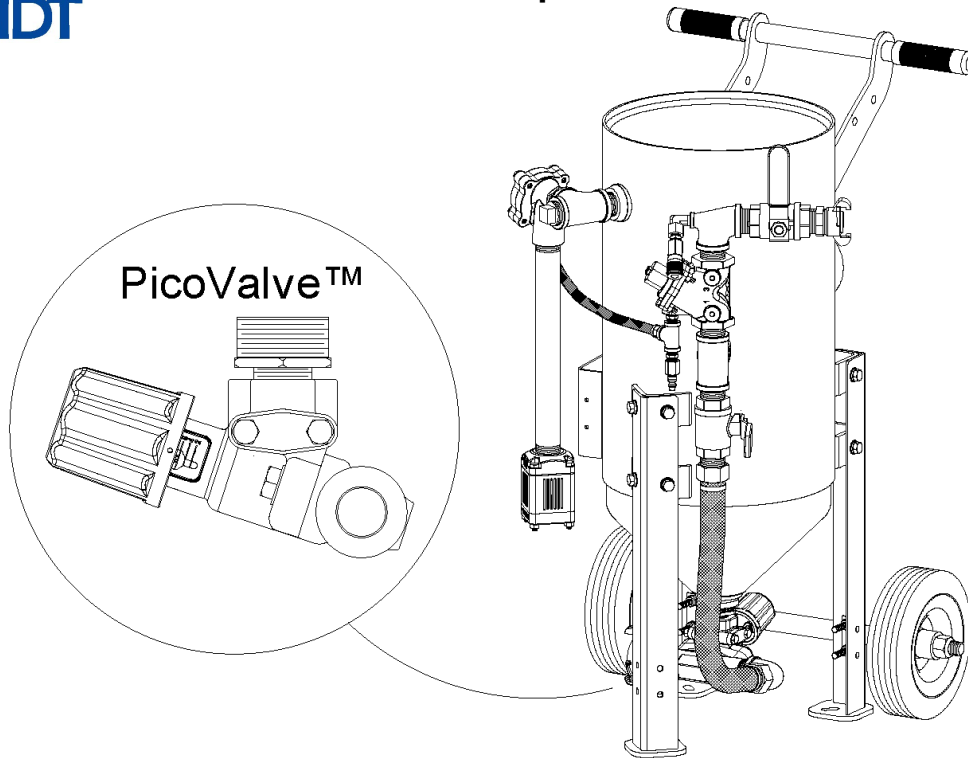




Universal Small Pot 1.5 cu.ft.

OPERATION AND MAINTENANCE MANUAL

September 2026



SCHMIDT®

SAVE THIS MANUAL AND MAKE AVAILABLE
TO ALL USERS OF THIS EQUIPMENT!

Manual Part Number 7200-380-01
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Manual

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WARNING

1. Any person intending to operate this equipment or any person intending to be in the vicinity during its operation must receive proper training from his/her supervisor, employer, and/or supplier. If this equipment is to be leased or rented, the supplier must assure that the lessee or renter has received proper training before the lessee or renter takes possession of the equipment. Consult Axxiom Manufacturing, Inc.
2. Any person authorized to operate this equipment or any person intending to be in the vicinity during its operation and who cannot read and understand this manual must be fully trained regarding the *Rules for Safer Operation* and all operating procedures, and must be made aware of all the Dangers, Warnings, Cautions, and Notices identified herein. Consult Axxiom Manufacturing, Inc.
3. Do Not operate any abrasive blaster or blast equipment before reading and completely understanding all the warnings, operating procedures and instructions, and the *Rules for Safer Operation* contained in this manual.
4. Do Not operate any abrasive blaster or blast equipment without following the *Rules for Safer Operation* and all the operating procedures and instructions. Failure to properly use blast equipment could result in severe injury or death.
5. Do Not perform any maintenance on any abrasive blaster or blast equipment while it is pressurized. Always depressurize the abrasive blaster vessel before loading abrasive or performing any maintenance.
6. Do Not use abrasives containing free silica. Silica can cause silicosis or other related respiratory damage. All operators must wear personal protective equipment for all abrasive blasting operations. Observe all applicable local, state, and federal safety regulations in conjunction with airline filters and respiratory protection. Reference OSHA 29 CFR 1910.134.
7. Do Not enter areas during abrasive blasting operations without breathing protection. All personnel in the vicinity of abrasive blasting operations should wear NIOSH approved air fed respirators, hoods, or helmets.
8. Do Not modify or alter any abrasive blaster, blast equipment or controls thereof without written consent from Axxiom Manufacturing, Inc.
9. Do Not use bleeder type deadman valves on any Schmidt® abrasive blaster. The use of A-BEC, Clemco or a similar bleeder type deadman valve can cause unintentional start-up without warning, which can result in serious personal injury.
10. Do Not sell, rent, or operate abrasive blasters without remote controls. OSHA regulations require remote controls on all blast machines. Failure to use remote controls can cause severe injury or death to the operator(s) or other personnel in the blasting area. Reference OSHA 29 CFR 1910.244(b).
11. Do Not repair or replace any portion of Schmidt® equipment using components that are not Schmidt® original factory replacement parts. Use of replacement components that are not Schmidt® original factory replacement parts may result in equipment failure which can result in serious personal injury and in addition will void all warranties.

Instructions for use of manual sections

This manual contains information needed to operate and maintain your abrasive blaster. Read the entire operations and maintenance manual before using your abrasive blaster. Pay close attention to the *Rules for Safer Operation* (Section 1.0), and the Dangers, Warnings, and Cautions identified.

The purpose of safety symbols and explanations are to alert you of the possible hazards and explain how to avoid them. The safety symbols and explanations do not by themselves eliminate any danger. However, following the instructions given and taking proper accident prevention measures will lower the risk of injury to personnel. Below are the four hazard levels used in this manual.

DANGER

WHITE LETTERS with RED BACKGROUND

DANGER: Indicates an imminently hazardous situation that, if not avoided, will result in death or severe injury. This signal word is limited to the most extreme situations.

WARNING

BLACK LETTERS with ORANGE BACKGROUND

WARNING: Indicates a potentially hazardous situation that, if not avoided, could result in death or severe injury.

CAUTION

BLACK LETTERS with YELLOW BACKGROUND

CAUTION: Indicates a potentially hazardous situation that, if not avoided, may result in minor or moderate injury. It may also be used to alert against unsafe practices that may cause property damage.

NOTICE

WHITE LETTERS with BLUE BACKGROUND

NOTICE: Indicates that equipment could malfunction or potentially become damaged if certain instructions are not followed.

This manual contains terms that may be specific to the abrasive blast industry. Understanding these terms will help you understand the procedures and instructions given in this manual. Please familiarize yourself with the following terms and refer to them as needed while reading this manual.

Term	Definition
Pressure Vessel	A fabricated tank (or reservoir) that is part of the abrasive blaster which is filled with compressed air and abrasive. (Also referred to as “blast vessel” or “vessel.”)
Pressure Equipment	Any equipment that is pressurized with compressed air for operation such as moisture separators, ACS/ADS AirPrep Systems, and abrasive blast systems.
Pressurize	To fill the abrasive blast vessel (manually or automatically) with compressed air.
Depressurize	To release all the compressed air from inside the abrasive blast vessel (manually or automatically). (Also referred to as “blowdown.”)
Depressurized System	An abrasive blaster that is pressurized only when the deadman activates the blast operation. The blaster automatically depressurizes when the deadman is released.
Pressurized System	An abrasive blaster that is automatically pressurized when the air inlet ball valve is opened. The blaster remains pressurized when the deadman is released.
Blowdown	To release all the compressed air from inside the abrasive blast vessel (manually or automatically). (Also referred to as “depressurize.”)
Deadman	A manually operated valve or switch that allows remote starting and stopping of the blast operation. [Also referred to as “deadman valve” (pneumatic blast controls) or “deadman switch” (electric blast controls.)]
Popup	An air pressure operated valve that seals the abrasive inlet at the top of the pressure vessel. Its operation may be manual or automatic.
Abrasive	A granular substance used in the air blast operation that is the means for blasting the surface of an object. (Also referred to as abrasive blasting media.)
Silica	The crystalline chemical compound silicon dioxide (SiO ₂) which can be found in many natural abrasives and other substances. Breathing silica dust can cause respiratory diseases such as silicosis. (Also referred to as crystalline silica)

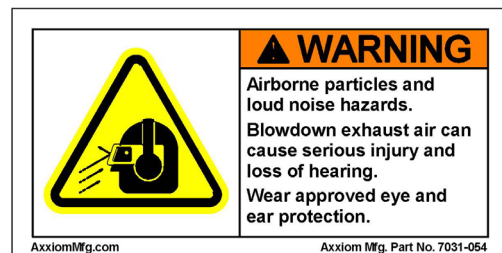
0.0 Warning Decal Identification and Location

Listed below are the warning decals and the corresponding hazards related to this equipment. Refer to Figures 0.1(a) and 0.1(b) for images of the warning decals. Refer to Figure 0.2(a) for the locations of these warning decals on the abrasive blaster.

No.	Qty.	Part no.	Description	Hazard
1.	1	7031-001	Medium “Schmidt”	Not Applicable
2.	1	7031-054	“Warning” Airborne particles and loud noise hazard.	Airborne particles and loud noise from blast nozzle and blowdown can cause injury and loss of hearing. Wear approved eye and ear protection. See Sections 1.0 and 3.10.
3.	1	7031-007B	“Danger” Pressurized vessel.	Propelled objects will cause serious injury or death. Depressurize vessel prior to performing any maintenance. See Sections 6.2 and 6.3.
4.	1	7031-057	“Warning” Read manual before using this machine.	Read and understand the operator’s manual before using this machine. Failure to follow operating instructions could result in injury or damage to equipment. See Section 1.0.
5.	1	7031-077	“Warning” Pinch point hazard.	Vessel pressurization will close popup. Closing popup can pinch and crush. Keep hands and fingers away from popup.
6.	1	7031-082	“Danger” Pressurized vessel Handway components	Propelled objects will cause serious injury or death. Incorrect or damaged handway or manway cover components can result in failure. See Section 6.3.
7.	1	7031-084	“Warning” General hazard and advisory notes.	A general list of required actions to take before and during the operation of this equipment. See Section 1.0.



1) 7031-001



2) 7031-054



3) 7031-007B



4) 7031-057

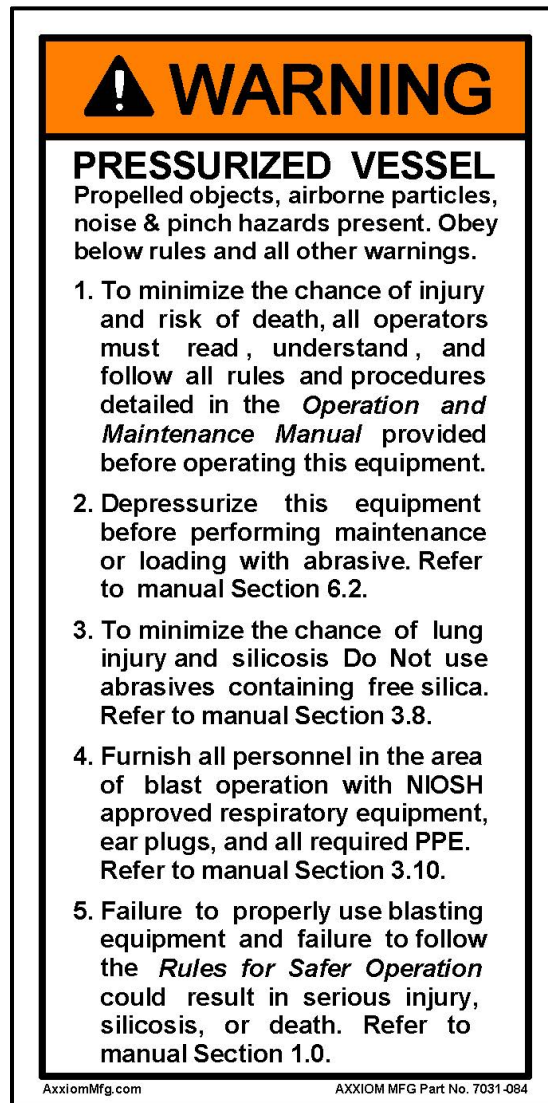
Figure 0.1(a) – Warning decal summary



5) 7031-077



6) 7031-082



7) 7031-084

Figure 0.1(b) – Warning decal summary (continued)

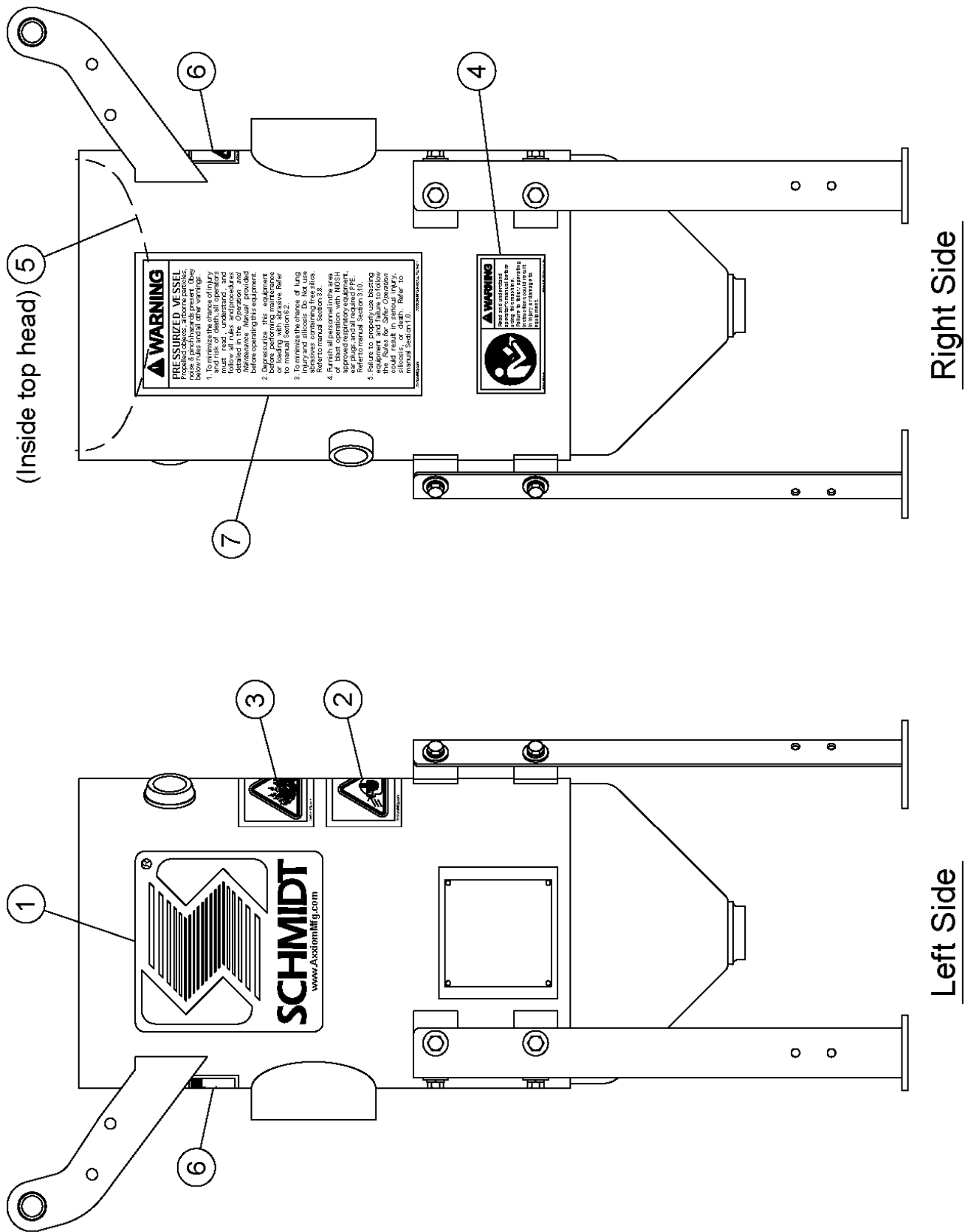


Figure 0.2(a) – Warning decal placement (1.5 cu. ft.)

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1.0 Rules for Safer Operation

1.1. GENERAL RULE FOR SAFER OPERATION.

SCHMIDT® ABRASIVE BLASTERS HAVE BEEN DESIGNED TO BE SAFE WHEN USED IN THE PROPER MANNER. ALL ABRASIVE BLASTERS ARE POTENTIALLY DANGEROUS IF ALL SAFETY PRECAUTIONS ARE NOT RIGOROUSLY FOLLOWED. PROPER TRAINING IS REQUIRED BEFORE OPERATION. PROPER PROCEDURES MUST BE FOLLOWED. THE ABRASIVE BLASTER AND ALL COMPONENTS MUST BE PROPERLY MAINTAINED. FAILURE TO OPERATE, SERVICE AND MAINTAIN THE ABRASIVE BLASTER AS SET FORTH IN THIS MANUAL MAY CAUSE INJURY OR EVEN DEATH TO ANY PERSON USING, SERVICING OR IN THE VICINITY OF THE ABRASIVE BLASTER.

THIS MANUAL IDENTIFIES POTENTIAL HAZARDS BY DANGER, WARNING, AND CAUTION SYMBOLS. HOWEVER, ALL THE RULES, PROCEDURES AND RECOMMENDATIONS MUST BE FOLLOWED. FAILURE TO OPERATE PROPERLY IS VERY LIKELY TO PLACE PERSONS AND PROPERTY AT HIGH RISK OF DAMAGE, INJURY OR EVEN DEATH.



ABRASIVE BLASTERS AND THE ABRASIVE BLAST OPERATION ARE POTENTIALLY DANGEROUS IF ALL SAFETY PRECAUTIONS ARE NOT FOLLOWED. FAILURE TO OPERATE THE ABRASIVE BLASTER WITHOUT FOLLOWING ALL THE *RULES FOR SAFER OPERATION* MAY RESULT IN SERIOUS INJURY OR DEATH TO OPERATING PERSONNEL OR PERSONS IN THE OPERATING VICINITY.

1.2. KNOW YOUR EQUIPMENT.

Do Not operate this equipment in a manner other than its intended application (see Section 4.0). Do Not operate this equipment or any other Schmidt® equipment without following the *Rules for Safer Operation* and all the operating procedures and instructions. Learn the applications and limitations as well as the specific potential hazards related to this machine. Failure to do so could result in serious injury or death.

1.3. RECEIVE PROPER TRAINING.

Do Not operate this equipment unless you have received operational and maintenance training. Begin by thoroughly reading and understanding this operation and maintenance manual and all included information. Consult an authorized Schmidt distributor or Axxiom Manufacturing, Inc.

1.4. PROTECT YOUR FEET.

Do Not operate this equipment without wearing OSHA approved foot protection. Observe all applicable local, state and federal regulations. See Section 3.10 and OSHA 29 CFR 1910.136.



Heavy objects can shift while being blasted and may fall on operators. All operators and personnel in the vicinity must wear OSHA approved foot protection during the operation of this equipment. See Section 3.10 and OSHA 29 CFR 1910.136.

1.5. PROTECT YOUR EYES.

Do Not operate this equipment without wearing OSHA approved safety glasses. Observe all applicable local, state, and federal safety regulations. See Section 3.10 and OSHA 29 CFR 1910.133.



When filling the blast vessel and during the blast operation, abrasive can be blown in the face and eyes of operators. All operators and personnel in the vicinity must wear OSHA approved safety glasses during the operation of this equipment. See Section 3.10 and OSHA 29 CFR 1910.133.

1.6. PROTECT YOUR LUNGS.

Do Not operate this equipment without wearing OSHA approved respiratory protection. Abrasive blasting produces dust contaminated with toxic substances from the abrasive used, the coating being removed, and the object being blasted. This dust may contain silica which can cause severe and permanent lung damage, cancer, and other serious diseases. Do Not breathe the dust. Do Not rely on your sight or smell to determine if dust is in the air. Silica and other toxic substances may be in the air without a visible dust cloud. If air-monitoring equipment for silica is not provided at the worksite, then all personnel MUST wear appropriate respiratory protection when using or servicing this equipment. Breathing air supplied to respirators must be of acceptable quality. Consult your employer and OSHA regarding the appropriate respiratory protection and breathing air quality. See Sections 3.9, 3.10, and OSHA 29 CFR 1910.134.



Abrasive blasting produces dust which may contain silica and other toxic substances that can cause severe and permanent lung damage, cancer, and other serious diseases if inhaled. All operators and personnel in the vicinity must wear OSHA approved respiratory protection during the operation of this equipment. See Sections 3.9, 3.10, and OSHA 29 CFR 1910.134.

1.7. BREATHING AIR QUALITY.

Do Not use breathing air that does not meet OSHA Class D standards. Use extreme caution when selecting a source of breathing air. Breathing air provided by an oil-lubricated air compressor can contain carbon monoxide; therefore, use of a carbon monoxide detector is required (See Section 3.10). Carbon monoxide can be in the compressed air produced by an oil-lubricated air compressor when it is operated at extremely high temperature; therefore, a high temperature alarm is required to alert the operators when this condition exists. See Section 3.9 and reference OSHA 29 CFR 1910.134(i).

Use extreme caution when connecting to factory air sources. Factories can have sources of compressed gases such as nitrogen which is fatal if used as a breathing air source. Verify that the air source is breathable air.



Breathing air must meet OSHA Class D standards. Use of breathing air sources that do not meet Class D standards can cause asphyxiation and result in death. Verify that all air sources are breathable quality and use a high-temperature alarm and a carbon monoxide monitor when required. See Sections 3.9, 3.10 and OSHA 29 CFR 1910.134(i).

Enclosed blast areas must be ventilated to reduce airborne dust to an acceptable level as required by OSHA 29 CFR 1910.1000 and 1910.94.

1.8. PROTECT YOUR HEARING.

Do Not operate this equipment without wearing OSHA approved hearing protection. Observe all applicable local, state and federal safety regulations. See Section 3.10 and refer to OSHA 29 CFR 1926.101 and 1910.95.



Loud noise is produced by the blast nozzle and the blowdown operation of this equipment. All operators and personnel in the vicinity must wear OSHA approved hearing protection during the operation of this equipment. See Section 3.10 and refer to OSHA 29 CFR 1926.101 and 1910.95.

1.9. PROTECT YOUR PERSON

Abrasive blasting produces dust contaminated with toxic substances from the abrasive used, the coating being removed, and the object being blasted. All blast operators and other personnel involved in the blast operation or in the vicinity of the blast operation should wear protective clothing. The protective clothing should be disposable or washable work clothes that should be removed at the worksite so that contaminated dust is not transferred into automobiles or homes. See Section 3.10 and refer to OSHA 29 CFR 1910.94 and 1910.132.

1.10. ADHERE TO ALL REGULATIONS.

Do Not operate this equipment without observing all local, state, and federal safety regulations including, but not limited to, OSHA (Occupational Health and Safety Administration).

1.11. STAY ALERT.

Do Not operate this equipment when you are tired or fatigued. Use caution and common sense while operating and/or performing maintenance on this equipment.

1.12. DO NOT USE DRUGS, ALCOHOL, or MEDICATION.

Do Not operate this equipment while under the influence of drugs, alcohol, or any medication.

1.13. PROTECT BYSTANDERS.

Do Not allow blast equipment operators and other personnel to enter the vicinity of the blast operation without providing respiratory protective equipment that meets OSHA regulations. If dust concentration levels exceed the limitations set in OSHA 29 CFR 1910.1000 then respirators are required.

1.14. KEEP CHILDREN AND VISITORS AWAY.

Do Not allow children or other non-operating personnel to contact this equipment or the connecting hoses and cords. Keep children and non-operating personnel away from work area.

1.15. AVOID DANGEROUS ENVIRONMENTS.

Do Not operate this equipment without familiarizing yourself with the surrounding environment. The blast operation creates high level of noise which may prevent the operator from hearing other possible dangers (i.e. traffic or moving equipment). In such situations a stand-by watch person may be necessary to protect against injury to personnel.

1.16. AVOID DANGEROUS ENVIRONMENTS.

Do Not use this equipment in areas cluttered with debris. Debris in the work area can create tripping hazards which can cause the operator to lose control of the blast hose and result in injury to operating personnel. Keep work area clean and well lit. When working at an elevated location, pay attention to articles and persons below.

1.17. AVOID DANGEROUS ENVIRONMENTS.

Do Not operate this equipment in elevated areas without using fall protection equipment. Certain applications of this equipment may require the use of scaffolding. Use of scaffolding creates hazardous situations such as tripping and fall hazards which can result in serious injury or death to operating personnel. Consult OSHA 29 CFR 1910 Subpart D.

1.18. AVOID DANGEROUS ENVIRONMENTS.

Do Not blast objects that are not properly secured. The blast operation can cause the blasted object to shift or move. Extremely large objects to be blasted can create a crush hazard to operating personnel which can result in serious injury or death. Properly secure the object to be blasted.

1.19. AVOID DANGEROUS ENVIRONMENTS.

Do Not blast objects used to store flammable materials. The blast operation can cause sparks which can ignite fumes or residual flammable materials inside enclosed containers which can explode resulting in serious injury or death to operating personnel.

1.20. AVOID DANGEROUS ENVIRONMENTS

It has been determined that blast abrasives approved for use in blast equipment are not ignitable nor do they present a dust explosion hazard in environments approved for use. However, airborne substances that make up the items and substrates being blasted can be ignitable when mixed with airborne dust from the blast abrasive. To mitigate risk of dust explosion avoid blasting in confined spaces without proper ventilation. Consult plant authorities, OSHA 29 CFR 1910.146 and 1910.94.

⚠ DANGER

Explosion Hazard. Do Not operate blast equipment in confined spaces without proper ventilation. Consult plant authorities, OSHA 29 CFR 1910.146 and 1910.94.

1.21. ELECTRICALLY GROUND EQUIPMENT.

Static electricity is generated by the abrasive flow through the blast hose and/or vacuum hose. To minimize chance of static electrical shock to operating personnel only use anti-static blast hose and/or vacuum hose, properly electrically bond the blast nozzle, blast hose couplings, and the equipment, and properly install an earth ground to the abrasive blaster. See Section 5.10.

1.22. MAINTAIN VESSEL INTEGRITY.

Do Not operate this equipment with the pressure vessel damaged, or with any part of it worn or damaged. Immediately remove damaged vessel from service and have it inspected and/or repaired by a qualified facility. Do Not operate this equipment in a condition that may cause failure of the pressure vessel. See Sections 1.23 through 1.32 below.

⚠ DANGER

An abrasive blaster is a Pressurized Vessel. Alterations, damage, or misuse of the pressure vessel can result in rupturing. Damaged or incorrect components used on the abrasive blaster can result in rupturing. The compressed air inside a pressurized vessel contains a dangerously high level of energy which can propel objects and cause serious injury or death.

1.23. NEVER OPERATE OVER MAXIMUM WORKING PRESSURE.

Do Not operate this equipment above maximum allowable working pressure (MAWP) at maximum operating temperature (°F) shown on the ASME nameplate attached to the vessel. See Sections 2.2 and 8.1.

1.24. INSTALL AN AIR PRESSURE RELIEF DEVICE.

Do Not operate this equipment without an air pressure relief device in place. The ASME Code requires that all vessels be equipped with an air pressure relief devices prior to installation. The air pressure relief device must be set at the maximum allowable working pressure of the abrasive blaster. See the ASME nameplate attached to the vessel typically located above the handway. See Section 3.11 for information regarding the air pressure relief valve.

1.25. NEVER OPERATE BEYOND ALLOWABLE TEMPERATURE RANGE.

Do Not operate this equipment above the maximum allowable temperature at the allowable pressure or below the minimum design metal temperature (MDMT) shown on the pressure vessel nameplate. The characteristics of the pressure vessel metal are weakened when the temperature is outside the operating range. Operating the pressure vessel outside of allowable temperature range can result in rupturing and cause serious injury or death. See Section 2.2.

1.26. ASME NAMEPLATE REQUIRED.

Do Not operate this equipment if the ASME pressure vessel nameplate is missing. Contact Axxiom Manufacturing, Inc. for technical support.

1.27. DO NOT MODIFY VESSEL.

Do Not modify or alter any abrasive blaster, blast equipment, or controls thereof without written consent from Axxiom Manufacturing, Inc. Do Not weld, grind, or sand the pressure vessel. *It will not be safe to operate.* Non-authorized modifications could lead to serious injury or death. Non-authorized modifications will void the warranty and may void the ASME/NB integrity.

1.28. DO NOT HAMMER ON VESSEL.

Do Not hammer on or strike any part of the pressure vessel. Hammering on the pressure vessel can create cracks and cause rupturing.

1.29. FIRE DAMAGE NOTICE.

Do Not operate if the pressure vessel has been damaged by fire. Immediately remove damaged vessel from service and have it inspected and/or repaired by a qualified facility. Contact Axxiom Manufacturing, Inc. for technical support.

1.30. INSPECT VESSEL REGULARLY.

Do Not operate this equipment with damage to the pressure vessel. *It is not safe.* Inspect outside, and inside of the pressure vessel regularly for corrosion or damage (i.e., dents, gouges, or bulges). Immediately remove damaged vessel from service and have it inspected and/or repaired by a qualified facility. Contact Axxiom Manufacturing, Inc. for technical support. See Section 8.0.

1.31. CHECK FOR LEAKS IN VESSEL.

Do Not operate this equipment if there is a leak in the pressure vessel. Immediately remove leaking vessel from service and have it inspected and/or repaired by a qualified facility. Contact Axxiom Manufacturing, Inc. for technical support.

1.32. INSPECT HANDWAY ASSEMBLY.

Do Not operate the abrasive blaster without first inspecting the handway assembly. To ensure proper operation all handway components must be the correct size for the vessel handway opening. See Section 6.3.

1.33. NEVER MODIFY BLOWDOWN.

Do Not connect the blowdown on this equipment onto a common header with any other unit of any description, or any other source of compressed air, without first making sure a check valve is used between the header and this unit. Do Not install this equipment sharing piping with another unit of higher discharge pressure and capacity. A safety hazard could occur in the form of a back-flow condition. Do Not install a muffler or silencer on the blowdown that is not designed for use on abrasive blast equipment it can cause a malfunction and can result in a hazardous condition.

1.34. DEPRESSURIZE VESSEL BEFORE PERFORMING MAINTENANCE.

Do Not remove, repair, or replace any item on this equipment while it is pressurized. Do Not attempt to perform maintenance or load abrasive while this equipment is pressurized or is even capable of being pressurized. This means the inlet ball valve should be closed and the air supply should be shut off or disconnected. Anytime the popup is closed it should be assumed that the abrasive blast vessel is pressurized.



An abrasive blaster is a Pressurized Vessel. The compressed air inside a pressurized vessel contains a dangerously high level of energy which can propel objects and cause serious injury or death. Depressurize vessel before performing any maintenance. See Section 6.2.

1.35. ALWAYS USE REMOTE CONTROLS.

Do Not sell, rent, or operate abrasive blasters without remote controls. OSHA regulations require remote controls on all abrasive blasters. All abrasive blasters must be equipped with automatic (deadman) type remote controls (either pneumatic or electric). Failure to use remote controls can cause serious injury or death to the operator(s) or other personnel in the blasting area. Reference OSHA 29 CFR 1910.244(b).

1.36. NEVER USE BLEEDER TYPE DEADMAN VALVES.

Do Not use bleeder type deadman valves on any Schmidt® abrasive blaster. The use of A-BEC, Clemco, or a similar bleeder type deadman valve can, without warning, cause unintentional start-up which can result in serious personal injury. A particle of dirt from the air hose can plug the bleed hole in the deadman valve and cause the blast outlet to turn on.

1.37. CHECK FOR DAMAGED PARTS.

Do Not use this equipment with damaged components. Periodically check all valves, hoses, fittings, pipe, and pipe fittings (internal and external) to confirm that they are in good condition. Repair or replace any component that shows any sign of wear, leakage, or any other damage. See Section 8.0.



Damaged components can fail during operation and result in serious injury or death to operating personnel.

1.38. ALWAYS USE SAFETY PINS ON HOSE COUPLING CONNECTIONS.

Do Not use this equipment without hose coupling safety pins in place and hose whip checks installed on all air and blast hoses. All blast hose couplings and air hose couplings have pin holes that must be safety pinned to protect against accidental disconnections. Accidental hose disconnection can cause serious injury or death. See Sections 5.12 and 8.7.

1.39. ALWAYS USE CORRECT REPLACEMENT PARTS AND ACCESSORIES.

Do Not use replacement parts or accessories that are not rated for pressures equal to or higher than the abrasive blaster's operating pressure. Improper hoses and/or fittings used on or connected to the abrasive blaster can rupture and cause serious injury or death.

Do Not use replacement parts that are not Schmidt® original factory replacement parts. Non-original parts may not fit properly and can cause equipment damage and/or failure which can result in serious injury to operating personnel. Consult Axxiom Manufacturing, Inc.



Use of replacement components that are not Schmidt® original factory replacement parts may result in equipment failure which can result in serious injury to operating personnel.

1.40. ALWAYS USE CORRECT PRESSURE RATED ACCESSORIES.

Do Not use air reservoirs or moisture separator tanks that are not rated for use in compressed air applications. Air reservoirs and moisture separator tanks larger than 6 inches inside diameter must have an ASME code stamp.



An air reservoir or moisture separator tank is a Pressurized Vessel. The compressed air inside a pressurized vessel contains a dangerously high level of energy which can explode propelling objects and result in serious injury or death to operating personnel. Air reservoirs and moisture separator tanks must be ASME coded tanks.

1.41. NEVER AIM BLAST NOZZLE TOWARDS ANY PERSON.

Do Not aim the blast nozzle towards yourself or any person. A system malfunction or a blocked blast nozzle that clears can trigger accidental start up resulting in injury to personnel.



See Section 11.2.3(7) for instructions to dissipate air pressure from a blocked nozzle.

1.42. NEVER USE ABRASIVE NOT INTENDED FOR BLAST EQUIPMENT.

Do Not use abrasive blast media containing free silica. Silica can cause silicosis or other related respiratory damage. Verify that the abrasive is intended for use in blasting equipment. Personal protective equipment, including airline filters and respirators, must be used for all abrasive blasting operations. Observe all applicable local, state, and federal safety regulations. See Sections 3.8, 3.10, and reference OSHA 29 CFR 1910.134.

1.43. CHECK ABRASIVE FOR DEBRIS.

Do Not use blast abrasive that contains trash or other debris. Trash or debris can create a blockage and cause equipment malfunction. Screen recycled abrasive to remove trash.

1.44. STOP OPERATION IMMEDIATELY IF ANY ABNORMALITY IS DETECTED.

Do Not operate this equipment if anything abnormal is seen during operation. Stop operation immediately for inspection. Refer to Section 8.0 for maintenance and inspection details.

1.45. DO NOT OVERLOAD THE LIFT EYES.

Do Not load the lifting eyes above the rated capacity. Do Not lift the blast vessel by any point other than the lifting eyes or designated lift points. Do Not lift the blast vessel while it is pressurized. See Section 2.6.

1.46. DO NOT TRANSPORT BLAST EQUIPMENT LOADED WITH ABRASIVE.

Do Not attempt to roll portable blasters with abrasive inside. The additional weight of the abrasive can cause loss of control of the blaster while moving which can result in injury to operating personnel.

1.47. MAINTAIN WARNING DECALS.

Do Not remove, cover, obstruct, or paint over any warnings, cautions, or instructional material attached. Warning decals must be installed, maintained, and located to be visible and with enough light for legibility. See Sections 0.0 and 8.14.

1.48. SAVE THIS OPERATION AND MAINTENANCE MANUAL.

Refer to this operation and maintenance manual as needed as well as any additional information included from other manufacturers. Never permit anyone to operate this equipment without having him/her first read this manual and receive proper training. Make this manual readily available to all operating and maintenance personnel. If the manual becomes lost or illegible replace it immediately. This operation and maintenance manual should be read periodically to maintain the highest skill level; it may reduce the chance of a serious accident occurring.

1.49. SAFETY REFERENCES

See Section 12.4 for safety information sources and contact information. Use these sources to obtain additional information regarding all aspects of blast operation safety.

2.0 Specifications and General Information

2.1 Notes to Distributors and Owners

- 2.1.1. Verify that the deadman, twinline, and the operation and maintenance manual are included with the abrasive blaster when it is received. Verify that the deadman, twinline, and the operation and maintenance manual are included with the abrasive blaster when it is delivered to the purchaser.
- 2.1.2. This equipment is intended for knowledgeable and experienced users. No person or persons should be allowed to operate this equipment without first receiving proper training in abrasive blasting operation and use of this equipment.
- 2.1.3. Immediately notify Axxiom Manufacturing, Inc. of any instances of use of this equipment in any manner other than the intended application. See Section 4.0.
- 2.1.4. Only qualified personnel should load and unload this equipment for shipping. Slings or other lifting devices must only be attached to the designated lifting points. See the lifting diagrams shown in Section 2.6.
- 2.1.5. For further information on options and accessories available for Schmidt® abrasive blasters visit the Schmidt website or contact us:

Axxiom Manufacturing, Inc.
11927 South Highway 6
Fresno, Texas 77545
Phone: 1-800-231-2085
Fax: 1-281-431-1717
Website: www.SchmidtMfg.com

2.2 Abrasive Blaster Operational Specifications

Maximum Working Pressure	150 or 175 psig @ 250°F (see ASME nameplate)
Maximum External Pressure	Not designed for external pressure
Minimum Metal Temperature	-20°F @ 150 or 175 psig (see ASME nameplate)
Air Consumption	See Section 13.0 table 1
Abrasive Consumption	See Section 13.0 table 2
Blast Hose Size	See Section 13.0 table 3
Abrasive Capacity	1 Bag: 1.0 cu ft

2.3 Important Reference Numbers

Fill in the Abrasive Blaster model number, serial number, and other information in the blank spaces below. This information will be needed for reference when service, maintenance, or technical support is required.

Blaster Model Number _____

Blaster Serial Number _____ National Board Number _____

Blaster Type: Universal Small Pot 1.5 cu. ft. Blaster Piping Size _____

2.4 Vessel Information

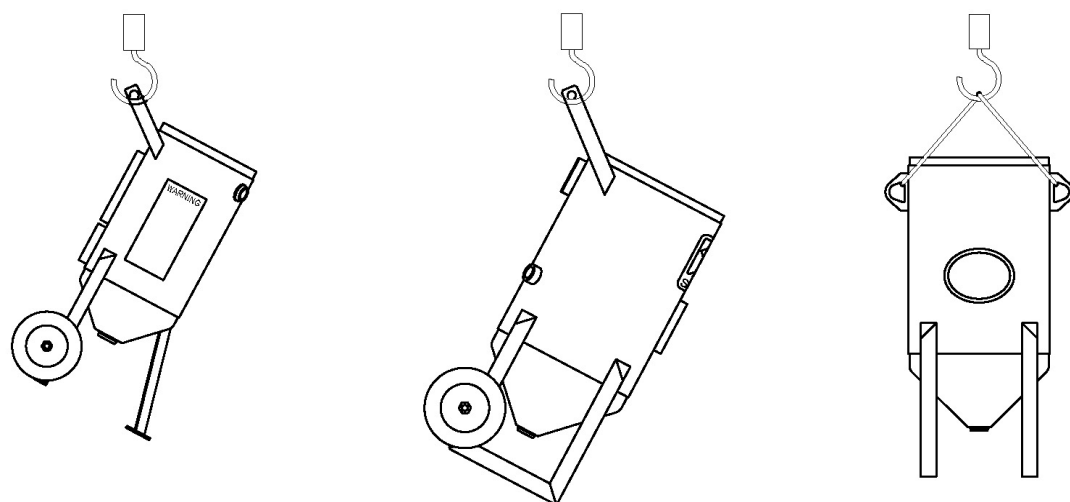
- 2.4.1. All pressure vessels used in Schmidt® Abrasive Blasters are manufactured in strict accordance with the provisions of the ASME Code Section VIII, Div. 1.
- 2.4.2. To maintain the high level of quality and quality control used in the manufacture of this vessel, it is required that all welded repairs to this vessel be performed by a reputable shop holding a National Board “R” Stamp and/or an ASME “U” stamp, depending on state or city law. Welding on the vessel performed by welders not properly qualified per the ASME Code may void the ASME/NB integrity of the vessel.

2.5 Notes

2.6 Abrasive Blaster Lifting Diagrams and Dimensional Specifications



An abrasive blaster is a Pressurized Vessel. The compressed air inside a pressurized vessel contains a dangerously high level of energy which can propel objects and cause serious injury or death. Depressurize vessel and empty of abrasive before lifting, moving, or transporting. See Section 6.2.



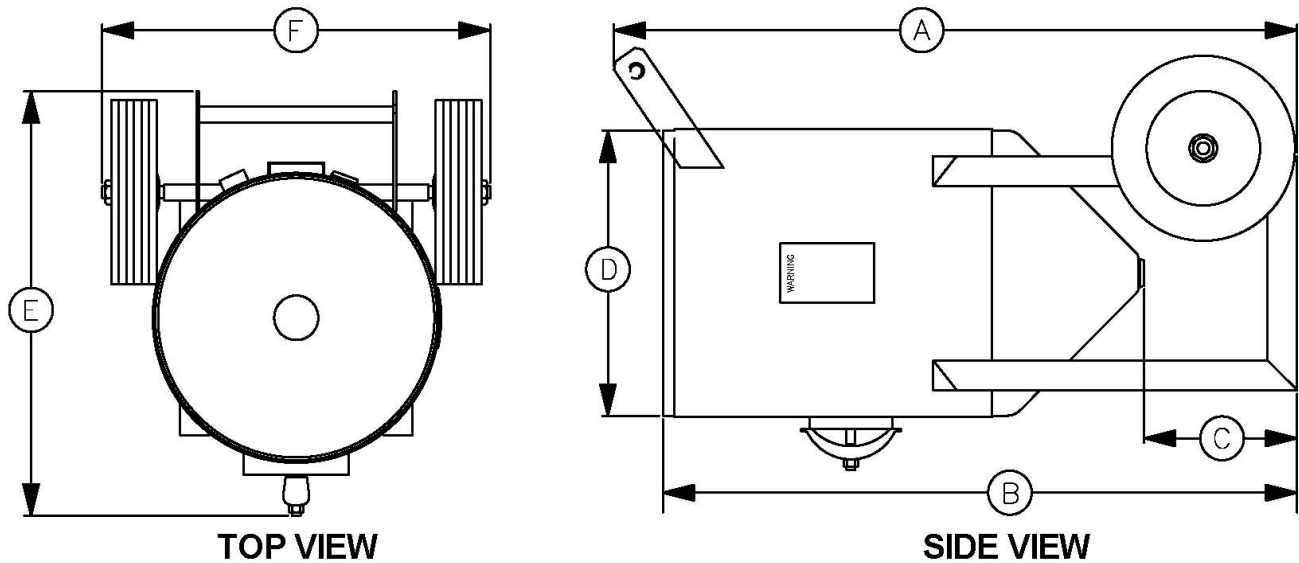
1 BAG PORTABLE

3-10 BAG PORTABLE

3-20 BAG STATIONARY

NOTE: EMPTY LIFT ONLY. DO NOT LIFT WITH ABRASIVE.

Figure 2.6(a) – Abrasive Blaster Lifting Diagram

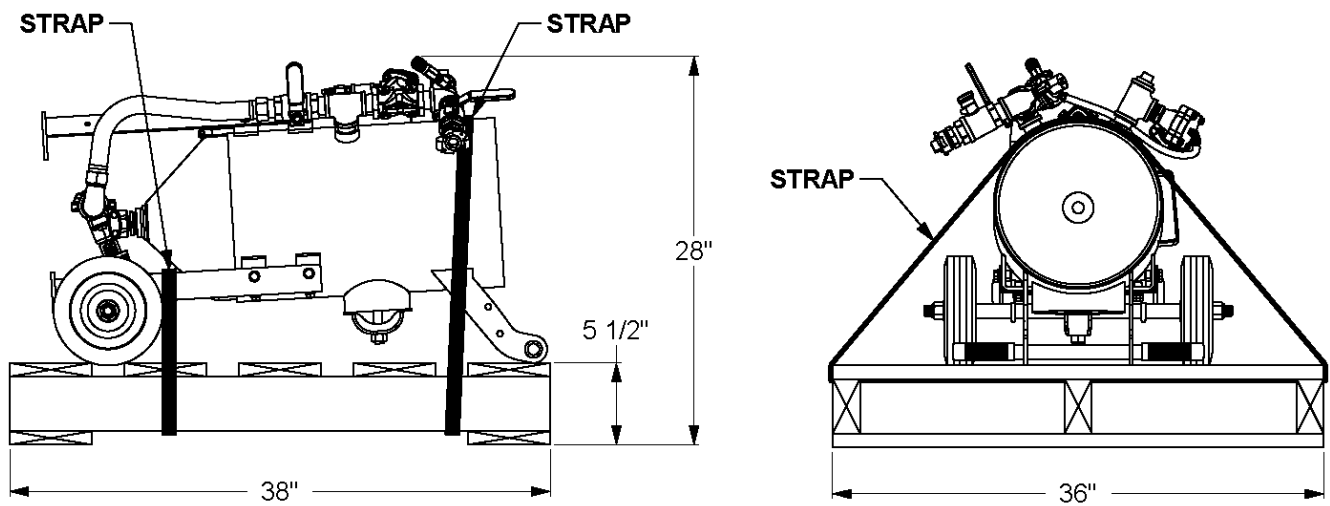


SIZE	CONTROLS	TYPE	A	B	C	D	E	F		*WEIGHT	
1.5	Universal Small Pot/PicoValve®	PORTABLE	36" (914)	33" (838)	6 1/2" 165	12" (305)	22" (559)	23" (584)	in. (mm)	136 (62)	lbs. (kg)

*All weights are approximate and include piping.

Figure 2.6(b) – Abrasive Blaster Dimensional Data

2.7 Abrasive Blaster Strapping / Packing Detail



**LAY BLASTER AS SHOWN TO PREVENT DAMAGE TO PIPING.
STRAP BLASTER TO PALLET AS SHOWN. DO NOT STRAP ACROSS PIPING.
REFER TO SECTION 2.0 FIGURE 2.6(b) FOR BLASTER EMPTY WEIGHT.**

Figure 2.7(a) – 1.5 cu.ft Universal Small Pot Shipping Detail

3.0 Installation Requirements and Personnel Protective Equipment

Carefully read and follow all the recommendations regarding the abrasive blast system installation requirements. Improper installation can result in equipment malfunction and significant lost time expenses. Consult an authorized Schmidt® distributor or Axxiom Manufacturing, Inc.

3.1 Abrasive Blast System Installation Location

Units equipped with handles and wheels are portable and can be rolled to locations where blast jobs are performed. Locate the unit to allow accessibility to the handway and for ease of abrasive filling. Pay close attention to objects that may be in the path of the pressure vessel exhaust air (depressurization). See Section 6.2 for system depressurization.

3.2 Compressed Air Requirements (blast nozzle)

The blast nozzle size and blast pressure determine the compressed air requirements. Available air flow capacity and/or air compressor size must be considered before selecting the blast nozzle size. An air source dedicated to the abrasive blast system is preferred to reduce system pressure drops and back flow of air. If an existing air compressor is used or a limited air supply is available, then the blast nozzle must be selected based on these conditions. Be aware that as the blast nozzle wears the air demand will increase. See Table 1 in Section 13.0 for air consumption by nozzle size at various pressures.

3.3 Air Compressor Size

Air compressor size is crucial to the operation of the abrasive blast system. Blast nozzle selection and desired productivity must be evaluated to determine the air flow requirements prior to selecting the air compressor size. Sufficient air supply capacity is necessary to maintain adequate system air pressure. Insufficient air flow capacity will result in reduced blast nozzle pressure and lost productivity. The air compressor must be large enough to supply:

- i. The sum of blast air requirements for each nozzle at the highest pressure that will be used (see Section 13.0, Table 1).
- ii. The 12 CFM breathing air supplied to each blast operator respirator. **Note:** Reference OSHA regulations regarding requirements for breathing air, especially when an oil-lubricated air compressor is used.

3.4 Blast System Air Supply Line

The air supply hose and fittings must be rated at a minimum of 175 psi operating pressure. The air supply hose from the air compressor to the blast unit should be at least the same diameter as the air inlet piping (see Section 9.0). This size hose will be large enough to supply the required airflow to operate the blast unit controls and each blast nozzle. See Section 5.12 for further information on air hose connection.

Note: If the abrasive blast system will be installed in a permanent location, the inlet connection can be hard piped. Do Not install hard piping that is smaller than the piping size of the blast system. Smaller piping size will reduce the air flow capacity. If other equipment will be using the same source of air as the abrasive blaster, install a check valve at the air inlet. A properly operating check valve will protect against back flow of air pressure that can carry abrasive into the blast controls.

Hard piping connected to the abrasive blaster must be structurally supported so not to apply any loading on the pressure vessel at the points of connection. Unsupported piping can create bending loads at the pressure vessel connections which can cause damage and failure. Hard piping connections to the pressure vessel must be designed and installed by qualified personnel experienced with piping systems and the applicable codes pertaining to them.



External loading at piping connection can cause damage and failure of the pressure vessel. Hard piping connected to the pressure vessel must include support to eliminate the possibility of applying loads on the pressure vessel.

3.5 Blast System Air Pressure

The maximum allowable working pressure (MAWP) for the blast unit is stamped on the ASME nameplate attached to the vessel. For the Universal Small Pot, the MAWP is 175 psig. Do Not exceed the MAWP. An air pressure regulator can be installed to reduce air supply pressure that is higher than the MAWP. To protect against air pressure backflow only use a non-relieving air regulator. Air pressure backflow will carry abrasive from the blast vessel and contaminate the blast control system. **Critical: Any inlet air valve or air pressure regulator added to the system must have sufficient air flow capacity for proper operation of the blast system. Insufficient air flow capacity will cause pressure drop in the blast system resulting in equipment malfunction, abrasive backflow, and reduced blast productivity. Select a valve that will operate with little or no pressure drop (5 psi max.) at the required cfm air flow.**

Installing an air pressure regulator allows the option of blasting at low pressure. When blasting at low pressure the air supply to the deadman blast control system must be at least 80psig (see Figure 5.1). The valves in the abrasive blast system are “spring closed” and therefore require at least 80psig to operate properly. If the air pressure regulator is set below 80psig the air supply to the blast controls must be taken upstream of the regulator.

3.6 Blast System Air Quality

Air quality is crucial to the operation of an abrasive blaster. Moisture and contaminants can cause components to malfunction. Moisture condensation in a blast system causes abrasive flow problems. Condensation occurs when the hot vapor-filled compressed air cools as it reaches the abrasive blaster. Water droplets formed during condensation can be absorbed by the abrasive in the blast vessel which can cause erratic flow to the abrasive valve. To minimize the chance of abrasive flow problems a moisture removal device installed for the blast system air supply is highly recommended (i.e. coalescing moisture separator, air-cooled aftercooler or deliquescent dryer). Contact a local authorized Schmidt® distributor or Axxiom Manufacturing, Inc. to locate one near you.

3.8 Abrasive Selection

Abrasive selection is likely the most difficult decision related to the blast operation. Choice of abrasive is based on factors such as blast application type, desired finish and coating requirements, characteristics of object to be blasted, cost and ability to recycle, available equipment, safety, and environmental constraints.

There are many abrasives available that are either natural, manufactured, or processing by-products. Abrasives are available in varying sizes, shapes, and hardness. These characteristics determine the resulting effect on the surface to be blasted and limitations of its use. The effects on the blasted surface are measured by its degree of cleanliness and the surface profile. Standards and required levels of these measurements are established by organizations such as the Association for Materials Protection and Performance (AMPP) and coating manufacturers. See Section 12.5 for contact information for these organizations. Use these sources to obtain information regarding all aspects of surface preparation and abrasive selection guidelines.

Schmidt® abrasive blasters are designed for high production open abrasive blasting with a wide range of abrasives. It is the responsibility of the employer and operators to select the proper abrasive. It is the responsibility of the employer to make certain that the abrasive selected is safe to use for abrasive blasting.

Critical: Always obtain the Material Safety Data Sheet (MSDS) for the abrasive to be used. The MSDS provides the chemical makeup of the abrasive. Do Not use abrasives containing toxic materials. Refer to OSHA 29 CFR for acceptable limits of various toxic substances and additional measures to be taken to protect operating personnel. Always use abrasives containing less than 1% crystalline silica. Always use a NIOSH approved respirator when handling, loading, and cleaning up abrasives. Organic substances which are combustible may only be used in automated blast systems with ventilation that meets OSHA 29 CFR 1910.94.

3.9 Breathing Air Quality

All blast operators must be supplied with and required to use NIOSH approved air-fed respirators. Breathing air supplied to these respirators must meet Grade D air quality standards as specified by OSHA 29 CFR 1910.134(i) and the Compressed Gas Association Specifications ANSI/CGA G-7.1. Consult these specifications when selecting a source of breathing air.

Breathing air must be clean, dry, contaminant-free, and provided at a pressure and volume specified by NIOSH. Use NIOSH approved air filters on all sources of breathing air. See Section 3.10.

DANGER

Breathing air filters do not remove carbon monoxide or any other toxic gases. Use a carbon monoxide monitor to detect unacceptable levels. Consult OSHA 29 CFR 1910.134(i).

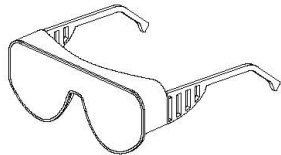
Many sources of breathing air are available such as air cylinders, free-air pumps, oil-less air compressors, and oil lubricated air compressors. The most used source is the same air compressor that is used for the blast air which most often is oil lubricated. Breathing air provided by an oil-lubricated air compressor can contain carbon monoxide and therefore requires the use of a carbon monoxide detector (See Section 3.10). Carbon monoxide can be in the compressed air produced by an oil-lubricated air compressor when it is operated at extremely high temperature; therefore, a high temperature alarm is required to alert the operators when this condition exists.

DANGER

Oil lubricated air compressors can produce carbon monoxide. Carbon monoxide can cause asphyxiation and result in death. Use a high-temperature alarm and a carbon monoxide monitor when an oil lubricated air compressor is used to supply breathing air. Consult OSHA 29 CFR 1910.134(i).

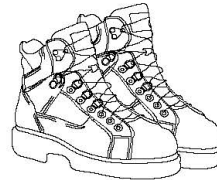
3.10 Personal Protective Equipment (PPE)

Abrasive blasting has many hazards that may cause injuries to operators. To minimize risk of injury to operators, each must be supplied with, and required to use Personal Protective Equipment. The Occupational Health and Safety Administration (OSHA) requires the employer to assess the workplace to determine what PPE is necessary and supplied to each operator (Reference 29 CFR 1910 Subpart I). OSHA requires that this equipment meet or be equivalent to standards developed by the American National Standards Institute (ANSI). Figure 3.10 below identifies the minimum personal protective equipment required for each abrasive blast operator. Also identified are the OSHA references for each and the ANSI standard each PPE item must meet. All PPE clothing and equipment should be selected for safe design and quality of construction. Select each for proper fit and for comfort which will encourage operator use.



Safety Glasses

Reference OSHA 29 CFR 1910.133
Must meet ANSI Z87.1



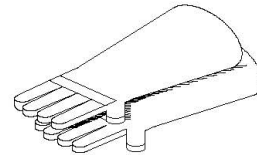
Safety Boots

Reference OSHA 29 CFR 1910.136
Must meet ANSI Z41.1



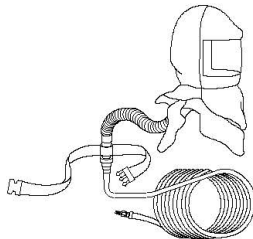
Ear Plugs

Reference OSHA 29 CFR 1926.101
Must meet ANSI S3.19
(Also see OSHA 29 CFR 1910.95)



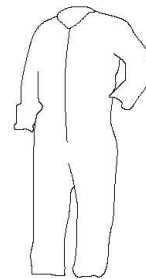
Gloves

Reference OSHA 29 CFR 1910.138
No Applicable ANSI Standard



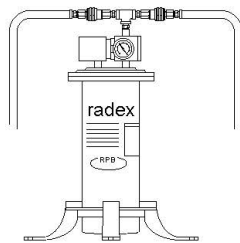
Respirator

Reference OSHA 29 CFR 1910.134
Must be NIOSH approved



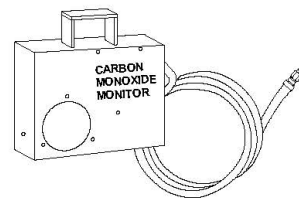
Protective Clothing

Reference OSHA 29 CFR 1910.132
No Applicable ANSI Standard



Airline Filter

Reference OSHA 29 CFR 1910.134
Must be NIOSH approved



Carbon Monoxide Monitor

Reference OSHA 29 CFR 1910.134

Figure 3.10 - Personal Protective Equipment

3.11 Air Pressure Relief Valve Installation

NOTICE

For the purpose of this manual the terms “user” and “owner/operator” are defined as the person, persons, or entity that is connecting the pressure equipment to an external pressure source such as, but not limited to, an air compressor.

Design and application of an air pressure relief device(s) without complete knowledge of the pressure source (such as, but not limited to, an air compressor) and other causes of over pressurization could result in an unsafe installation, serious injury, or death.

Because Axxiom Manufacturing, Inc has no knowledge of the pressure source(s) to be connected to the pressure equipment, Axxiom is not defined as the “user” and does not supply pressure equipment with an air pressure relief valve. Reference ASME Section VIII, Division 1 Part UG-150 and ASME Section XIII, Part 2.

The user person or entity selecting the pressure source and connecting the pressure equipment to pressure is the responsible person or entity to identify all potential overpressure scenarios and select the appropriate over pressurization protection.

Do Not operate this equipment without an air pressure relief device installed to protect the blaster pressure vessel from over-pressurization. The ASME Code requires that all vessels be operated with an air pressure relief device in place.

If the compressed air system does not provide for the installation of an air pressure relief valve one can be installed on the pressure vessel piping. Refer to Figure 3.11 for the recommended location of the air pressure relief valve.

Local regulations set the specifications for air pressure relief valves; therefore, it is the responsibility of the user and/or owner/operator of the pressure equipment to install an air pressure relief valve that meets *all* applicable regulations. The air pressure relief device must be set at or below the maximum allowable working pressure of the abrasive blaster pressure vessel. See the ASME/CE vessel nameplates attached to the pressure vessel.

⚠ DANGER

Rupture Hazard. Operating the pressure vessel above the maximum allowable working pressure can result in rupturing the pressure vessel which can cause serious injury or death. Install an air pressure relief valve to protect against over pressurization of the blast vessel.

⚠ WARNING

Airborne particles and loud noise hazards from relief valve exhaust air can cause serious injury and loss of hearing. Wear approved eye and ear protection. Stay clear of exhaust air path. DO NOT place hands or other body parts in the exhaust air path. Make sure no personnel are in the exhaust air path. Direct the relief valve exhaust away from work area.

⚠ WARNING

In special cases at the request of customer, an air pressure relief valve may be included with the equipment. It is the responsibility of the user and/or owner/operator to confirm that the supplied air pressure relief valve meets all local regulations.

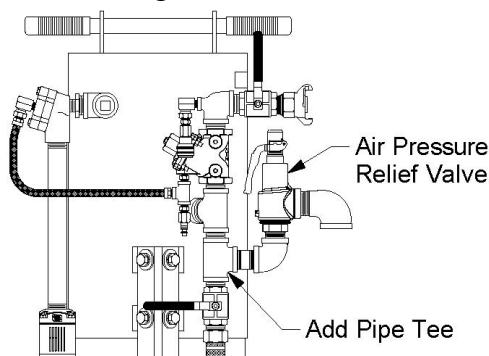


Figure 3.11 – Suggested location for air pressure relief valve

3.12 INSTALLATION CHECKLIST (Photocopy this page to use as a worksheet)

- ☐ **Deadman/Twinline (or cords):** confirm delivery with the abrasive blaster.
- ☐ **Blast accessories:** confirm receipt as purchased with the blaster.
- ☐ **Inspect blaster:** check for damage during shipment. See Section 8.0 for inspection instructions.
- ☐ **Popup alignment:** remove popup dust cover from top head and check popup alignment. Shifting of the popup is possible during shipment. See Section 8.4 for inspection & alignment instructions.
- ☐ **Clean blaster:** remove handway cover and check for debris inside. Trapped debris can vibrate loose during shipment and later block abrasive flow. If necessary, vacuum the bottom of tank. Replace handway cover per instructions in Section 6.3.
- ☐ **Accessible location:** install abrasive blasters so that handway is accessible for maintenance. See Section 3.1 for additional information.
- ☐ **CFM available:** determine available air supply (cfm) and record here. _____
See Sections 3.2, 3.3, and 3.5 for information on determining air requirements.
- ☐ **Air supply connection:** install air supply piping or connect an air supply hose that is the same size as the blaster piping size or larger. See Section 3.4 for details.
- ☐ **Air quality:** install moisture separator or AirPrep System to remove moisture from blast air supply to protect against abrasive flow problems. See Section 3.6.
- ☐ **Blast abrasive:** select abrasive suited for application. See Section 3.8.
- ☐ **Breathing air:** provide Grade D air source for blast operators. See Section 3.9.
- ☐ **PPE:** provide all the necessary personal protective equipment. See Section 3.10.
- ☐ **Air Pressure relief valve:** install an air pressure relief valve. See Section 3.11 for information on the air pressure relief valve installation.
- ☐ **Blast nozzle:** select size based on available cfm noted above. See Section 5.11.
- ☐ **Blast hose:** select size three times the nozzle size to be used. See Section 5.10.
- ☐ **Install ground:** install earth ground. Electrically bond components. See Section 5.10.
- ☐ **Operator training:** all operators must completely read and understand the operation and maintenance manual and be trained in equipment and blast operations.
- ☐ **Abrasive Blaster Setup:** follow procedures in Section 6.0.

4.0 Abrasive Blast System General Operation

The function of the Schmidt® abrasive blaster is to provide a mixture of dry abrasive and compressed air to a blast nozzle. The abrasive blast stream through the blast nozzle is used for removing rust, paint, or other unwanted surface defects. After abrasive blasting, the surface is ready for new paint or coating.

An abrasive blaster is one of a group of components used in an abrasive blasting job. The typical components are an air compressor, moisture removal device, an abrasive blaster, blast hose, a blast nozzle, operator personal protective equipment, and blast abrasive. See Figure 4.1.

The blast abrasive is loaded into the abrasive blaster through the abrasive inlet at the top of the blaster. All the compressed air must be removed from inside the abrasive blaster before it can be filled with abrasive. The abrasive can be bag loaded or loaded from a Schmidt storage hopper. To begin blasting, the abrasive inlet is closed, and the abrasive blaster is filled with compressed air from the air compressor. To minimize the occurrence of problems in the blast operation it is common for the compressed air to be fed through a moisture removal device, such as a Schmidt AirPrep System. The air pressure in the abrasive blast vessel is equal to the air pressure in the blast hose where it connects at the metering valve. This equal pressure is needed to allow the blast abrasive to flow downward by gravity. The abrasive flow is controlled by the metering valve at the bottom of the blaster. From the metering valve the blast abrasive flows into the blast air stream and through the blast hose. The speed of blast air and abrasive mixture is increased by the blast nozzle onto the work surface. The high speed of the air and abrasive is what gives it the energy to blast rust and paint from work surfaces. The abrasive blast stream and the dust it creates are harmful; therefore, all blast operators must use personal protective equipment during the blast operation.

All the components required for the blast operation (except for the air compressor) are available from Axxiom Manufacturing, Inc. Call Schmidt® to locate a distributor.

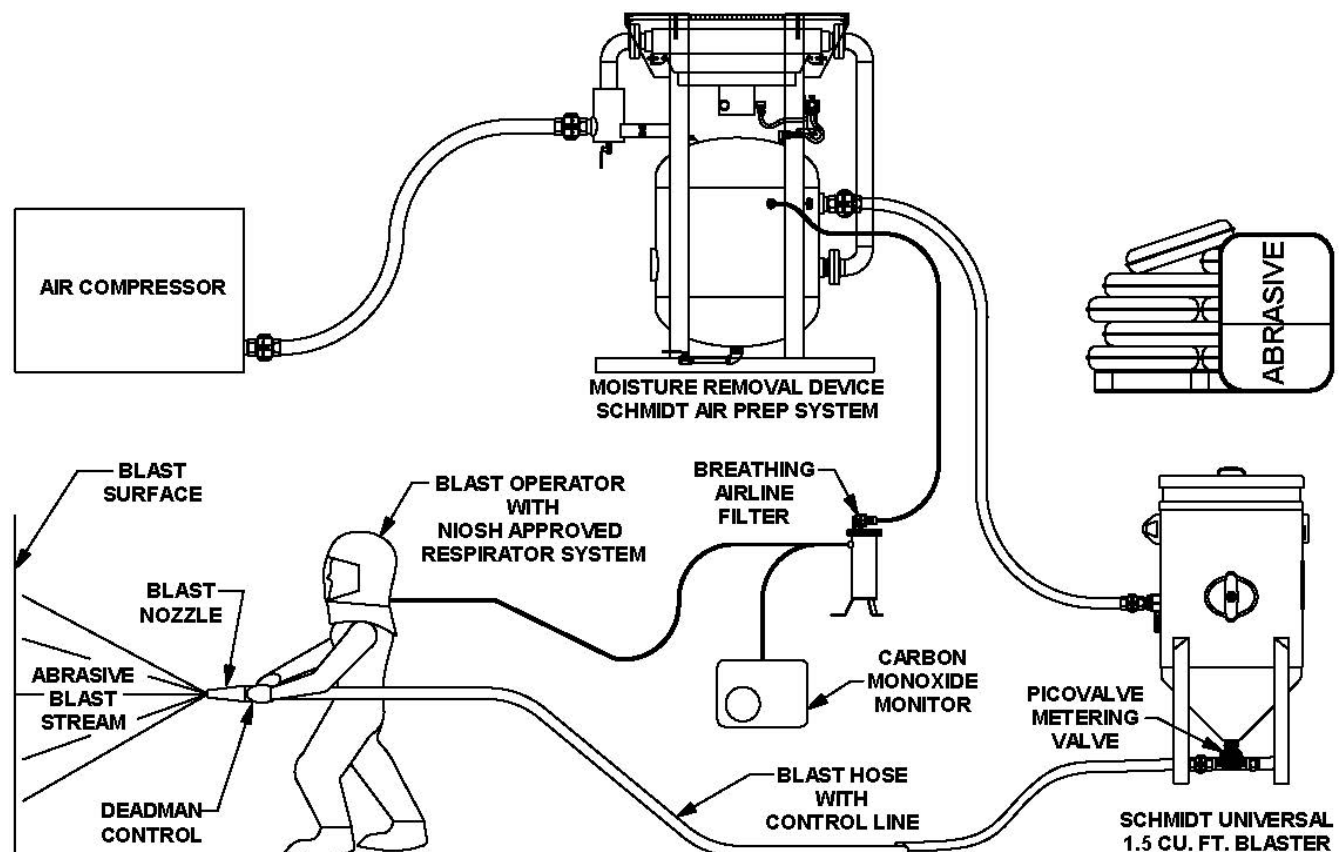


Figure 4.1 – Typical Abrasive Blast System

5.0 Universal Small Pot General Operation

See Figure 5.1 below or Figure 9.1 to help understand the general operation of a Universal Small Pot abrasive blaster. Do not attempt to operate the abrasive blaster before reading all sections of this manual and following all setup procedures. Read Sections 5.1 through 5.16 for a detailed explanation of all components of the abrasive blaster.

The Universal Small Pot is a *depressurized system*; meaning the blaster will pressurize only when the exhaust valve (#4) is closed, and the automatic air valve (#9) is opened by pressing the G3 deadman trigger (#12).

Compressed air enters the blast system when the air inlet ball valve (#3) is opened. Air flows into the supply side of automatic air valve (#9) and G3 deadman valve (#12). When the G3 deadman (#12) is activated, signal air will flow back to close the exhaust valve (#4) and open the automatic air valve (#9). When the automatic air valve opens, air will flow into the blast vessel internal piping. The air flow pushes the popup (#5) against the gasket (#6) to seal the abrasive inlet and allow the air flow to pressurize the blast vessel (#1) and the blaster piping (#13).

Blasting starts when the G3 deadman trigger (#12) is pressed down. Compressed air will flow from the automatic air valve (#9) to the blast hose (#10). The choke ball valve (#13) must be fully open during the blast operation. Abrasive will flow through the PicoValve™ (#14) and fall into the blast air stream. The abrasive flow can be increased or decreased by turning the knob on top of the PicoValve (#14). Because of the length of the blast hose, it will be a few seconds to see changes in abrasive flow.

Blasting stops when the G3 deadman trigger (#12) is released. This will close the automatic air valve (#9) and open the exhaust valve (#4) at the same time to depressurize the vessel. The compressed air in the abrasive blaster will exhaust through the VBS® Lite (#45). The abrasive blaster (#1) remains depressurized when the automatic air valve (#9) is closed.

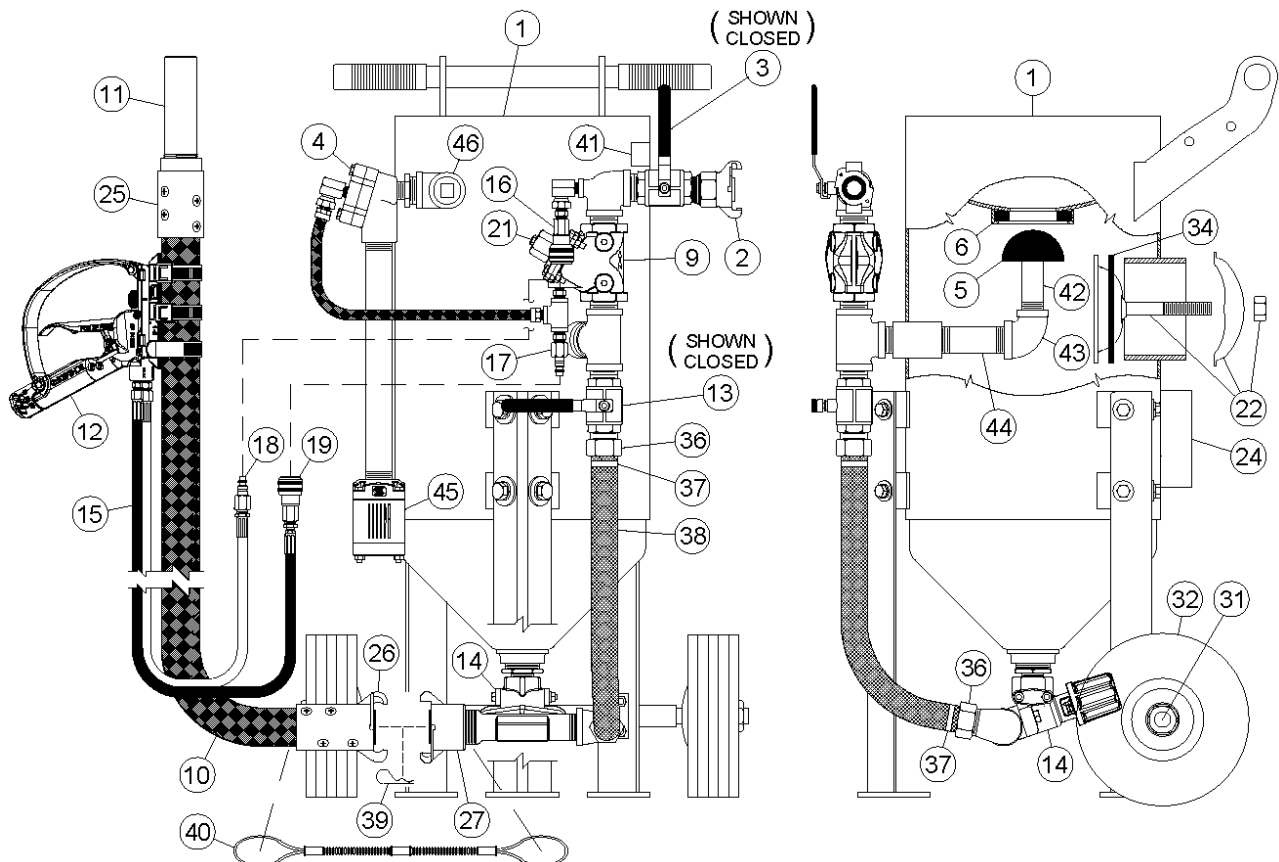


Figure 5.1 – Universal Small Pot with pneumatic blast controls

5.1 Popup Valve (abrasive inlet)

The blaster is filled with abrasive through the abrasive inlet at the top of the pressure vessel. The abrasive inlet is automatically sealed by the popup head (#5) when the blaster is pressurized. The air flow into the internal piping pushes the popup head (#5) up against the gasket (#6). See Figure 5.2.

⚠ WARNING

Pinch point hazard. Vessel pressurization will close the popup. Keep hands and fingers away from popup. Disconnect air supply prior to performing popup maintenance.

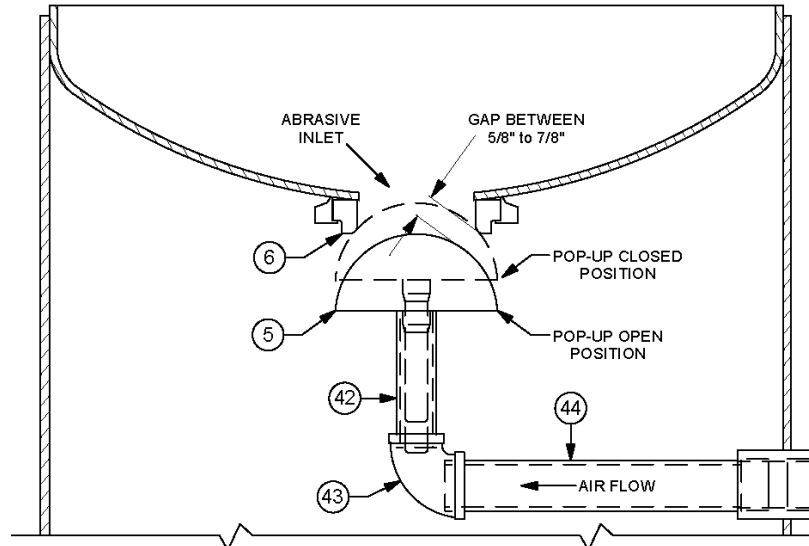


Figure 5.2 – Standard Popup Assembly & Internal Piping

5.2 Air Supply Connection

Air is supplied to the abrasive blaster through a hose connection at the air inlet crowfoot (#2). The air supply hose connected to the abrasive blaster must be same diameter as the air supply piping and rated at a minimum of 175psi operating pressure. See the drawings and parts lists in Section 9.0 and refer to Sections 3.4 and 5.12.

5.3 Air Inlet Ball Valve

The air inlet ball valve (#3) is used to turn on and turn off the air flow to the abrasive blaster. When the inlet ball valve is opened, air will flow into the automatic air valve (#9). In a properly operating Universal Small Pot system the blast vessel (#1) *does not* pressurize when the inlet ball valve is opened.

5.4 Exhaust Valve (depressurize)

The exhaust valve (#4) is a normally open valve that works in conjunction with the automatic air valve (#9) to control both the blast vessel (#1) pressurization and the blast operation. The exhaust valve (#4) closes when it receives air to its signal port. When the G3 deadman trigger (#12) is pulled back, the exhaust valve (#4) closes, sealing the blowdown port, and the automatic air valve (#9) opens pressurizing the abrasive blaster and starting the blast operation. When the G3 deadman trigger (#12) is released, the exhaust valve (#4) opens and the automatic air valve (#9) closes, depressurizing the abrasive blaster and stopping the blast operation. See Section 9.6. The abrasive blaster must be depressurized before filling with abrasive or before performing any maintenance.

⚠ DANGER

The Universal Small Pot is a pressurized vessel. Propelled objects will cause serious injury or death. Read and follow all pre-operation and operating procedures prior to pressurizing the abrasive blaster. See Sections 6.0 and 7.0.

WARNING

Airborne particles and loud noise hazards from blowdown exhaust air can cause serious injury and loss of hearing. Wear approved eye and ear protection. Stay clear of blowdown air path. DO NOT place hands or other body parts in the blowdown air path. Make sure no personnel are in the blowdown air path.

NOTICE

Air leaking from the VBS Lite while the G3 deadman is activated and the vessel is pressurized indicates that the exhaust valve (#4) diaphragm is damaged and must be replaced immediately. Irreparable damage to the exhaust valve body will result in continuous operation with a defective diaphragm.

Note: All Schmidt® Universal Small Pots are equipped with the VBS® Lite (Volumetric Blowdown Suppression System) which reduces the noise level and floor damage caused by the blowdown exhaust flow. Refer to Section 5.16.

5.5 Automatic Air Valve (blast vessel pressurization)

The automatic air valve (#9) is a normally closed valve that works in conjunction with the exhaust valve (#4) to control both the blast vessel (#1) pressurization and the blast operation. The automatic air valve (#9) opens when it receives air to its signal port. When the G3 deadman trigger (#12) is pulled back, the exhaust valve (#4) closes, sealing the blowdown port, and the automatic air valve (#9) opens pressurizing the abrasive blaster and starting the blast operation. When the G3 deadman trigger (#12) is released, the exhaust valve (#4) opens and the automatic air valve (#9) closes depressurizing the abrasive blaster and stopping the blast operation. See Section 9.5. The abrasive blaster (#1) remains depressurized when the automatic air valve (#9) is closed. The abrasive blaster must be depressurized before filling with abrasive or before performing any maintenance.

DANGER

The Universal Small Pot is a pressurized vessel. Propelled objects will cause serious injury or death. Read and follow all pre-operation and operating procedures prior to pressurizing the abrasive blaster. See Sections 6.0 and 7.0.

5.6 Choke (ball) Valve

The choke ball valve (#13) is used to clear any trash that may get into the blast vessel and block the PicoValve™ (#14) orifice. Whenever trash (paint chips, cigarette butts, etc.) blocks the PicoValve orifice the procedure is to fully open the PicoValve by backing out the knob, then press down the G3 deadman trigger (#12) to begin blasting. While blasting, have an assistant close the choke valve (#13) completely for about one second. This creates differential pressure at the PicoValve (high pressure above; low pressure below). The higher pressure from the blast vessel (#1) should be enough to force the trash through the PicoValve orifice. Keep the choke valve fully open at all other times while blasting to minimize excess PicoValve wear.

DANGER

Do not aim blast nozzle towards yourself or any person. System malfunction can cause accidental start up and result in injury to personnel. See Section 11.2.3(7).

A secondary purpose of the choke ball valve (#13) is as a manual shut off valve for the blast air supply. When the choke valve (#13) is closed it will shut off the blast air supply to the blast outlet.

NOTICE

See Section 11.3.2 for further safety information regarding the choke procedure.

5.7 PicoValve™ (abrasive metering valve)

The PicoValve (#14) is used to control (meter) abrasive flow by use of an adjustable orifice. The size of this orifice is controlled by turning the knob at the top of the PicoValve. Turning the knob clockwise reduces the orifice size which decreases abrasive flow. Turning the knob counterclockwise increases the orifice size which will increase the abrasive flow to the blast nozzle (#11). Adjustments to the abrasive flow should be made by turning the knob a little at a time. Evaluate the adjustment by starting the blast for a brief period to determine if further adjustment is needed. The PicoValve (#14) has an orifice indicator on the body to use in reference to the amount the orifice is open. The PicoValve has a dual cleanout ports used to purge trash that blocks abrasive flow. This is done by removing the clean out plugs and pressing down the G3 deadman trigger (#12). The blast air flow purges trash through the clean out ports (see Section 11.3.2). The cleanout plugs are then reinstalled for operation. See Section 9.4

⚠ WARNING

Airborne particles and loud noise hazards from purged air can cause serious injury and loss of hearing. Wear approved eye and ear protection. Stay clear of purge air path. DO NOT place hands or other body parts in the purge air path. Make sure no personnel are in the purge air path.

5.8 G3 Deadman Valve (blast control)

The G3 Deadman (#12) valve is part of the system that controls the blast operation. The deadman allows the operator to remotely start and stop the blast operation. The deadman is mounted at the end of the blast hose assembly (#10) near the blast nozzle (#11) to give the operator easy control of the blast operation.

When the pneumatic G3 deadman trigger (#12) is pressed down, air supply from the orange hose of the twinline hose (#15) flows into the black hose. Air flows through the black hose to the signal port of the exhaust valve (#4) to close it and the automatic air valve (#9) to open it and send air into the abrasive blaster and blast air hose. When the G3 deadman trigger (#12) is released, the air signal is cut off causing the exhaust valve (#4) to open and the automatic air valve (#9) to close, depressurizing the abrasive blaster through the VBS® Lite (#45). See Figures 5.1, 5.3, and 5.4 and the drawings in Sections 9.9(a), 9.9(b), and 9.9(c).

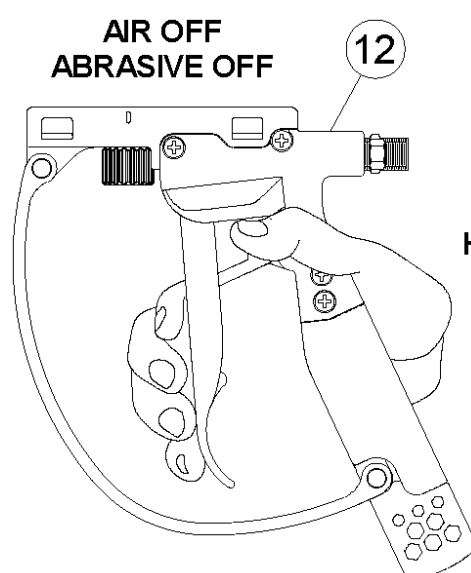


Figure 5.3

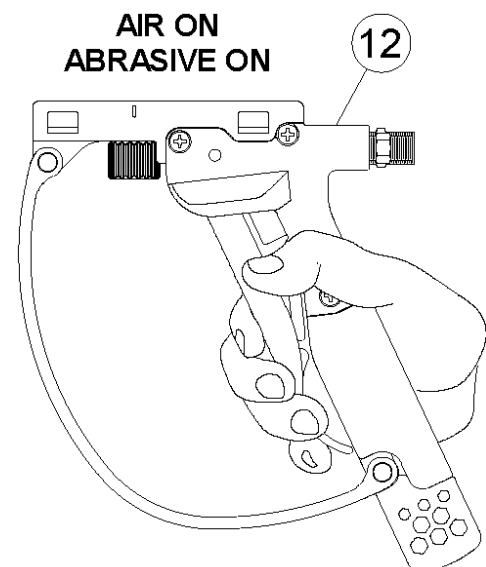


Figure 5.4

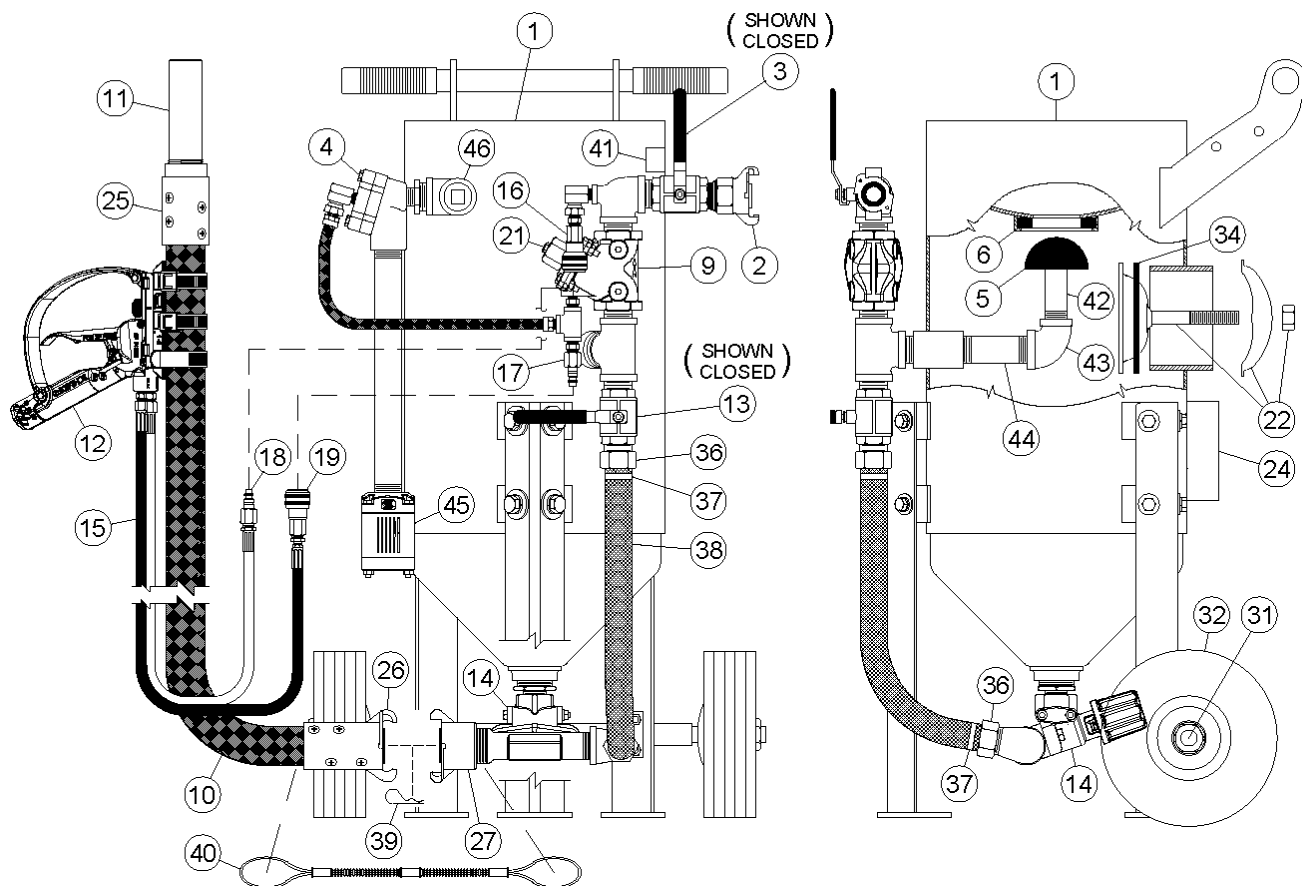


Figure 5.5 – Universal Small Pot with pneumatic blast controls

5.10 Blast Hose

The blast air and abrasive mixture flows from the PicoValve™ (#14) to the blast nozzle (#11) through the blast hose assembly (#10). The typical length of the blast hose is 50ft; however, blast hose extensions can be added to increase length. For higher efficiency keep the blast hose as short as possible. Increased blast hose length causes pressure drop at the blast nozzle which reduces the blast efficiency. For higher efficiency use a blast hose with an inside diameter that is approximately three times the nozzle throat diameter. Keep blast hose as straight as possible. Sharp bends create high wear points. Static electricity is generated by the abrasive flow through the blast hose. To minimize chance of static electrical shock to operating personnel only use anti-static blast hose and/or vacuum hose, properly electrically bond the blast nozzle, blast hose couplings, and the equipment, and properly install an earth ground to the abrasive blaster.

CAUTION

Static electric shock hazard. To minimize chance of static electrical shock to operating personnel only use anti-static blast hose, properly electrically bond the blast nozzle, blast hose couplings, and the equipment, and properly install an earth ground to the abrasive blaster.

Note: To reduce operator fatigue, a blast whip hose can be used along with the blast hose. A whip hose is thinner wall and lighter weight hose. Consult an Authorized Schmidt® distributor.

5.11 Blast Nozzle

The blast nozzle (#11) is an important part of the blast operation since the size of it determines the air flow and abrasive requirement. The amount of air flow and abrasive determine how quick blasting can be done. The larger the nozzle, the more air and abrasive will be needed. The larger the nozzle size the greater the blast productivity. However, for a fixed amount of air supply, increasing the nozzle size will reduce the blast pressure. For optimum performance, the blast pressure must be maintained as high as possible. Therefore, select the nozzle size based on the amount of air available and then adjust the abrasive flow at the PicoValve™ (#14) as needed.

The nozzle size can be identified by the small number molded into the outer nozzle jacket. Or in the case of ceramic nozzles, by measuring the throat diameter (the smallest inside diameter). The throat diameter is measured in sixteenths of an inch; for example, a #5 nozzle has a throat diameter of 5/16". See the tables in Section 13.0 for approximate air and abrasive consumption for each nozzle. **Note:** For the best possible mixture of air to abrasive, the blast hose and piping must be at least three times the size of the blast nozzle.

DANGER

Do not aim blast nozzle towards yourself or any person. System malfunction can cause accidental start up and result in injury to personnel. See Section 11.2.3(7).

5.12 Hose Connection

All air hose, blast hose, and threaded couplings have two pin holes that align when connected. To protect against accidental hose disconnections safety pins must be installed through these holes. As a secondary safety measure, each hose connection should also include a hose whip check that will hold the hose if there is an accidental disconnection. Connect one loop to each side of the connection and stretch out as shown in Figure 5.6 below. All air hose, blast hose, and threaded couplings have a gasket that seals the connection and should be replaced when air is leaking.

WARNING

Failure to install safety pins on all air and blast hose couplings can result in hose disconnects and could result in serious injury or death.

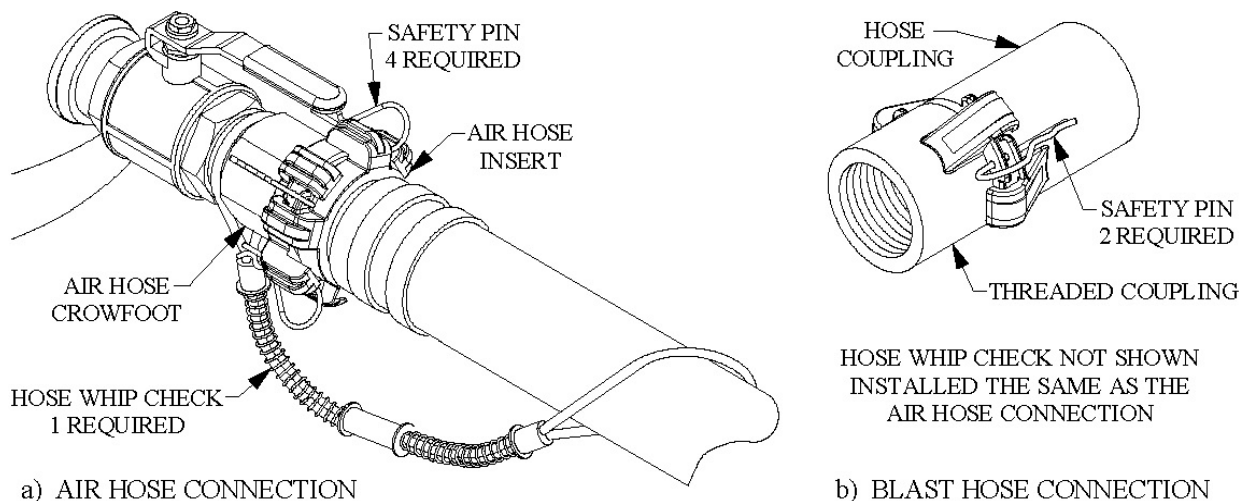


Figure 5.6 – Hose Connection Disconnect Protection

5.16 VBS® Lite (Volumetric Blowdown Suppression System) (patent pending)

The VBS Lite (Volumetric Blowdown Suppression System) (#45) is designed to reduce the noise level and eliminate floor damage caused by the blowdown exhaust air. The VBS Lite (#45) attaches to the end of the pipe below the exhaust valve (#4). The VBS Lite changes the characteristics of the blowdown exhaust air as it flows through. The VBS Lite reduces the noise level of the blowdown air by diffusing and reducing the velocity of the blowdown air and abrasive mixture. The VBS Lite urethane wear pad absorbs the abrasive impact to reduce wear on the internal components. The VBS Lite (#45) has three sides with slots and one side without slots. When installing the VBS Lite, rotate the one side without slots to point towards the blast vessel (#1). See drawing in Section 9.10.

⚠ DANGER

Failure to rotate the VBS Lite (#45) to have the one side without slots pointing towards the pressure vessel (#1) will allow abrasive carryover in the blowdown air to wear away the pressure vessel wall and may lead to pressure vessel rupture causing serious injury or death. See drawing in Section 9.10 for correct orientation.

⚠ WARNING

Airborne particles and loud noise hazards from blowdown exhaust air can cause serious injury and loss of hearing. Wear approved eye and ear protection. Stay clear of exhaust air path. DO NOT place hands or other body parts in the exhaust air path. Make sure no personnel are in the exhaust air path.

NOTICE

Air leaking from the VBS Lite while the G3 deadman is activated and the vessel is pressurized indicates that the exhaust valve (#4) diaphragm is damaged and must be replaced immediately. Irreparable damage to the exhaust valve body will result in continuous operation with a defective diaphragm.

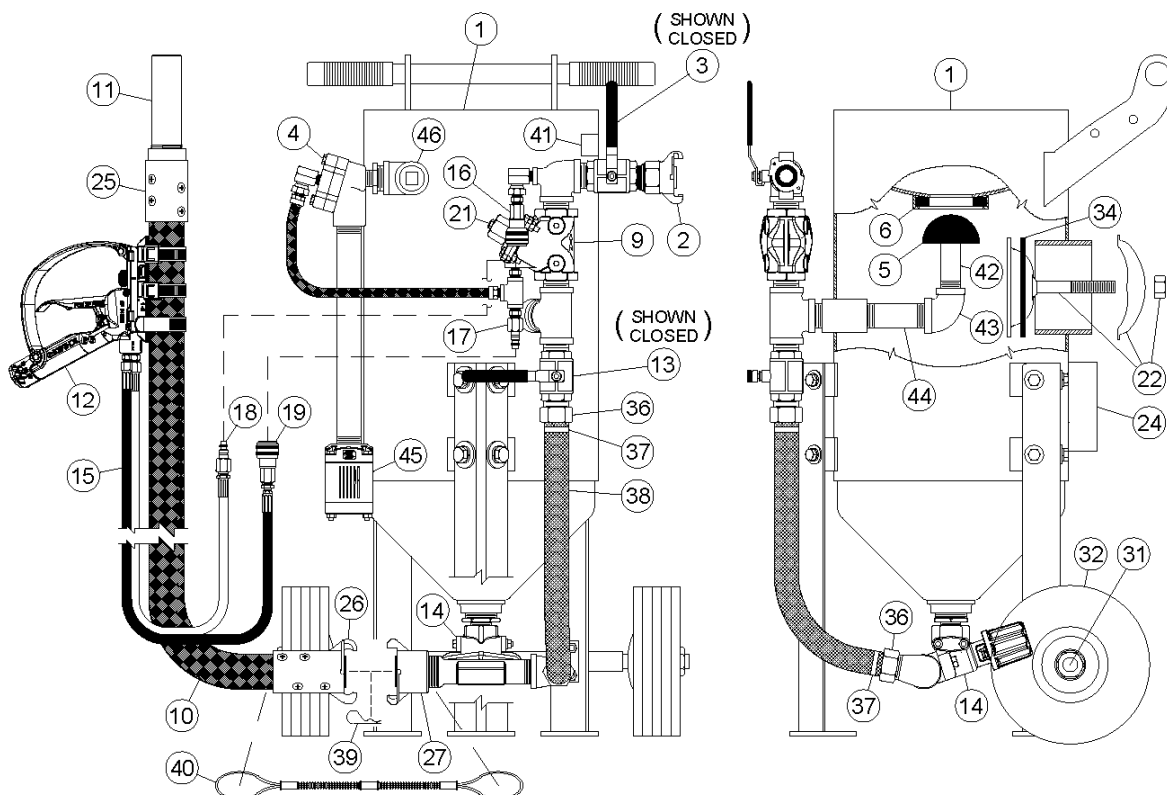


Figure 5.8 – Universal Small Pot with the VBS Lite

6.0 Pre-operation Procedures

DANGER

Failure to follow the procedures below could result in serious injury or death. In addition to these procedures completely read and understand all sections of this *Abrasive Blaster Operation and Maintenance Manual*.

DANGER

The Abrasive Blaster is a pressurized vessel. Propelled objects will cause serious injury or death. Depressurize vessel before performing any maintenance. See Section 6.2.

6.1 Abrasive Blaster Setup Procedure (See Figure 6.2)

- 6.1.1. Confirm the abrasive blaster installation is complete per Section 3.12. Then confirm that the abrasive blaster is properly maintained and inspected as detailed in Section 8.0.
- 6.1.2. Static electricity is generated by the abrasive flow through the blast hose. To minimize chance of static electrical shock to operating personnel only use anti-static blast hose, properly electrically bond the blast nozzle, blast hose couplings, and the equipment, and properly install an earth ground to the abrasive blaster. See Section 5.10.

CAUTION

Static electric shock hazard. To minimize chance of static electrical shock to operating personnel only use anti-static blast hose, properly electrically bond the blast nozzle, blast hose couplings, and the equipment, and properly install an earth ground to the abrasive blaster. See Section 5.10.

- 6.1.3. Do Not operate this equipment without an air pressure relief device in place. The ASME Code requires that all vessels be provided with an air pressure relief device. See Section 3.11.

DANGER

Rupture Hazard. Operating the pressure vessel above the maximum allowable working pressure can result in rupturing the pressure vessel. Install an air pressure relief valve to protect against over pressurization of the blast vessel. See Section 3.11.

- 6.1.4. Make certain that the abrasive blaster is not pressurized. Follow the depressurizing procedure given in Section 6.2.

WARNING

Airborne particles and loud noise hazards from blowdown exhaust air can cause serious injury and loss of hearing. Wear approved eye and ear protection. Stay clear of blowdown air path. DO NOT place hands or other body parts in the blowdown air path. Make sure no personnel are in the blowdown air path.

- 6.1.5. Properly install the handway cover (#22) and gasket (#34). See Section 6.3.
- 6.1.6. Verify that all required personal protective equipment is available for each operator and in good operating condition (safety glasses, safety shoes, ear plugs, gloves, protective clothing, airline filter, respirator, & carbon monoxide monitor). *Critical: Adhere to all local, state, and federal regulations including, but not limited to, OSHA (Occupational Health and Safety Administration). Pay close attention to requirements regarding breathing air quality. When an oil-lubricated air compressor is used, additional requirements for a high temperature alarm and/or a carbon monoxide monitor become necessary. See Sections 3.9 and 3.10.*

⚠ WARNING

Failure to use personal protective equipment could result in serious injury or death.

- 6.1.7. Install the BAABS G3 Swivel Strap Assembly (#12) onto the blast hose assembly (#10) in a comfortable position behind the nozzle holder (#25). Refer to Section 9.9(a). Refer to BAABS® G3 Swivel Strap Assembly manual 7200-372 for setup information.
- 6.1.8. Wire tie the twinline hose (#15) to the blast hose assembly (#10).
- 6.1.9. Screw nozzle (#11) into the nozzle holder (#25) at end of the blast hose assembly (#10).
- 6.1.10. Connect the blast hose coupling (#26) to the threaded coupling (#27) on the abrasive metering valve (#14). Then install safety pins (#39) and a hose whip check (#40) to protect against accidental disconnections during operation. See Sections 5.12 and 8.7.

⚠ WARNING

Failure to install safety pins on all blast hose couplings can result in hose disconnects and could result in serious injury or death. See Sections 5.12 and 8.7.

- 6.1.11. Connect the twinline hose quick disconnects (#18 & #19) to the mating disconnect(s) (#16 & #17) on the abrasive blaster piping.
- 6.1.12. Close the air inlet ball valve (#3).
- 6.1.13. Connect a 175psi rated (minimum) air supply hose to the air inlet crowfoot (#2) and install safety pins (#39) and a hose whip check (#40) to protect against accidental disconnections during operation. See Sections 5.12 and 8.7.

⚠ WARNING

Failure to install safety pins on all air hose couplings can result in hose disconnects and could result in serious injury or death. See Sections 5.12 and 8.7.

6.2 Abrasive Blaster Depressurizing Procedure

The Universal Small Pot is a *depressurized system*; meaning that the blaster will depressurize when the G3 deadman trigger (#12) is released.

- 6.2.1. Release the G3 deadman trigger (#12) to close the automatic air valve (#9) and open the exhaust valve (#4) to depressurize the abrasive blaster. The blast operation will stop.

⚠ WARNING

Airborne particles and loud noise hazards from blowdown exhaust air can cause serious injury and loss of hearing. Wear approved eye and ear protection. Stay clear of blowdown air path. DO NOT place hands or other body parts in the blowdown air path. Make sure no personnel are in the blowdown air path.

6.2.2. The popup head (#5) will fall open when the blast vessel is completely depressurized.

⚠ WARNING

When the popup valve opens after depressurizing, abrasive can be blown out of the blast vessel and into the face and eyes of the operator. Wear OSHA approved safety glasses. See Section 3.10.

6.2.3. Close the air inlet ball valve (#3) to disable the blaster and the deadman blast control. The ball valve (#3) is closed when the handle is fully turned to the position shown in Figure 6.2 (handle perpendicular to body). The handle tab will bottom against the ball valve body in the closed position. **Note:** A faulty ball valve may allow air flow even in the closed position. Confirm air flow is stopped by loosening the twinline connection (#18) to check for air flow. Replace faulty ball valves. See Section 8.0 for inspection and maintenance details.

6.2.4. The exhaust valve (#4) and fittings should be periodically inspected for wear. Refer to Section 8.0 for inspection and maintenance details.

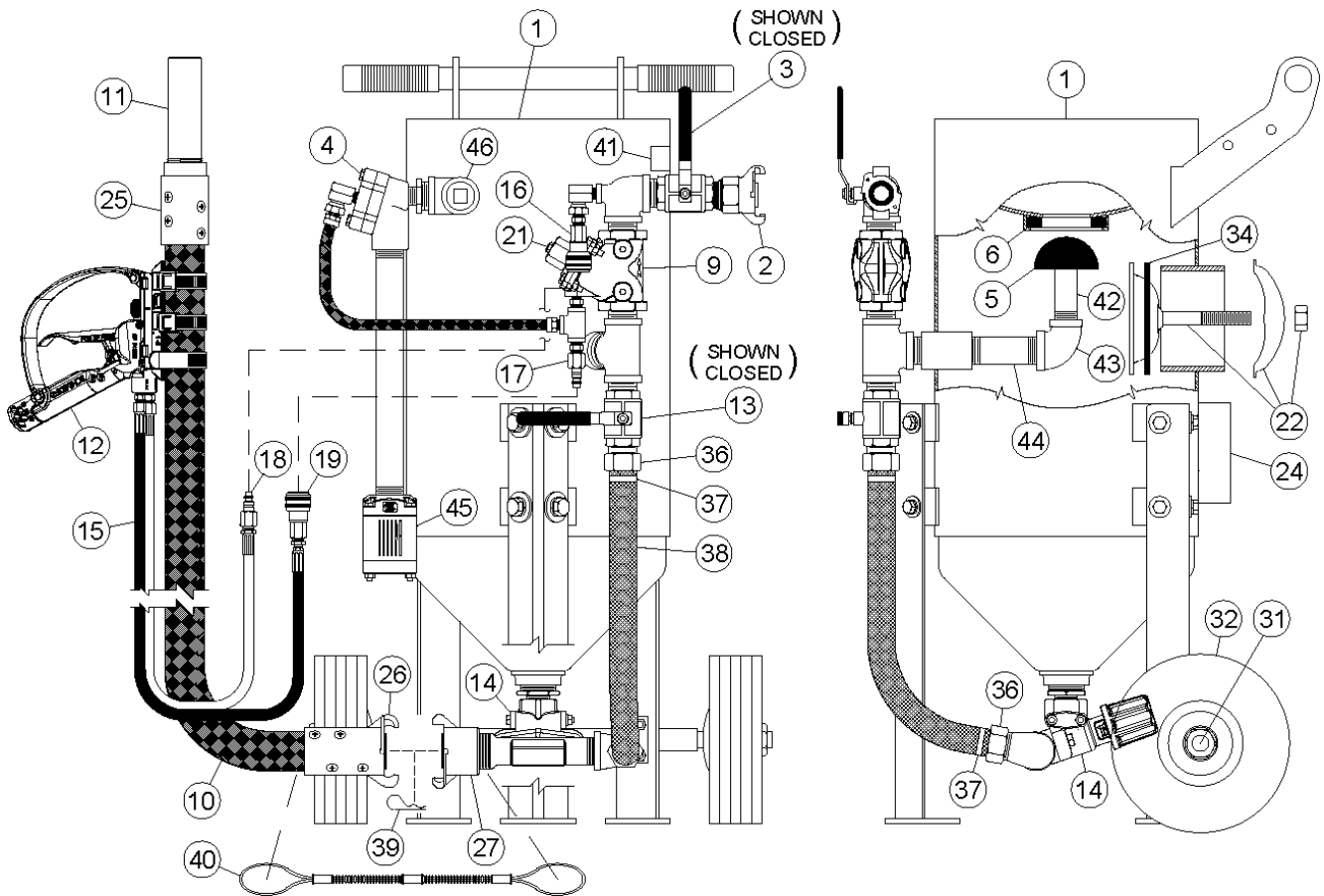


Figure 6.2 Universal Small Pot with pneumatic blast controls

6.3 Handway Cover Installation Procedures (See Figure 6.3(a))

- 6.3.1. Check that the handway cover, crab, bolt, and gasket are dimensionally correct for the size handway weld ring of the pressure vessel.
- a) Measure and write down the inside dimensions' "A" and "B" of the handway weld ring. See Figure 6.3(a).
 - b) Verify the size of the handway assembly by comparing the weld ring measurements from step "a" to the dimensions shown in Table 6.3(c).
 - c) Verify that the dimensions of the cover, crabs, bolts, and gasket match the corresponding dimensions given in Table 6.3(c). **Note:** The actual dimensions may vary by up to 1/4" from those given in Table 6.3(c).
 - d) Replace any component that is not dimensionally correct. Incorrect dimensions indicate that the component is part of a different size handway assembly.



The handway assembly is part of a Pressurized Vessel. Use of incorrect handway components will result in assembly failure. Assembly failure will propel objects causing serious injury or death.

- 6.3.2. Once a month inspect the handway gasket for tears, cracks, or other wear. Replace gasket if damage is found.
- 6.3.3. Once a month inspect the handway weld ring sealing surface inside the vessel. Inspect the handway cover sealing surface. Both surfaces must be smooth.
- 6.3.4. Place the gasket on the handway cover then fit both through the opening.
- 6.3.5. Place the cover and gasket in position against the inside edge of the handway weld ring. Apply a pulling force to hold in position then proceed.
- 6.3.6. Center the gasket on the handway weld ring.
- 6.3.7. Center the handway cover on the gasket.
- 6.3.8. Center the handway crab on the outside weld ring.
- 6.3.9. Slide the handway crab bolt to the inside edge of the slot before tightening. See Figure 6.3(a).
- 6.3.10. When all components are centered and the crab bolt is bottomed in the slot, tighten the nut onto the bolt with a wrench until snug.
- 6.3.11. Only after completing all the pre-operation procedures in Section 6.0 and the abrasive blast vessel is then pressurized, re-tighten the nut with a wrench until snug.
- 6.3.12. Do not over-tighten the crab nut and bolt. Over-tightening could bend the crab out of shape resulting in malfunction of the assembly.
- 6.3.13. Periodically check for leaks.

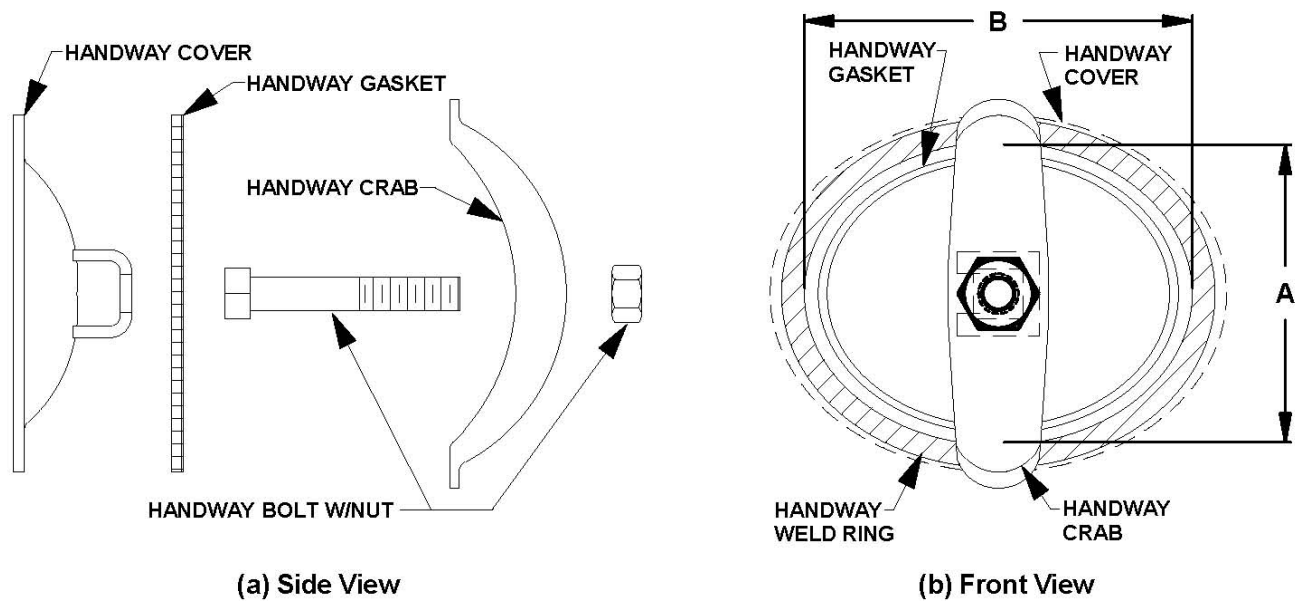


Figure 6.3 (a) – Handway Assembly

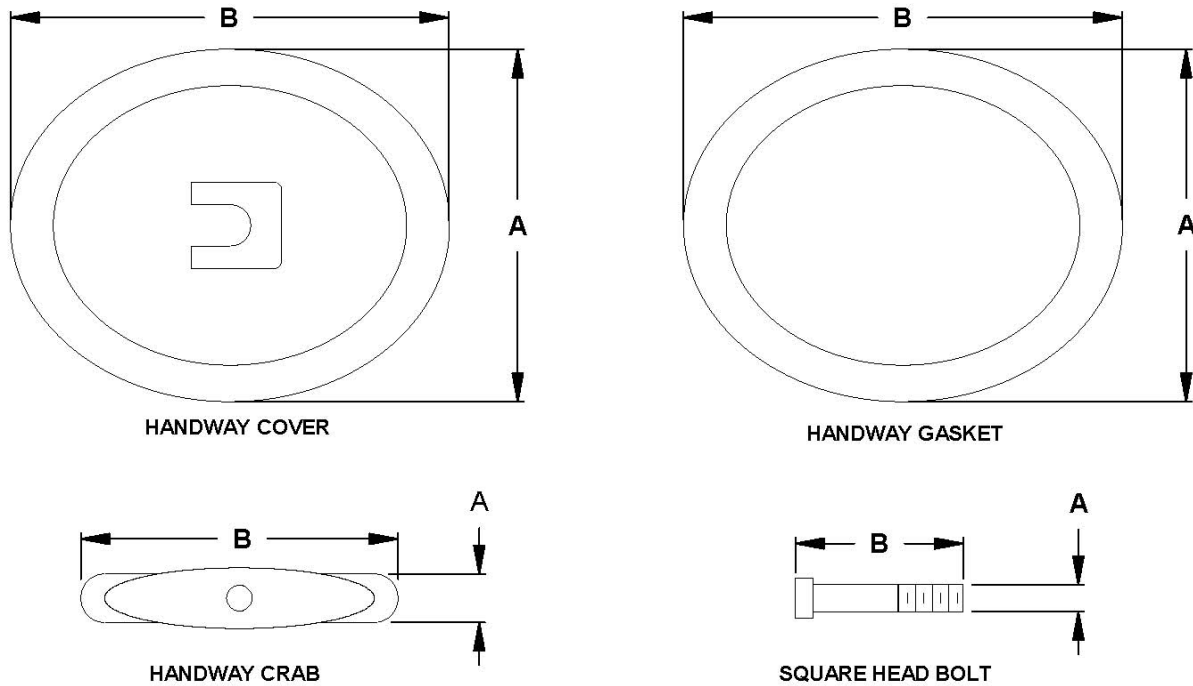


Figure 6.3 (b) – Handway Components

4" x 6" Handway Dimensions		
Component	A	B
Weld Ring	5"	6-11/16"
Handway Cover	5-1/4"	7-9/16"
Handway Gasket	5-5/16"	7-1/4"
Handway Crab	2-5/16"	7-11/16"
Square Head Bolt	7/8"-9 UNC	5-1/2"

Table 6.3 (c) – Handway Component Dimensions

7.0 Operating Instructions

7.1 Filling the Abrasive Blaster with Abrasive

- 7.1.1. The Abrasive blaster must be completely depressurized before filling with abrasive. Follow the depressurizing procedure in Section 6.2. Disable the blaster by closing the air inlet ball valve (#3).

⚠ WARNING

Airborne particles and loud noise hazards from blowdown exhaust air can cause serious injury and loss of hearing. Wear approved eye and ear protection. Stay clear of blowdown air path. DO NOT place hands or other body parts in the blowdown air path. Make sure no personnel are in the blowdown air path.

- 7.1.2. Check that the popup (#5) has dropped open. The open popup indicates that the blast vessel is depressurized. See Figure 7.1.
- 7.1.3. Fill the blaster with dry abrasive through the abrasive inlet (#6). Pass recycled abrasive through a screen to remove trash. Do not over-fill the blast vessel. An excessive amount of abrasive piled above the popup (#5) after the blast vessel is full may prevent the popup from sealing properly.

⚠ WARNING

Pinch point hazard. Vessel pressurization will close the popup. Keep hands and fingers away from popup. Disconnect air supply prior to performing popup maintenance.

- 7.1.4. After completing all the pre-operation procedures in Sections 6.0 and 7.1, pressurize the abrasive blast vessel per Section 7.2 then check the popup for leaks. Periodically check the popup for leaks thereafter.

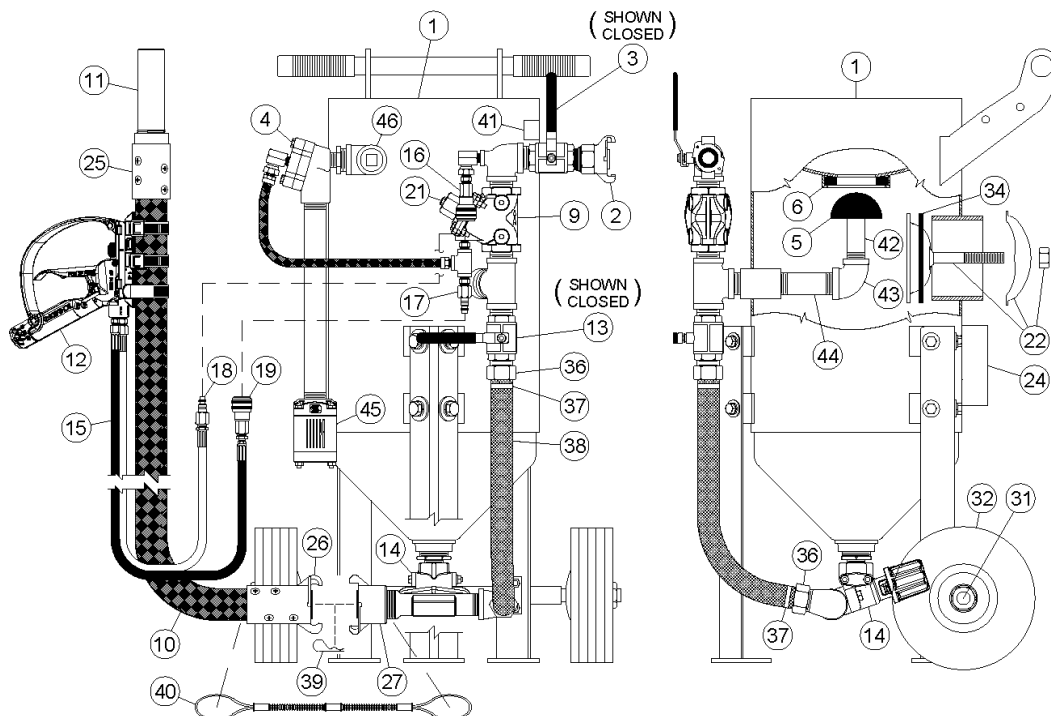


Figure 7.1 – Universal Small Pot with pneumatic blast controls

7.2 Beginning the Blasting Operation (See Figures 7.1 and 7.2)

- 7.2.1. The abrasive blaster must be properly setup, and all operating personnel must be thoroughly trained before beginning the blast operation. All operators must completely read and understand all sections of this manual before beginning the blast operation. See the pre-operation setup procedures given in Section 6.0.
- 7.2.2. Perform the required inspections and maintenance before beginning the blast operation. See the instructions given in Section 8.0.

DANGER

The abrasive blaster is a Pressurized Vessel. Propelled objects will cause serious injury or death. Depressurize vessel before performing any maintenance. See Section 6.2.

- 7.2.4. Open the choke ball valve (#13). Always leave the choke ball valve completely open while blasting. Close the choke ball valve only for the “choke” procedure (see Section 11.3.2.). Do Not blast for long periods with the choke ball valve partially closed since this will cause excessive wear in the PicoValve™ (#14).
- 7.2.5. For initial startup, the PicoValve (#14) should only be partially open. Turn the valve knob clockwise to completely close, then turn counterclockwise about three turns to partially open. The best setting for the valve varies depending on abrasive type, blast pressure, and nozzle size; therefore, it may take more than one adjustment to achieve the desired air/abrasive mixture. Further adjustment can be made later as needed. See Figure 7.2.

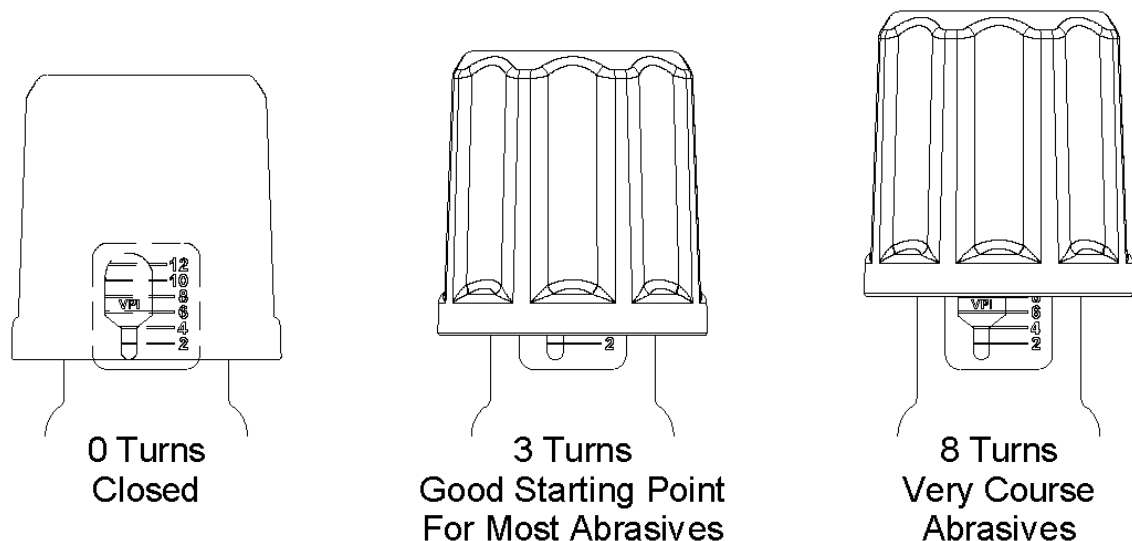


Figure 7.2 – PicoValve VPI Detail

- 7.2.6. Slowly open the inlet ball valve (#3). This will supply air to the automatic air valve (#9) and the deadman controls (#12 & #15). The blast vessel (#1) will not pressurize.
- 7.2.8. The following steps are for abrasive flow setting which may require several adjustments and testing of the blast flow. It is recommended that testing of the blast be made on a test piece so not to damage anything of value.

- 7.2.9. Securely grip the G3 deadman (#12). The blast hose (#10) should be on the same side as the hand that is gripping the G3 deadman (#12), such as between the arm and torso. Pull the blast hose as close to the body as comfortably possible. This will make managing the thrust of the blast hose easier. To begin blasting, push the safety flap down and out of the trigger safety lock position with the thumb and pull back on the deadman trigger with the fingers. The exhaust valve (#4) will close, and the automatic air valve (#9) will open to pressurize the abrasive blaster. Air and blast abrasive will flow into the blast hose (#10) and out through the blast nozzle (#11).



Do Not aim the blast nozzle towards yourself or any person. A system malfunction or a blocked blast nozzle that clears can trigger accidental start up resulting in injury to personnel. See Section 11.2.3(7).

- 7.2.10 Observe the blast stream and the coating removal rate. A bluish color in the blast stream indicates a good abrasive to air mixture. Release the deadman trigger to stop blasting.
- 7.2.11. If necessary, adjust the abrasive flow with the knob on the PicoValve™ (#14). Turn clockwise for less abrasive flow or turn counterclockwise for more abrasive. Due to the length of the blast hose, there will be a slight delay in control of the abrasive flow at the nozzle; therefore, allow a few seconds before adjusting further.
- 7.2.12. Note the orifice indicator (VPI) on the side of the PicoValve (#14) body to view the knob position relative to the abrasive flow. The VPI position can be used as reference when changing nozzle size or abrasive for different applications. See Figure 7.2.
- 7.2.13. Re-test the blast air and abrasive mixture again on a test piece to determine if further adjustment is needed.
- 7.2.14. At initial blasting have an assistant check the popup, handway, hoses, and piping for leaks while the blaster is pressurized. Periodically check for leaks thereafter.
- 7.2.15. Release the G3 deadman trigger (#12) to stop blasting. The abrasive blaster will depressurize.



Airborne particles and loud noise hazards from blowdown exhaust air can cause serious injury and loss of hearing. Wear approved eye and ear protection. Stay clear of blowdown air path. DO NOT place hands or other body parts in the blowdown air path. Make sure no personnel are in the blowdown air path.

7.3 Ending the Blast Operation (See Figure 7.1)

- 7.3.1. Close the air inlet ball valve (#3). The ball valve is closed when the handle is fully turned to the position shown in Figure 7.1 (handle perpendicular to body). The handle tab will bottom against the ball valve body in the closed position.

CAUTION

Do not turn off the air compressor and allow the abrasive blaster air pressure to back flow through the air supply system. Back flow will carry abrasive into the abrasive blaster piping and contaminate the controls.

- 7.3.3. Completely depressurize the abrasive blast vessel (#1). Universal Small Pots automatically depressurize when the G3 deadman trigger (#12) is released to stop blasting. See Section 6.2 for blowdown procedure.

WARNING

Airborne particles and loud noise hazard from the blowdown exhaust air can cause serious injury and loss of hearing. Wear approved eye and ear protection. Stay clear of blowdown air path. DO NOT place hands or other body parts in the blowdown air path. Make sure no personnel are in the blowdown air path.

- 7.3.4. For extended periods of non-usage remove remaining blast abrasive from blast vessel (#1) to minimize moisture contamination. Replace lid to prevent debris from entering blast vessel.

CAUTION

Steel abrasive left inside the blast vessel can be contaminated by moisture and solidify inside causing costly damage.

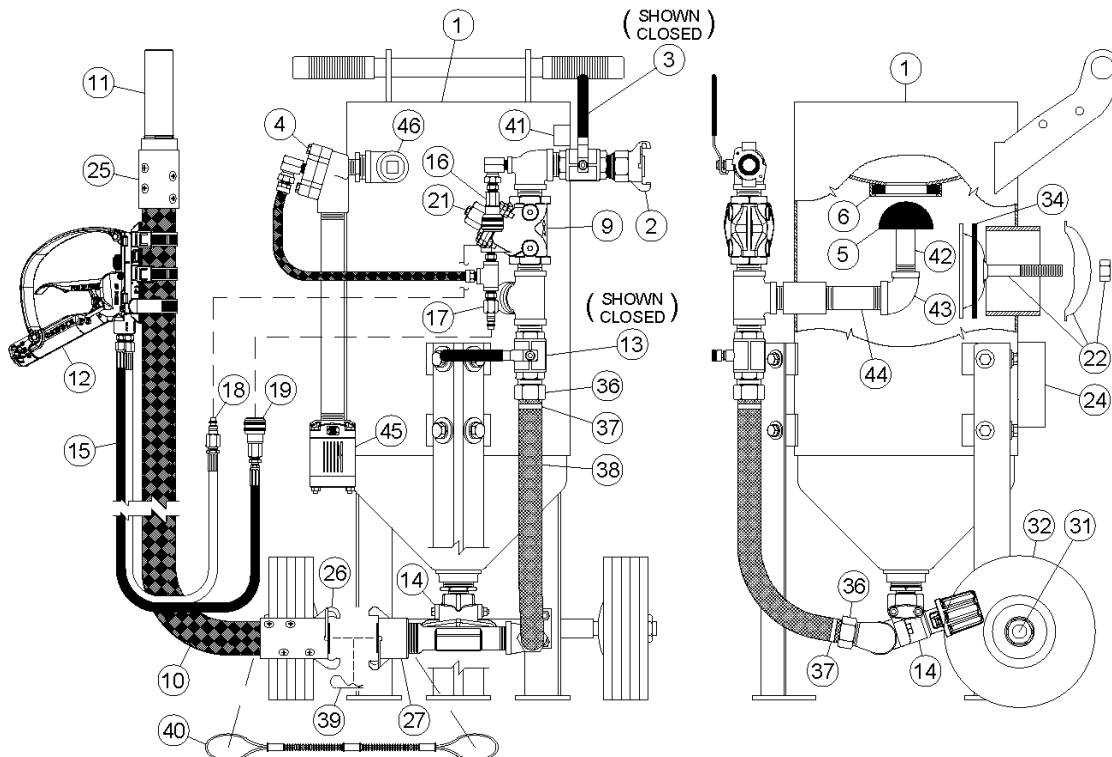


Figure 7.1 – Universal Small Pot with pneumatic blast controls

8.0 Maintenance and Inspection Instructions

DANGER

The Universal Small Pot is a Pressurized Vessel. Propelled objects will cause serious injury or death. Depressurize vessel before performing any maintenance. See Section 6.2.

WARNING

For proper operation, maintenance should be performed with the assistance of a qualified technician.

- 8.1. **Blaster Pressure Vessel:** The ASME Code is a standard covering materials, design, fabrication, and installation. Vessel integrity after purchase is the responsibility of the owner and/or user. At intervals required by state law and/or local authorities, the vessel should be subjected to a hydrostatic test as described in the ASME Code, Section VIII, Division 1. Do Not subject the abrasive blaster pressure vessel to a pneumatic proof test exceeding the maximum allowable working pressure. In no case should the hydrostatic test pressure exceed 1.3 times the maximum allowable working pressure (MAWP) shown on the pressure vessel nameplate (#24). Thoroughly clean and dry the vessel before re-assembly. Moisture or debris left in vessel can cause equipment malfunction.
- 8.2. **Blaster Pressure Vessel:** Any damage to an abrasive blaster can make it unsafe. Inspect the exterior of the abrasive blast vessel weekly for corrosion, pitting, or other damage (i.e., dents, gouges, or bulges). Immediately remove damaged vessel from service and have it inspected and/or repaired by a qualified facility. Contact Axxiom Manufacturing, Inc. for support.
- 8.3. **Blaster Pressure Vessel:** The interior condition of the abrasive blast vessel (#1) should be inspected quarterly. Pitting caused by corrosion will reduce the wall thickness of the vessel. If excessive corrosion is found, have the abrasive blast vessel inspected by a qualified facility. Contact Axxiom Manufacturing, Inc. for technical support. Refer to the ASME Data Report for the vessel minimum thickness.

Check the pressure vessel internal piping for corrosion, cracks, wear, holes, or any other damage. Repair or replace damaged components. See Figure 8.1 and Section 9.11.
- 8.4. **Popup Assembly:** The popup alignment and operation are tested by the manufacturer, however vibration and creeping during shipment may cause the internal popup support piping to shift resulting in misalignment. Check the popup gap and alignment prior to initial usage and weekly thereafter. Inspect the popup as follows:
 - a) Depressurize the abrasive blaster per Section 6.2.
 - b) Disconnect air supply hose from the crowfoot (#2).
 - c) Inspect the popup gasket (#6) and popup head (#5) sealing surfaces for wear or deformations. Replace either if necessary.
 - d) Check that the popup is centered within the gasket opening. If necessary, use a pry bar as a lever between the popup and gasket to deflect the internal support piping and shift the popup to the center of the gasket opening.
 - e) Check the popup gap (distance between the popup surface and the gasket). It should be between 5/8" and 7/8". See Figure 8.1. An excessive gap is created by a vertical nipple that is too short. An excessive gap will expose the top of the vertical nipple to abrasive when the popup closes which could result in premature wear to the popup.
 - f) After checking the alignment and gap, the blast vessel can be re-pressurized and the popup is then checked for leaks. If a leak is present, repeat the above steps to isolate the problem.

WARNING

Pinch point hazard. Vessel pressurization will close the popup. Keep hands and fingers away from popup. Disconnect air supply prior to performing popup maintenance.

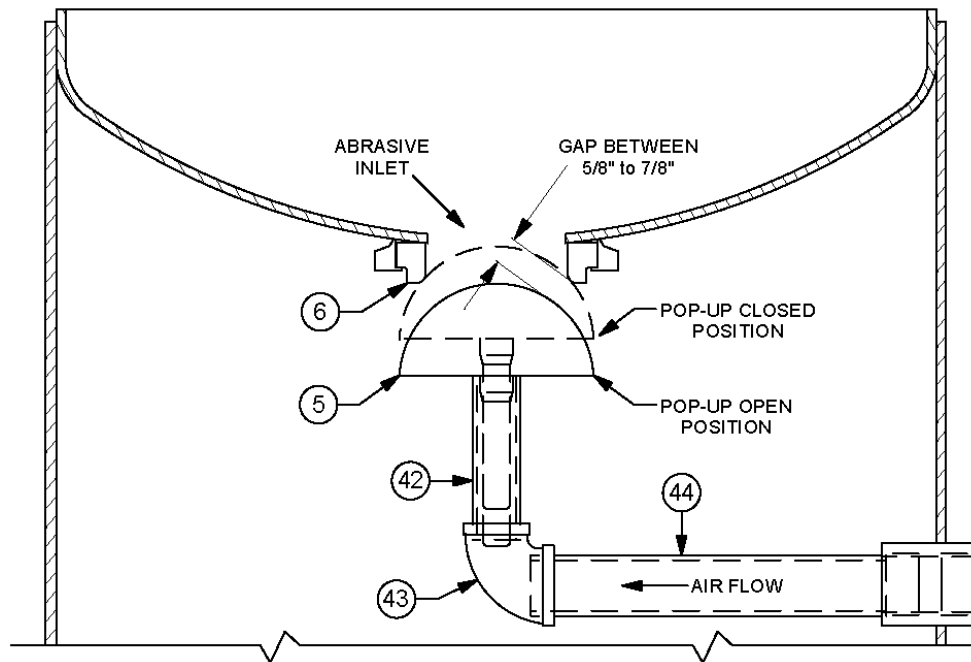


Figure 8.1 – Standard Popup Assembly and Internal Piping

- 8.6. **Blast and Air Hoses, Piping, Pipe Fittings, and Wires:** All air hoses, blast hoses, control hoses, pipe, pipe fittings, and wires are wear items on any abrasive blaster. These components should be inspected daily for air leaks, cracks, holes, dry rotting, cuts, or any other damage. Repair or replace any components that show any signs of wear or damage.

⚠ DANGER

Damaged hoses, piping, pipe fittings or wires can cause system malfunctions and can result in serious injury or death to operating personnel.

Blast hoses are a high wear component of the abrasive blast system. Sharp bends in the blast hose create high wear points resulting in soft spots where the blast hose wall has thinned. These areas can rupture while blasting. Check the full length of the blast hose assembly for soft spots caused by wear. To protect against serious injury to personnel replace blast hoses with soft spots. **Note:** Static electricity is generated by the abrasive flow through the blast hose. To protect against static electrical shock to operating personnel only use anti-static blast hose and properly ground the abrasive blaster.

⚠ WARNING

Worn blast hose assemblies can rupture while blasting and the resulting abrasive blast stream can cause serious personal injury.

⚠ WARNING

Longer blast hoses require longer time to dissipate the blast stream when the deadman is released to end the blast operation. This extended dissipation time increases the risk of injury if there is an accidental loss of control of the blast hose.

⚠ CAUTION

Static electric shock hazard. To minimize chance of static electrical shock to operating personnel only use anti-static blast hose, properly electrically bond the blast nozzle, blast hose couplings, and the equipment, and properly install an earth ground to the abrasive blaster. See Section 5.10.

- 8.7. **Blast and Air Hose Couplings:** All air hose, blast hose, and threaded couplings have two pin holes that align when connected. To protect against accidental hose disconnections safety pins must be installed through these holes. Each hose connection must also include a hose whip check that will hold the hose if there is an accidental disconnection. Connect one loop to each side of the connection and stretch out as shown in Figure 8.2 below. Check hose connections daily and replace missing or damaged pins and whip checks.

⚠ WARNING

Failure to install safety pins on all air and blast hose couplings can result in hose disconnects and could result in serious injury or death.

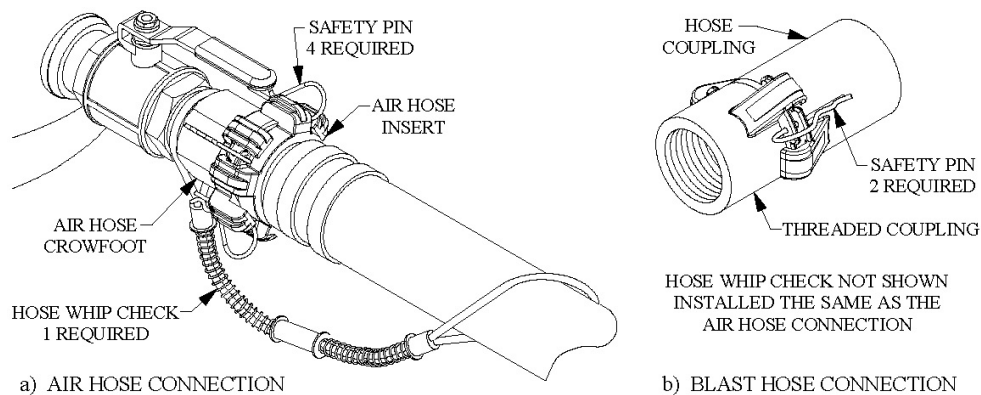


Figure 8.2 – Hose Connection Disconnect Protection

- 8.8. **Blast and Air Hose Gaskets:** All air hose, blast hose, and threaded couplings have gaskets that seal the connection. To protect against loss of air pressure and/or premature abrasive wear replace these gaskets when leaks are found. Inspect the couplings daily for leaks and wear. Replace gaskets when visible wear or leaks are found. When installing or replacing hose couplings, cut the hose end square for secure fit (see Figure 8.3). To ensure proper coupling connection always use fittings that are the same brand. See the drawings and part lists in Section 9.0.

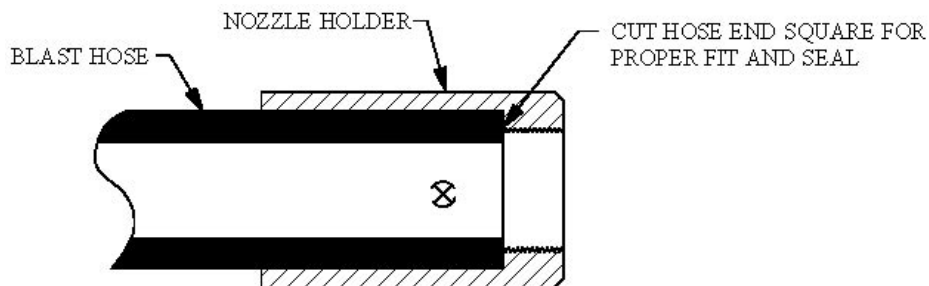


Figure 8.3 – Hose End Fit up

- 8.9. **Blast Nozzle:** Remove the blast nozzle daily and check the jacket and thread condition. Check nozzle throat diameter. An over-sized throat diameter reduces blast efficiency. Replace the blast nozzle if worn or damaged.

⚠ DANGER

Confirm the air in the blast hose has dissipated before removing the blast nozzle. Squeeze or step on the blast hose. Firmness or stiffness indicates that the blast hose is pressurized. Do Not attempt to remove the blast nozzle. Allow the air to dissipate or manually dissipate before proceeding. See Section 11.2.3(6).

- 8.10. **Valves:** PicoValve, automatic air valve, and deadman valves should be disassembled and inspected quarterly, or more frequently if heavily used. Ball valves should open and close without difficulty and should not leak air. Repair or replace any component that shows signs of damage. Replace parts as needed with Schmidt® original factory replacement parts furnished by an authorized Schmidt distributor. Refer to valve drawings in Section 9.0 and specific valve maintenance manual.

Note: Refer to manuals 7200-292 for servicing the PicoValve™
7200-372 for servicing the BAABS® G3 Swivel Strap Assembly

⚠ DANGER

Depressurize vessel before performing any maintenance. See Section 6.2. Removing components with the abrasive blaster pressurized will result in serious injury or death.

⚠ WARNING

Use of replacement components that are not Schmidt® original factory replacement parts may result in equipment failure which can result in serious personal injury.

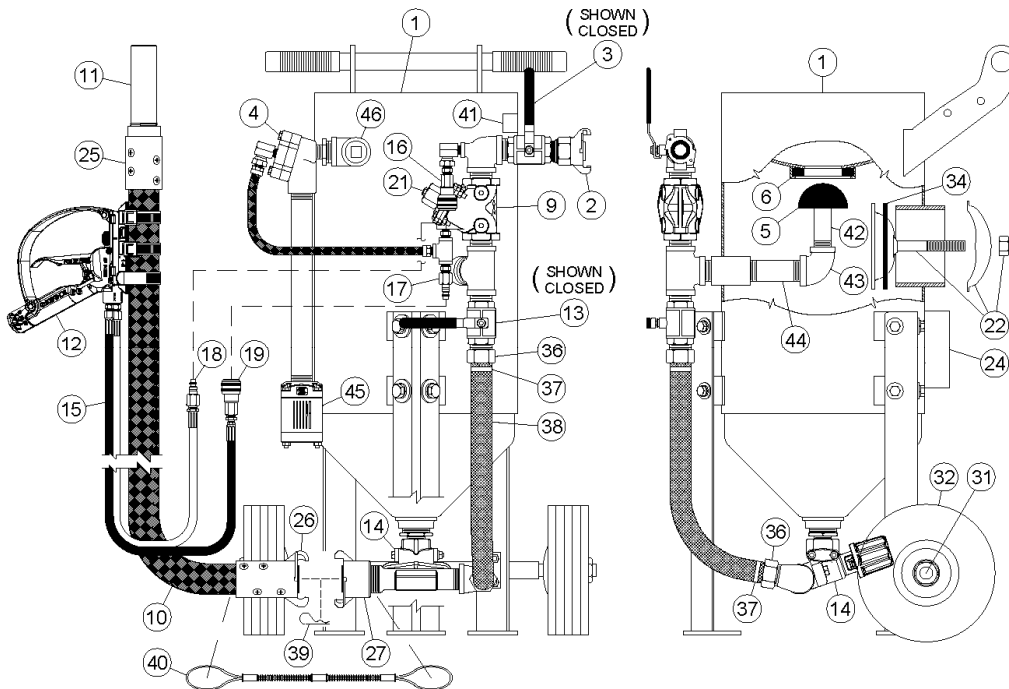


Figure 8.4 – Universal Small Pot with pneumatic blast controls

- 8.11. **Exhaust Valve:** Check daily for air leaks from the VBS Lite with the blast activated. Abrasive carry-over will thin and eventually wear a hole through the exhaust valve (#4) diaphragm. Excessive thinning will cause an irregular surface and prevent the diaphragm from sealing the exhaust flow and result in air leaks and equipment malfunction. The abrasive carry-over will also wear the exhaust valve body and the pipe fittings upstream. These fittings are the 1" x close blowdown flow control nipple (#46), 1" tee, and the 1" pipe plug (see Figure 8.4). Depressurize the abrasive blaster per Section 6.2 and check the diaphragm condition monthly. Replace as needed. See drawing in Section 9.6.

NOTICE

Air leaking from the VBS Lite while the G3 deadman is activated and the vessel is pressurized indicates that the exhaust valve (#4) diaphragm is damaged and must be replaced immediately. Irreparable damage to the exhaust valve body will result in continuous operation with a defective diaphragm.

- 8.12 **VBS® Lite Blowdown System:** Remove monthly and check for internal wear of components. Replace worn components as needed. See drawing in Section 9.10.
- 8.13 **PPE:** Check daily to verify that all personal protective equipment is available for each blast operator. Check daily to verify that all personal protective equipment is in good operating condition. Consult the operating and maintenance instructions provided by the manufacturer of each PPE item. See Section 3.10 and reference OSHA 29 CFR 1910 Subpart I.



Failure to use personal protective equipment could result in serious injury or death.

- 8.14. **Warning Decals:** Check monthly to verify that all the warning decals are in position and legible. See Section 0.0 for full descriptions and locations.



Failure to maintain warning decals risks the possibility of not alerting the abrasive blaster operator to potential dangers which can result in serious injury or death. See Section 0.0.

- 8.15. **Handway Assembly:** Refer to Section 6.3 for installation and inspection procedures.

8.17. *Maintenance Schedule Quick Reference Chart*

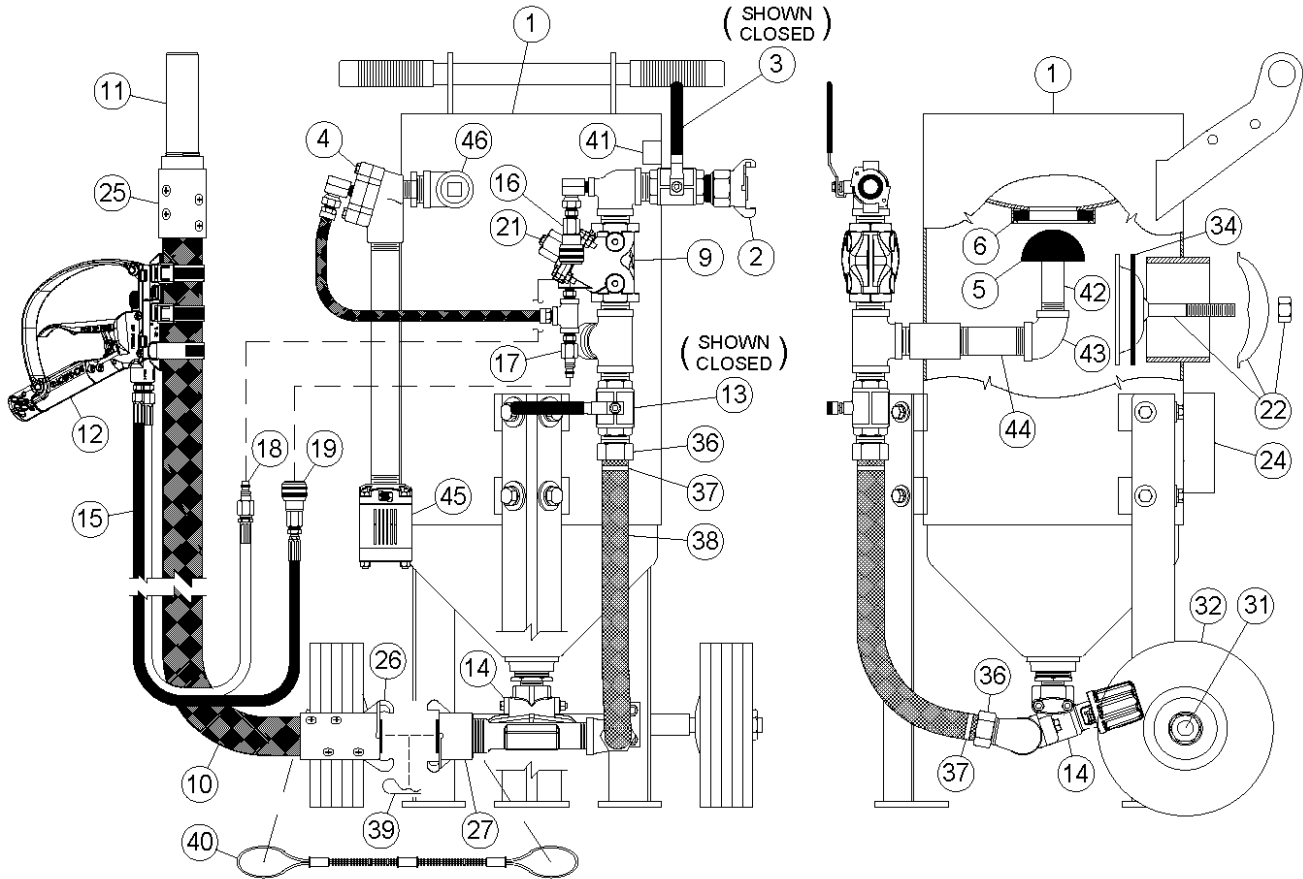
Note: The below schedule is the minimum requirements for inspection and maintenance; however, the equipment should be inspected and serviced immediately if abnormal operation is detected.

SMALL POT ABRASIVE BLASTER MAINTENANCE SCHEDULE					
Item	Maintenance Required	Daily	Weekly	Monthly	Quarterly
Blaster Vessel	Hydrostatic Test See Section 8.1	As required by state law and/or local authorities			
Blaster Vessel	Check for exterior damage (corrosion, dents, bulges). See Section 8.2		X		
Blaster Vessel	Check for interior wear, corrosion, & pitting. Check internal piping for wear or damage. See Section 8.3				X
Popup	Check sealing surfaces, alignment and gasket to popup gap. See Section 8.4		X		
Blast & Air Hoses	Check air & blast hoses for soft spots, wear, cracks, or air leaks See Section 8.6	X			
Remote Control Hoses	Check control air hoses for soft spots, wear, cracks, or air leaks See Section 8.6	X			
Blaster Piping & Pipe Fittings	Check pipe & pipe fittings for wear, cracks, or air leaks See Section 8.6	X			
Blast & Air Hose Couplings	Check for safety pins and whip checks See Section 8.7	X			
Hose Coupling Gaskets	Check for leaks from the air, blast, and threaded hose coupling gaskets See Section 8.8	X			
Blast Nozzle	Check blast nozzle threads and jacket for wear, damage, or air leaks. See Section 8.9	X			
Valves	Disassemble, inspect, and lubricate. Check operation. See Section 8.10				X
Exhaust Valve	Check diaphragm for wear or thinning. Check body, pipe tee, plug, and nipple for wear. See Sections 8.11 and 9.6.	X			
VBS® Lite System	Check VBS Lite internal components for wear. See Sections 8.12 and 9.10.			X	
Personal Protective Equipment	Check for presence and condition of all personal protective equipment. See Sections 3.10 and 8.13.	X			
Warning Decals	Check presence and condition of warning decals. See Sections 0.0 and 8.14			X	
Handway Assembly	Check condition of gasket and sealing surfaces See Sections 6.3 and 8.15.			X	

9.0 Drawings and Parts Lists

The following pages contain drawings representing typical blast control systems and components. To ensure the proper operation of the blast system only install Schmidt® original factory replacement parts furnished by an authorized Schmidt distributor. See Section 1.39 and Section 12.2.12.

9.1 Universal Small Pot with Pneumatic Control (1.5 cu. ft.)

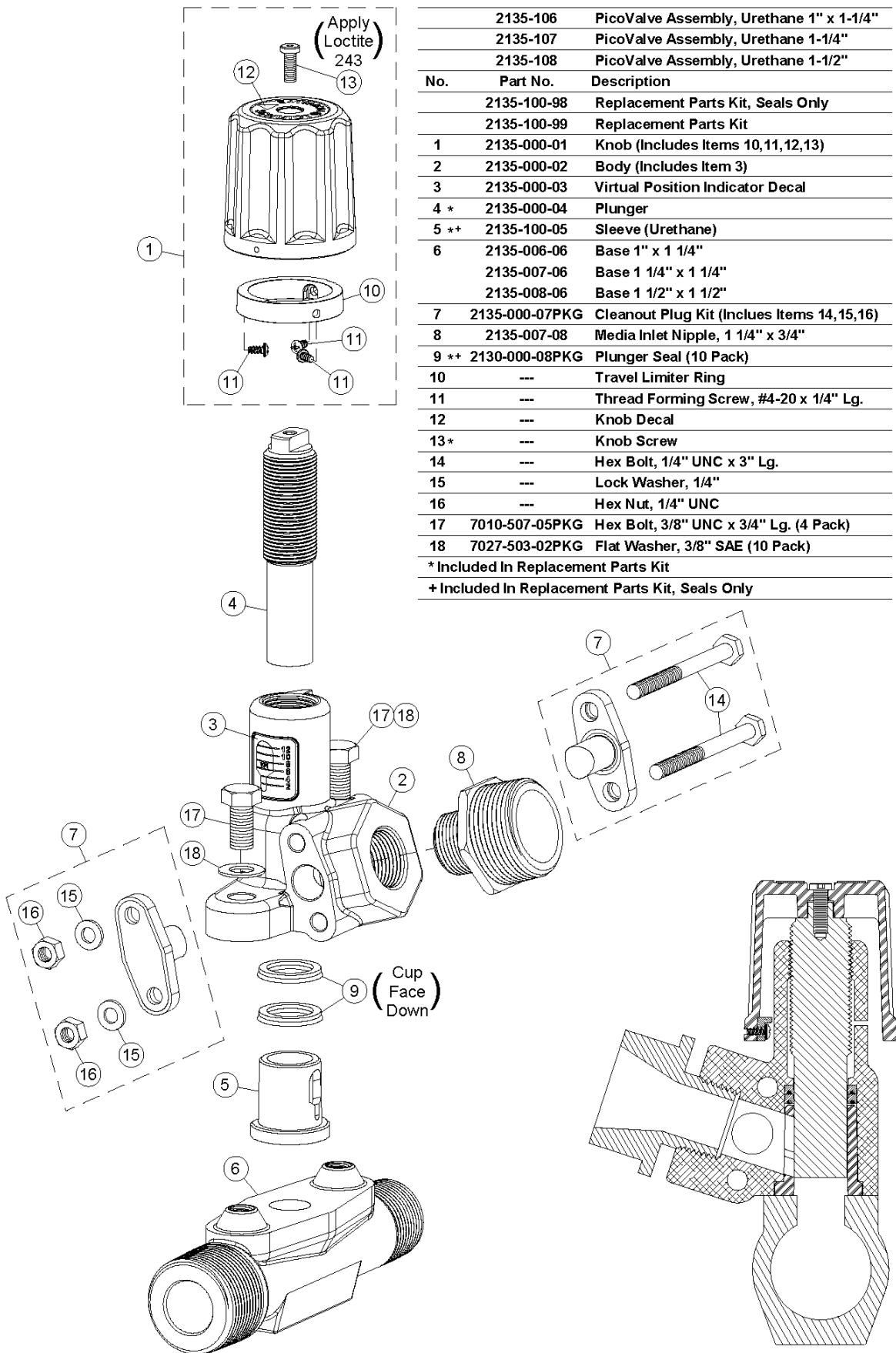


1" Universal Small Pot Piping

No.	Part. No.	Description
1	1031-001-01	1.5 cu.ft Vessel Fab 175 PSI
2	4208-106	Crowfoot, 1" 2-Lug MNPT With Gasket
3	2401-506	Air Inlet Ball Valve, 1" Full Port
4	2227-004	Exhaust Valve, 1/2" (See Section 9.6)
5	2100-000	Pop-Up Head, 1 Bag
6	2100-001	Pop-Up Gasket, 1 Bag
9	2123-106	Auto Air Valve, 1" Normally Closed (See Section 9.5)
10	4104-XXX-XX	Blast Hose Assembly (Specify Size)
11	500X-XXX	Blast Nozzle (Specify Size)
12	4501-01P	G3 Swivel Hose Adapter Package (Pneu) (See Section 9.9(a))
13	2401-506	Choke Ball Valve, 1" Full Port
14	2135-106	PicoValve™, 1" x 1 1/4" (See Section 9.4)
15	4100-301	Twinline Hose Assembly, 27.5 ft
16	4224-301-02	Female Quick Connect, 1/4"
17	4224-300-02	Male Quick Connect, 1/4"
18	4224-300-02	Male Quick Connect, 1/4"
19	4224-301-02	Female Quick Connect, 1/4"
21	2014-300	Breather Vent, 1/8"
22	7000-006-11	Handway Crab Assembly, 4" x 6"
24	-----	Pressure Vessel Nameplate

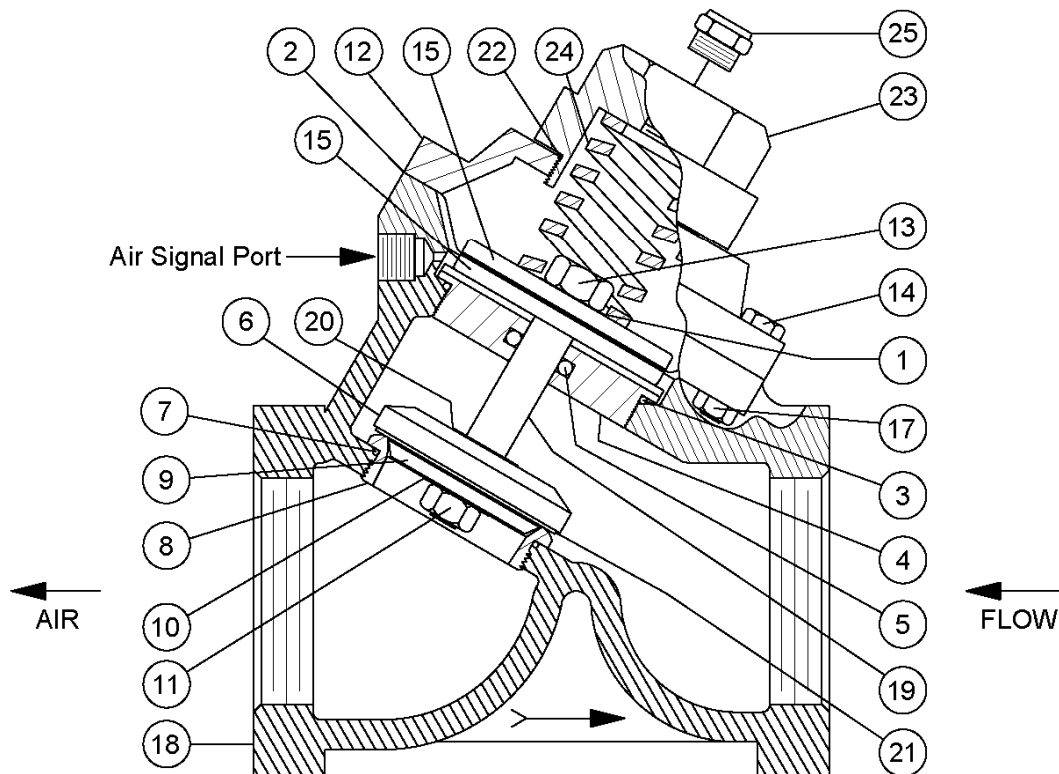
No.	Part. No.	Description
25	4215-XXX	Nozzle Holder (Specify Size)
26	4213-XXX	Blast Hose Coupling (Specify Size)
27	4214-XXX	Threaded Coupling (Specify Size)
	4214-999	Coupling Gasket
31	7040-003	Axle, 1 Bag
	7019-519	Nylock Nut, 3/4" UNC
32	7046-002	Wheel, 1 Bag
34	7000-000-06	Handway Gasket, 4" x 6"
36	4205-106	Hose Swivel Insert, 1" With Gasket
	4205-106-99	Hose Swivel Gasket, 1"
37	4235-006	Hose Clamp Double Bolt, 1"
38	4102-006	Air Hose, 1"
39	7119-002	Safety Pin, Air/Blast Hose Coupling
40	8710-98778	Hose Whip Check (Safety Cable)
41	7031-999-02	Warning Decal Kit
42	3030-005-11	Nipple TOE, 3/4" x 3" Lg.
43	3010-006-05	Reducing Elbow 90°, 1" x 3/4"
44	3029-006-14	Nipple TBE, 1" x 5" Lg.
45	2011-606	VBS® Lite, 1"
46	8408-000-389	Blowdown Flow Control Nipple, 1" x Close (#6) (3/8")

9.4 PicoValve™



9.5 Automatic Air Valve

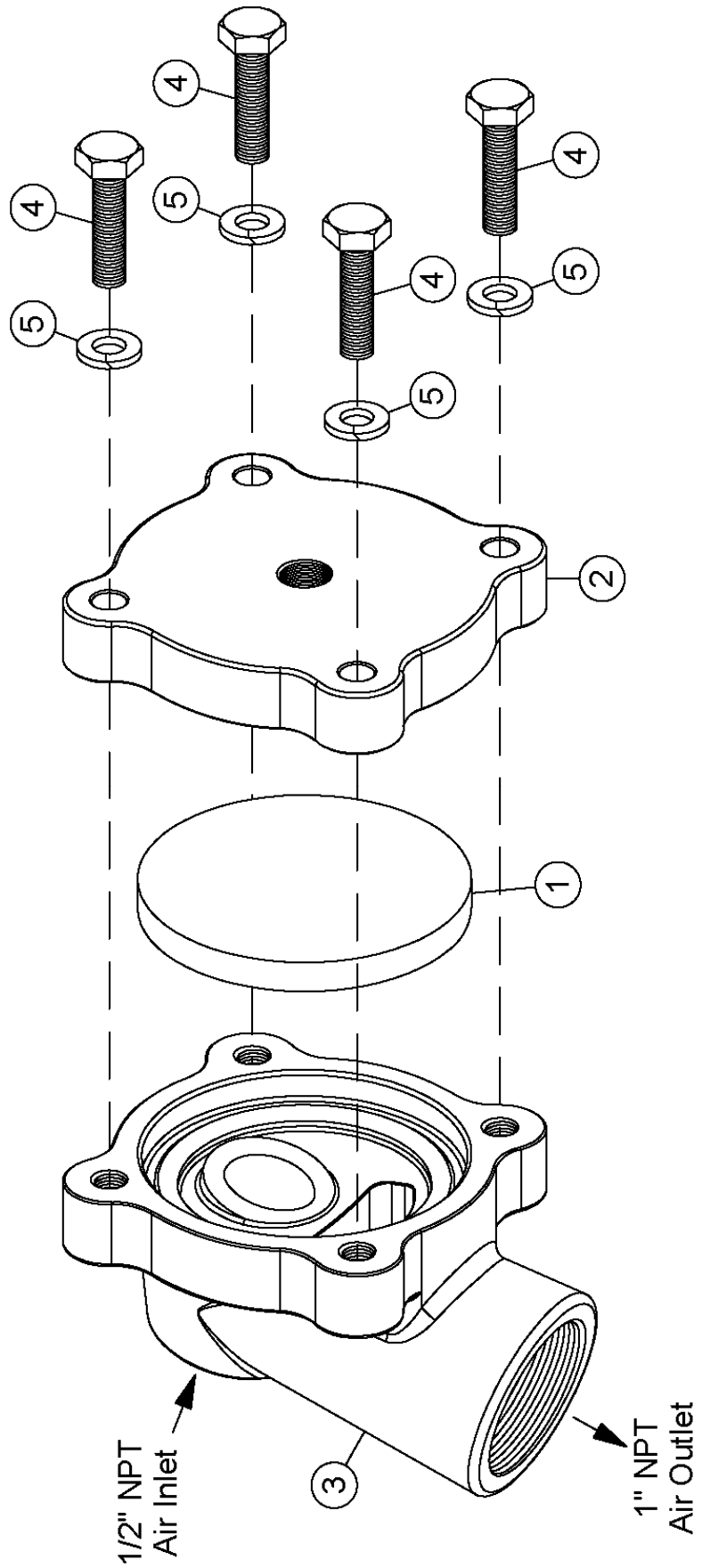
2123-106		1" Valve
No.	Part No.	Description
	2123-006-99	Replacement Parts Kit
	2123-006-97	Hard Parts Kit
1 *	2123-007-20	Gasket
2 *	2123-006-02	Diaphragm
3 *	2123-006-03	O-ring
4	2123-006-04	Retainer Bushing
5 *	2123-007-05	O-ring
6 +	2123-006-06	Disk Retainer
7 *	2123-006-07	O-ring
8	2123-006-08	Seat
9 +	2123-006-09	Disc Plate
10	"Deleted"	Lock Washer, Internal
11 *	7082-504	Lock Nut
12	2123-106-12	Cap
13 *	2123-006-13	Lock Nut
14	7010-503-06	Cap Screw
15 +	2123-006-15	Diaphragm Plate
17	7082-503	Lock Nut
18	2123-006-18	Body, 1"
19 **	2123-006-19	Shaft
20 *	2123-007-20	Gasket
21 *	2123-006-21	Disc
22 **	2123-106-22	O-ring
23 +	2123-106-23	Spring Retainer
24	2123-106-24	Spring
25 *	2014-300PKG	Vent, 1/8" (4 Pack)
26 *	2123-007-20	Gasket
* Included In Replacement Parts Kit		
+ Included In Hard Parts Replacement Kit		



NOTE: With spring closed valve air flow is in opposite direction from arrow on valve body.

9.6 Exhaust Valve

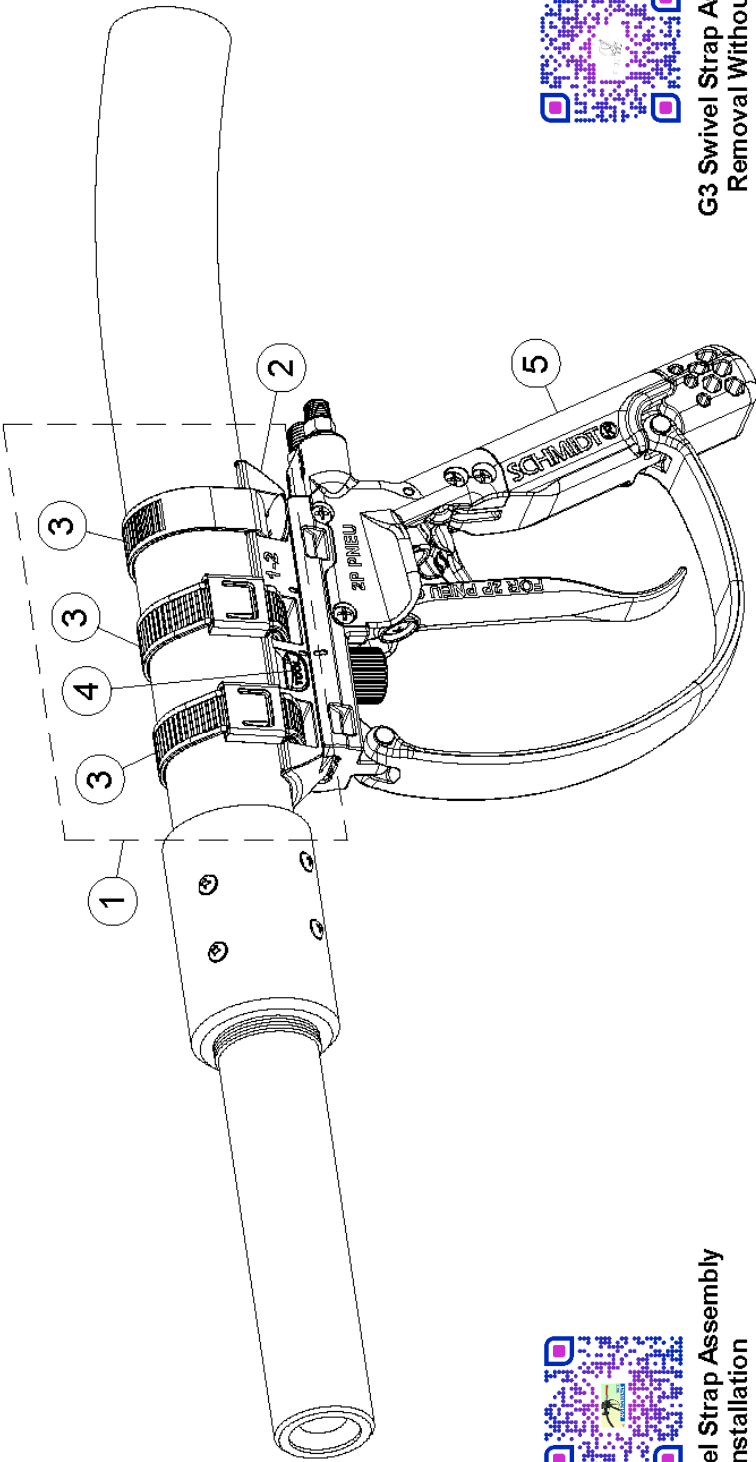
2227-004 Exhaust Valve, 1/2"		
Item	Part No.	Description
1	2227-004-01	Diaphragm
2	not available	Cap
3	not available	Body
4	7010-503-06	Hex Bolt, 1/4" UNC x 1" Lg.
5	7028-502	Lock Washer, 1/4"



9.9(a) G3 Swivel Strap Assembly (Pneumatic)

Item	Part No.	Description
	4501-01P	BAABS G3 Swivel Strap Assembly, Blast Hose 1/2"-1-1/2" HW, G3 2PP (2-Position Pneu)
1	4500-000-100	BAABS G3 Swivel Strap Adapter Subassembly, Blast Hose 1/2"-1-1/2" HW (G3 Trigger Deadman not included)
2	4500-005-102	BAABS G3 Swivel Strap Adapter, Blast Hose 1/2"-1" HW
	4500-007-102	BAABS G3 Swivel Strap Adapter, Blast Hose 1-1/4"-1-1/2" HW
3	4500-000-101PKG	BAABS Strap (12 Pack of Straps Includes 3 Swivel Strap Buckle Release Tools)
4	4500-000-103PKG	BAABS Swivel Strap Buckle Release Tool (5 Pack)
5	2270-101	G3 Trigger Deadman Assembly 2PP (2-Position Pneu) (See Figures 9.9(b) and 9.9(c))

* 4500-000-100 and 4501-01P assemblies include both sizes of G3 Swivel Strap Adapters (#2), 6 Straps (#3) and 3 Swivel Strap Buckle Release Tools (#4).



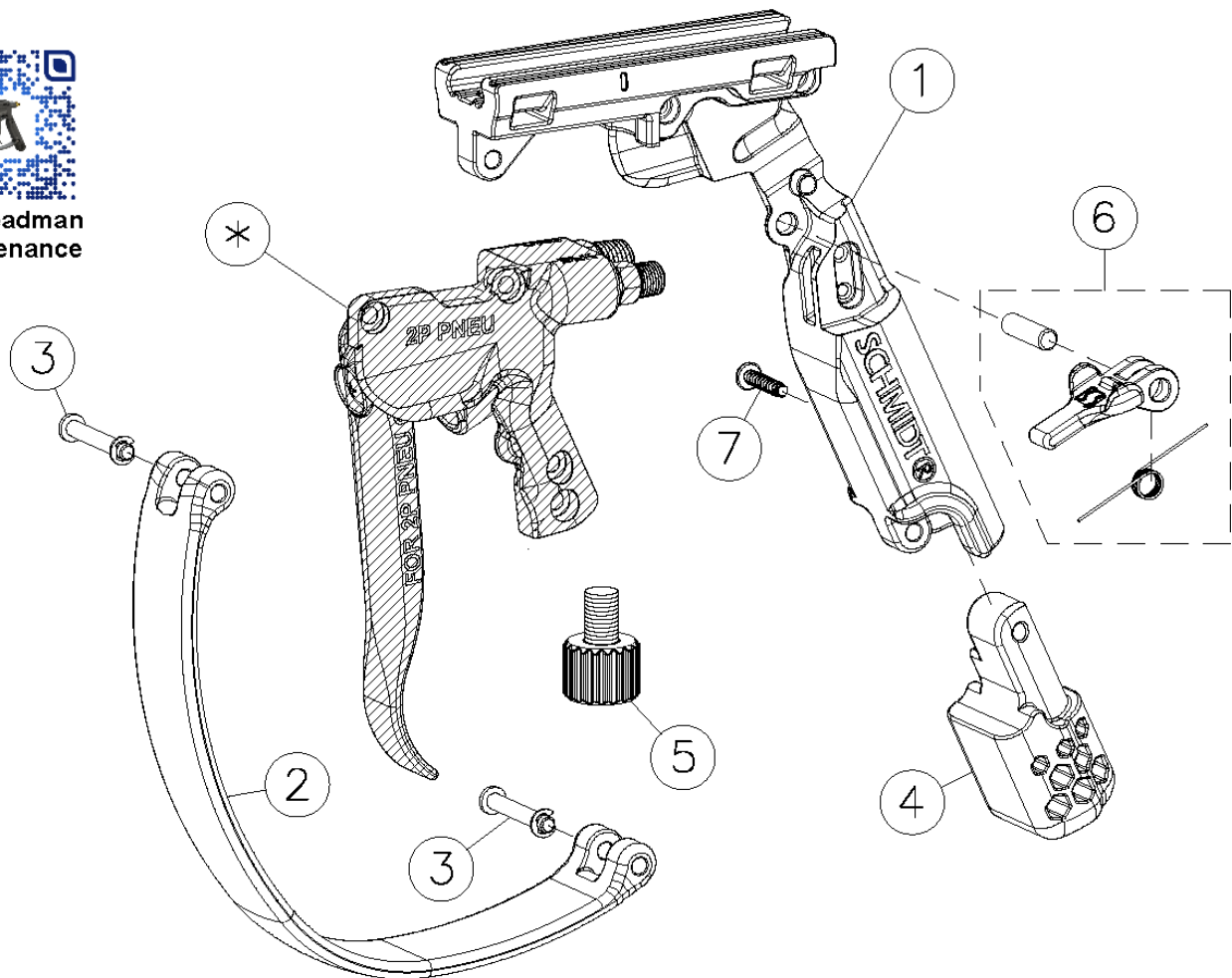
G3 Swivel Strap Assembly
Installation



G3 Swivel Strap Assembly
Removal Without Tool

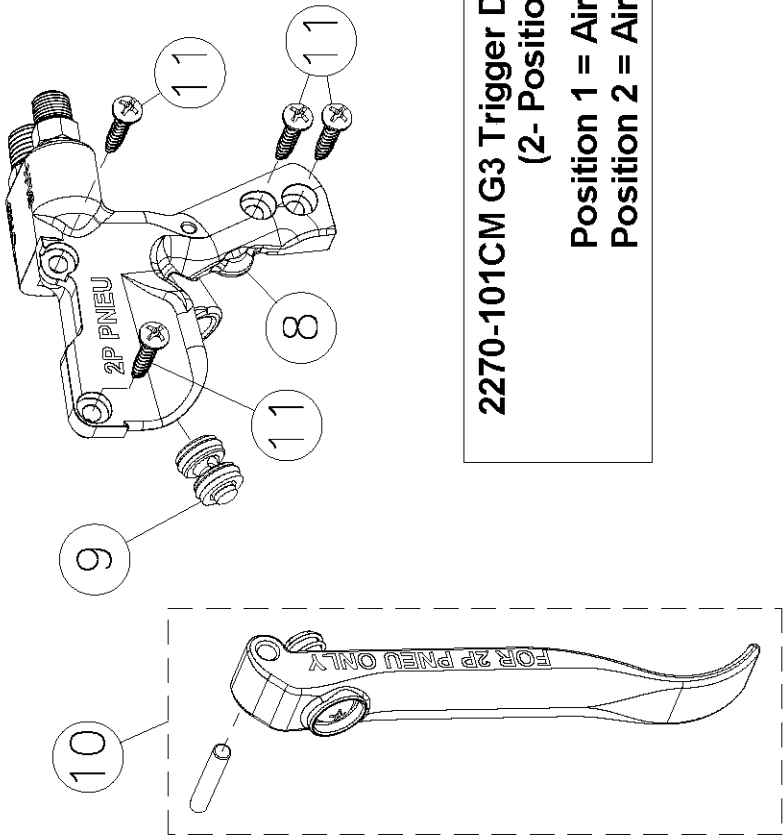
9.9(b) G3 Trigger Deadman Assembly (Pneumatic)

No.	Part No.	Description
	2270-101	G3 Trigger Deadman Assembly 2PP (2- Position Pneumatic)
		G3 Trigger Deadman Base Grip Assembly Part List
1	2270-000-01P	Grip
2	2270-000-02P	Trigger Guard
3	2270-000-08PKG	Trigger Guard Pin (4 Pack)
4	2270-000-07PKG	Bumper (2 Pack)
5	4500-000-05PKG	Locking Knob w/ Bolt (3 Pack)
6	2270-000-03APKG	Safety Flap Assembly (2 Pack)
7	2270-000-15PKG	Thread Forming Screw, #8-16 x 3/4" Lg. (4 Pack)
✱ See Figure 9.9(c) for 2-Position Trigger Deadman Control Module Subassembly		
	2270-101CM	G3 Trigger Deadman Control Module 2PP (2-Position Pneumatic)



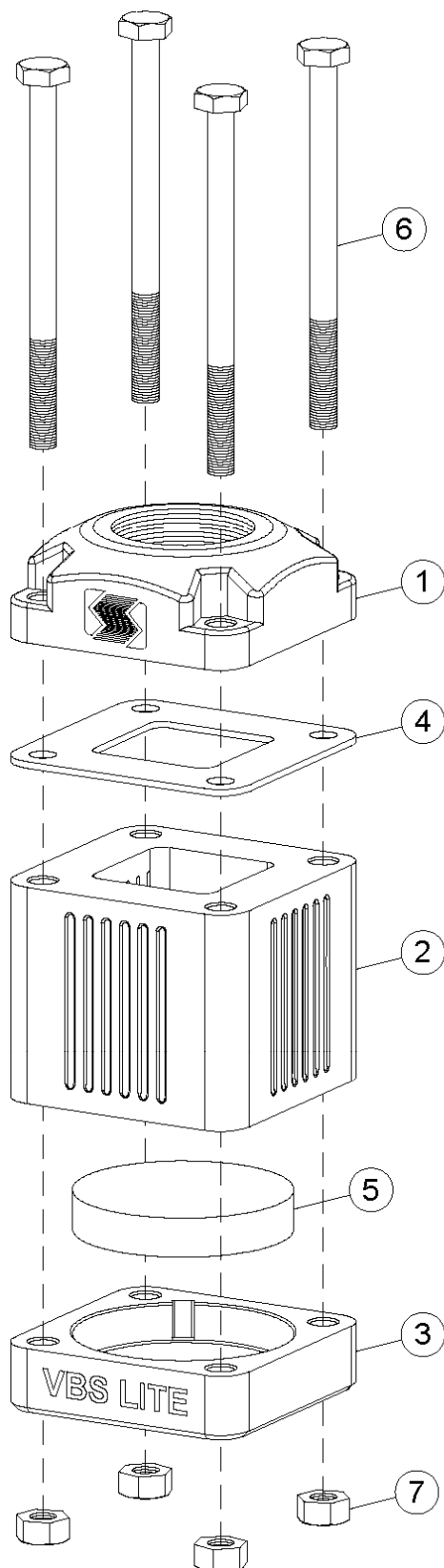
9.9(c) G3 Trigger Deadman Control Module 2PP (2-Position Pneumatic)

2270-101CM	G3 Trigger Deadman Control Module Subassembly 2PP (2-Position Pneu)	
No.	Part No.	Description
8	Not Available	Deadman Control Module Body 2PP (2-Position Pneu)
9	2263-002-03	Cartridge Assembly
10	2270-101T	Deadman Trigger Subassembly 2PP (2-Position Pneu)
11	2270-000-15PKG	Thread Forming Screw, #8-16 x 3/4" Lg. (4 Pack)

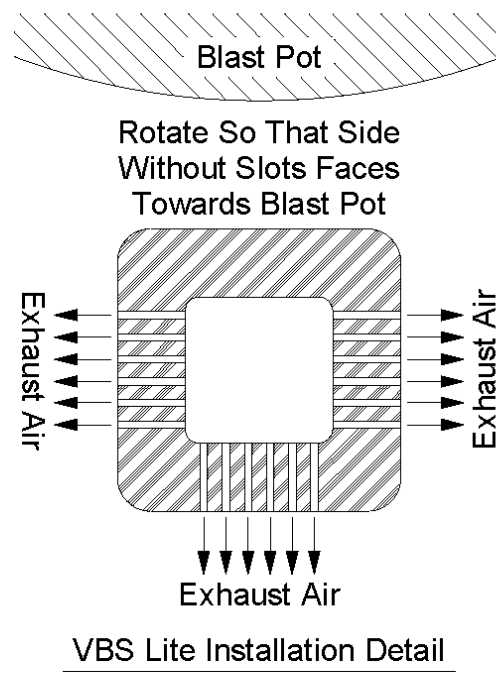


2270-101CM G3 Trigger Deadman Control Module 2PP
(2- Position Pneumatic)
Position 1 = Air Off, Abrasive Off
Position 2 = Air On, Abrasive On

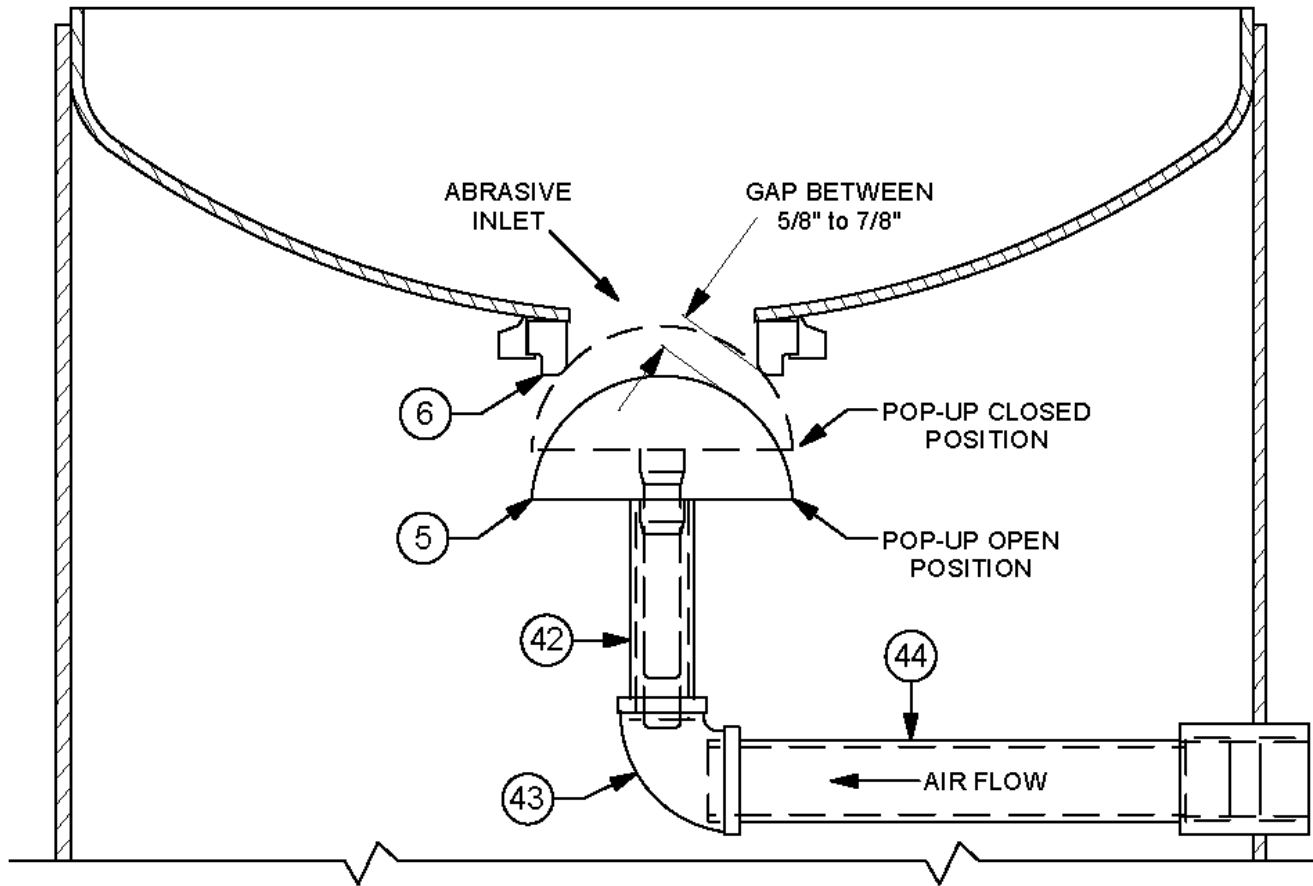
9.10 VBS® Lite (Volumetric Blowdown Suppression System)



2011-606		VBS Lite, 1"
No.	Part No.	Description
	2011-606-99	VBS Lite Replacement Parts Kit, 1"
1	2011-606-01	VBS Lite Base, 1"
2 *	2011-606-02	VBS Lite Body, 1"
3	2011-606-03	VBS Lite Cap, 1"
4 *	2011-606-04	VBS Lite Gasket, 1"
5 *	2011-606-05	VBS Lite Wear Pad, 1"
6	7010-503-12	Hex Bolt, 1/4" UNC x 3 1/2" Lg.
7	7017-503PKG	Hex Nut, 1/4" UNC (10 Pack)
* Included In Replacement Parts Kit		



9.11 Pop-Up and Internal Piping



NO.	PART NO.	DESCRIPTION
5.	2100-000	Pop-Up Head, (1 Bag)
6.	2100-001	Pop-Up Gasket (1 Bag)
* 42.	3030-005-11	Nipple TOE, 3/4" x 3" Lg.
43.	3010-006-05	Reducing Elbow 90°, 1" x 3/4"
44.	3029-006-14	Nipple TBE, 1" x 5" Lg.

*It may be necessary to cut to length to obtain the proper pop-up gap as shown above.

10.0 Recommended Spare Replacement Parts Lists

Universal Small Pot Spare Replacement Parts List			
Item No.	Qty.	Part No.	Description
2	1	4208-106PKG	Air Inlet Crowfoot, 1" (4 Pack)
2	1	4209-999PKG	Crowfoot Gasket (10 Pack)
3	1	2401-506	Air Inlet Ball Valve, 1"
4	1	2227-004	Exhaust Valve, 1/2"
4	2	2227-004-01	Exhaust Valve Diaphragm, 1/2"
5	1	2100-000	Popup Head with Stem (1 Bag)
6	1	2100-001	Popup Gasket (1 Bag)
9	1	2123-106	Automatic Air Valve, 1"
9	1	2123-006-02	Automatic Air Valve Diaphragm, 1"
9	1	2123-106-24	Automatic Air Valve Spring, 1"
9	1	2123-006-21	Automatic Air Valve Disc, 1"
9	1	2123-006-99	Automatic Air Valve Replacement Parts Kit, 1"
10	1	4104-40X-XX	Blast hose assembly (specify size and length)
11	1	500X-XXX	Blast nozzle (specify size and type)
12	1	2270-101	G3 Trigger Deadman Assembly, 2-Position Pneumatic
12	1	2270-101CM	G3 Trigger Deadman Control Module, 2-Position Pneumatic
12	1	2270-000-03APKG	G3 Trigger Deadman Safety Flap Assembly (2 Pack)
12	1	4500-000-101PKG	BAABS® Strap (12 Pack)
13	1	2401-506	Choke Ball Valve, 1"
14	1	2135-106	PicoValve™, 1" x 1-1/4"
14	1	2135-100-98	PicoValve replacement parts seals kit
14	1	2135-100-99	PicoValve replacement parts kit
14	1	2135-006-10	PicoValve Base, 1" x 1-1/4"
15	1	4100-301	Twinline Hose, 27.5ft.
21	1	2014-300PKG	Breather vent, 1/8" (4 Pack)
22	1	7000-006-11	Handway crab assembly, 4" x 6"
25	2	4215-XXX	Nozzle Holder (specify size and type)
26	2	4213-XXX	Blast Hose Coupling (specify size)
27	2	4214-107	Threaded coupling, 1-1/4"
27	1	4214-999PKG	Coupling Gasket (fits hose and threaded couplings) (10 Pack)
34	2	7000-000-06	Handway Gasket, 4" x 6"
36	2	4205-106	Hose insert, 1"
36	1	4205-106-99PKG	Insert gasket, 1" (10 Pack)
37	2	4235-006	Hose clamp, double bolt, 1" (for field installation)
38	10ft	4102-006	Air hose, 1"
39	2	7119-002PKG	Safety Pin, Air/Blast Hose Coupling (10 Pack)
40	2	8710-98778	Hose whip check
41	1	7031-999-02	Safety decal kit (See Section 0.0)

11.0 Troubleshooting

This section lists probable causes of problems that may occur during operation of the abrasive blaster. Not all the “probable causes” may apply to your abrasive blaster. The probable cause may not apply because of the control type and accessories on the abrasive blaster. Refer to Figure 11.1 and the drawings in Section 9.0.

DANGER

The Universal Small Pot is a Pressurized Vessel. Propelled objects will cause serious injury or death. Depressurize vessel before performing any maintenance. See Section 6.2.

11.1 Malfunction with Deadman Lever in the “Off” Position

11.1.1. Abrasive stops but blast air will not shut off

- (1) Defective or broken spring in automatic air valve (#9).
- (2) Defective seat in automatic air valve.
- (3) Blocked signal air hose to automatic air valve.
- (4) Defective O-ring in automatic air valve (around shaft).
- (5) Obstruction inside automatic air valve (#9) binding shaft movement.

11.1.2. Both blast air and abrasive will not shut off

- (1) Twinline hoses (#15) to deadman valve (#12) are crossed.
- (2) Non-Schmidt deadman (#12) has been installed.
- (3) Blocked twinline hose (#15).
- (4) Defective deadman valve (#12). Pneumatic deadman cartridge plunger stuck in the “ON” position (down). Cartridge plunger is visible below deadman handle.
- (5) Defective seat in automatic air valve (#9).
- (6) Defective or broken spring in automatic air valve (#9).
- (7) Defective O-ring in automatic air valve (#9) (around shaft).
- (8) Obstruction inside automatic air valve (#9) binding shaft movement

11.1.3. Blast outlet turns on accidentally

- (1) The G3 deadman trigger (#12) is worn out.
- (2) The safety flap on the G3 deadman (#12) is missing or broken. See drawings in Sections 9.9(b) and 9.9(c). Refer to manual 7200-372.
- (3) A bleeder type deadman valve has been installed. A bleeder type deadman valve *is not safe* because a particle of dirt from the air hose can plug the bleed hole and cause the blast outlet to turn on. See *Warnings and Rules for Safer Operation* in Section 1.0.
- (4) Defective O-ring in automatic air valve (#9) (around shaft).

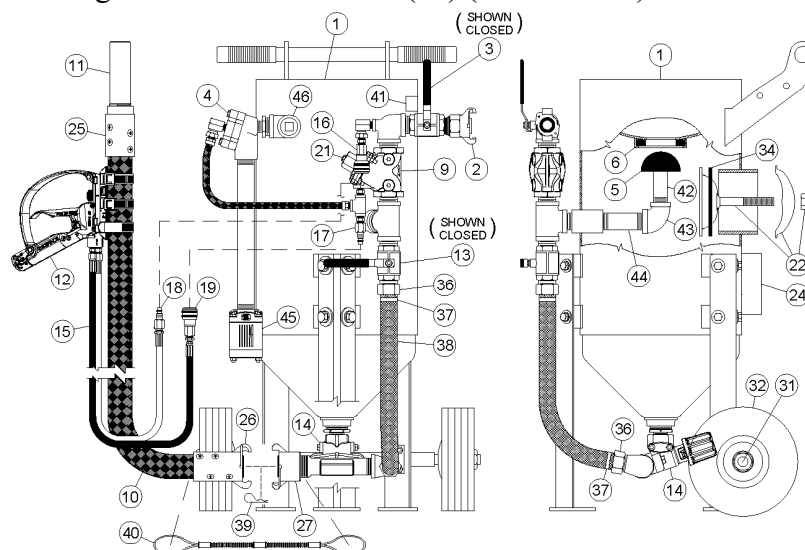


Figure 11.1 – Universal Small Pot with pneumatic blast controls

11.2 Malfunction with Deadman Lever in the “On” Position

11.2.1. Air blasts with no abrasive

- (1) Check abrasive level in blast vessel (#1).
- (2) PicoValve™ (#14) adjustment knob is in the closed position.
- (3) Trash plugging opening from tank to PicoValve (#14). See Section 11.3.
- (4) Defective diaphragm in exhaust valve (#4). Check for air leak at VBS® Lite (#45) slots.
- (5) Abrasive flow problems. See Section 11.3.
- (6) Blast vessel leak (popup or handway) reduces pressure slowing abrasive flow. See Section 6.3.
- (7) Air leak at PicoValve (#14) cleanout plug. See Section 9.4.

11.2.2. Abrasive choking out of blast hose with low blast air pressure

- (1) PicoValve (#14) abrasive adjustment knob is open too far.
- (2) Choke valve (#13) is partially closed causes differential pressure increases abrasive flow.
- (3) Low air compressor output cfm (unit may cycle on and off). See Section 3.3.

11.2.3. Reduced Pressure at the nozzle (with or without abrasive flow)

- (1) Low air compressor output CFM. See Section 3.3 to determine air requirements.
- (2) Air supply hose to blaster is too small. See Section 3.4.
- (3) PicoValve (#14) abrasive adjustment knob is open too far.
- (4) Check for leaks in blast vessel (popup or handway) or control piping.
- (5) Choke ball valve (#13) is partially closed.
- (6) Blocked automatic air valve (#9) breather vent (#21) prevents full opening.
- (7) Trash may be partially plugging the nozzle orifice (#11). Release deadman and allow the air pressure in the blast hose (#10) to dissipate. Close the air inlet ball valve (#3). **Note:** Only after the air in the blast hose has dissipated then remove the blast nozzle (#11) and clear blockage. *See note and instructions below.

DANGER

Confirm the air in the blast hose has dissipated before removing the blast nozzle. Squeeze or step on the blast hose. Firmness or stiffness indicates that the blast hose is pressurized. Do Not attempt to remove the blast nozzle. Allow the air to dissipate or manually dissipate before proceeding. *See note and instructions below.

DANGER

Do Not aim the blast nozzle towards yourself or any person. A system malfunction or a blocked blast nozzle that clears can trigger accidental start up resulting in injury to personnel.

Note: In a non-pressure hold system (Universal Small Pot) multiple malfunctions must occur simultaneously for air to be trapped in the blast hose. If the trapped air condition exists, follow the below instructions to manually dissipate blast hose pressure from a clogged blast nozzle:

- 1) Close the outlet choke ball valve (#13).
- 2) Close the outlet abrasive shut-off valve (if so equipped).
- 3) Slowly loosen the red air hose swivel nut (#36) just below the choke ball valve (#13).
- 4) Trapped air will leak from the swivel connection.
- 5) Loosen the red air hose swivel nut (#36) slightly more to confirm air dissipation.
- 6) When air has stopped leaking, squeeze the red air hose (#38) to confirm air has dissipated.
- 7) Prior to removing blast nozzle (#11) check flexibility of blast hose (#10) to confirm that no pressure is present.
- 8) Proceed to Section 11.1.3 for malfunctions with the deadman off.

11.2.4. Blast is slow to turn on or will not turn on when deadman trigger is pressed down.

- (1) Check twinline hose connections (#18 & #19) to see if they are connected properly.
- (2) Twinline control hoses (#15) are blocked.
- (3) Cartridge in deadman valve (#12) is blocked.
- (4) Low air compressor output CFM (unit may cycle on and off). See Section 3.3.
- (5) Air leaks in twinline hose (#15) from the deadman valve (#12).
- (6) Trash blocking the blast nozzle orifice (#11). See Item (6) in Section 11.2.3.
- (7) Blocked automatic air valve (#9) breather vent (#21) prevents full opening.

11.3 Notes on Abrasive Flow Problems

11.3.1. Contaminated Abrasive

Air quality is crucial to the operation of an abrasive blaster. Moisture and contaminants can cause components to malfunction. Moisture condensation in a blast system causes abrasive flow problems. Condensation occurs when the hot vapor-filled compressed air cools as it reaches the abrasive blaster. Water droplets formed during condensation can be absorbed by the abrasive in the blast vessel which can cause erratic flow to the abrasive valve. To minimize the chance of abrasive flow problems a moisture removal device installed for the blast system air supply is highly recommended (i.e. coalescing moisture separator, air-cooled aftercooler or deliquescent dryer). Contact a local authorized Schmidt® distributor or Axxiom Manufacturing, Inc. to locate one near you.



Do Not hammer on any part of the pressure vessel to improve abrasive flow. This can cause cracks that may lead to pressure vessel rupture.

11.3.2. Choking the blast outlet

The choke ball valve (#13) is used to clear any trash that may get into the blast vessel and block the PicoValve™ orifice. Whenever trash (paint chip, cigarette butt, etc.) blocks the abrasive valve orifice, the procedure is to fully open the valve by turning the knob counterclockwise, then press down the deadman trigger (#12) to begin blasting. While blasting, have an assistant close the choke valve completely for about one second. This creates differential pressure at the abrasive valve (high pressure above; low pressure below). The higher pressure from the blast vessel should be enough to loosen the trash blocking the abrasive valve orifice and blast it through the blast nozzle (#11). To protect against excess wear of the PicoValve (#14) keep the choke valve (#13) fully open during normal blasting.

Note: The PicoValve (#14) includes dual cleanout ports that can also be used in the choke procedure. Remove the cleanout plugs then choke as detailed above. Reinstall the plugs when complete. See the valve drawing in Section 9.4.



Trash cleared during the choking process may block the nozzle orifice. Refer to instructions Section 11.2.3(6) for procedure to clear nozzle.

11.3.3. Blast control hoses

Remember, the blaster controls and valves are normally closed. Therefore, the control hoses are depressurized to turn the blast off and pressurized to turn the blast on. If a needle gauge is available, it is the quickest way to check to see if there is pressure in the control hoses. If no needle gauge is available, disconnect each control hose fitting one at a time until the problem is located.

11.3.4. Recycled Abrasives

Used and recycled abrasives can contain trash & coating particles removed from previously blasted items (particularly sticky coatings) that can cause abrasive to clump together and block the metering valve orifice and stop flow. Prior to use recycled abrasive must be passed through a screen with openings no larger than 1/4" round. Some applications may require smaller openings.

NOTICE

Recycled abrasive can contain trash that can cause equipment malfunction. Prior to use, recycled abrasive must be passed through a screen with openings no larger than 1/4" round. Some applications may require smaller openings.

12.0 Warranty and Reference Information

12.1 Warranty

The following section is to be used as a guide in determining warranty policies and procedures for SCHMIDT® products. It is to be used in determining whether a warranty is justified and as a procedural guide in completing a SCHMIDT warranty claim.

12.2 Warranty Policy

1. All SCHMIDT products are guaranteed to be free of defects in material and workmanship at the time of shipment. Axxiom Manufacturing, Inc. warrants its products against defects in material and workmanship under normal and proper use for a period of ninety (90) days from the date of delivery. Such warranty is extended only to the buyer who purchases the equipment directly from Axxiom Manufacturing, Inc., or its authorized distributors. This warranty does not include expendable parts such as, but not limited to, hoses, nozzles, and seals.
2. The obligation under this warranty is limited to the replacement or repair, at Axxiom's option, of machines and does not include the cost of transportation, loss of operating time, or normal maintenance services. Axxiom Manufacturing, Inc. shall have no liability for labor, consequential damages, freight, or special charges.
3. This warranty does not apply to failure occurring due to abuse, misuse, negligence, corrosion, erosion, normal wear and tear, alterations or modifications made to the machine without express written consent of Axxiom Manufacturing, Inc.
4. Warranty requests must be submitted in writing within thirty (30) days after failure.
5. Written authorization to return merchandise under warranty must first be obtained from Axxiom Manufacturing, Inc. In no case shall merchandise to be returned to Axxiom for credit without authorization. At the time of authorization, Axxiom will issue a return authorization number that must be included on all packages and correspondence. Any material returned without prior authorization will remain the property of the sender and Axxiom will not be responsible for it.
6. All returns must be shipped with prepaid freight. All returns may be exchanged for other equipment or parts of equal dollar value. If goods are not exchanged, they are subject to a 20% restocking charge. Any cost incurred by Axxiom Manufacturing, Inc. to restore such goods to first class condition will be charged to the customer.
7. Axxiom Manufacturing, Inc. reserves the right to inspect and make the final decision on any merchandise returned under warranty.
8. Axxiom Manufacturing, Inc. offers no warranty with respect to accessories. This includes, but not limited to, engines, motors, batteries, tires, and any other parts not manufactured by Axxiom Manufacturing, Inc., but which the original manufacturer warrants.

9. Axxiom Manufacturing, Inc. reserves the right to make product changes or improvements without prior notice and without imposing any obligation upon itself to install the same on its products previously sold.
10. The above warranty conditions can only be altered by Axxiom Manufacturing, Inc. Axxiom must confirm alterations in writing for each specific transaction.
11. Axxiom Manufacturing, Inc. reserves the right to establish specific warranty terms for used or demo machines on an individual transaction basis. Invoices covering such merchandise will clearly state the provisions of the applicable warranty for each specific transaction.
12. USE OF NON-ORIGINAL SCHMIDT® FACTORY REPLACEMENT PARTS ON ANY SCHMIDT EQUIPMENT VOIDS ALL WARRANTIES.
13. AXXIOM MANUFACTURING, INC. DOES NOT AUTHORIZE ANY PERSON, REPRESENTATIVE OR SERVICE OR SALES ORGANIZATION TO MAKE ANY OTHER WARRANTY OR TO ASSUME ON BEHALF OF AXXIOM MANUFACTURING, INC. ANY LIABILITY IN CONNECTION WITH THE SALE OF OUR PRODUCTS OTHER THAN THOSE CONTAINED HEREIN.
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15. AXXIOM MANUFACTURING, INC. MAKES NO OTHER WARRANTIES, EXPRESSED OR IMPLIED, INCLUDING, BUT NOT LIMITED TO, THE IMPLIED WARRANTIES OF MERCHANTABILITY AND FITNESS FOR A PARTICULAR PURPOSE WITH RESPECT TO THE SCHMIDT PRODUCTS SOLD PURSUANT THERETO.

12.3 Trademarks, Patents, and Proprietary Statements

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Refer to www.SchmidtPatents.com linked here.



The text, diagrams, and drawings contained in this manual are proprietary information intended solely for instruction in the operation of the specified equipment. Use of any text, diagrams, or drawings contained in this manual for any reason other than its intended purpose without the written consent of Axxiom Manufacturing, Inc. is strictly prohibited.

12.4 Safety Information Sources

Axxiom Manufacturing, Inc

Axxiom Manufacturing, Inc exclusively manufactures this equipment and all Schmidt® equipment. If any operational or safety related questions arise relating to this equipment contact Axxiom Manufacturing, Inc.

Phone: 1-800-231-2085

Website: www.SchmidtMfg.com

Axxiom Manufacturing, Inc.
11927 South Highway 6
Fresno, Texas 77459

Occupational Safety and Health Administration (OSHA) establishes and enforces regulations regarding safety practices in the workplace including the abrasive blasting industry. Any questions, reporting of work-related injuries, or reporting of unsafe work practices can be submitted to the following contact information. Answers to most safety related questions can be found at the OSHA website shown below.

Phone: 1-800-321-6742

Website: www.osha.gov

U.S. Department of Labor
Occupational Safety and Health Administration
200 Constitution Avenue, N.W.
Washington D.C. 20210

National Institute of Occupational Safety and Health (NIOSH) is a federal agency responsible for conducting research and recommendations for the prevention of work-related injuries and sickness.

Phone: 1-800-232-4636

Website: www.cdc.gov/niosh

National Institute of Occupational Safety and Health
400 7th Street S.W.
Suite 5W
Washington, DC 20024

American National Standards Institute (ANSI) coordinates the development and use of voluntary consensus standards including safety standards.

Phone: 1-202-293-8020

Website: www.ansi.org

American National Standards Institute
1899 L Street, NW
Washington, DC 20036

12.5 Surface Preparation Information Sources

AMPP formally The Society for Protective Coatings (SSPC) consists of research and testing committees, conducts seminars, and establishes industry standards on surface preparation methods, abrasive, and coatings.

Website: www.ampp.org

Phone: 1-800-797-6223
15835 Park Ten Place
Houston, TX 77084

Phone: 1-877-281-7772
800 Trumbull Dr.
Pittsburg, PA 15205

National Association of Corrosion Engineers (NACE) develops test methods and recommends practices on surface preparation techniques and coatings.

Note: On June 2nd, 2021, NACE and SSPC merged and formed AMPP. Inquiries associated with NACE should be directed to the AMPP organization identified above.

12.6 Table of Blast Abrasive Characteristics

Abrasive Type	Hardness (Mohs)	Grain Shape	Density Lbs/ft ³	Color	Free Silica Content	No. of Recycles	Initial Cost	Typical Use
Corn Cobs	2	angular	35-45	tan	none	4-5	low	stripping paint from delicate substrates
Sodium Bicarbonate	2.8	crystal	60	white	none	4-5	medium	cleaning and stripping paint from delicate substrates
Walnut Shell	3	angular	45	lt. brown	none	4.5	low	stripping paint from delicate substrates
Plastic	3.2	angular	45-60	white	none	8-10	medium	Paint stripping, deburring, and cleaning
Glass Beads	4.5	spherical	90	crystal	none	8-10	low	cleaning finishing
Starblast XL	6.5	spherical	128	lt. brown	<1%	4-5	medium	outdoor blasting
Coal Slag	7	angular	85	black	none	1-2	medium	outdoor blasting
Copper Slag	7	angular	112	black	none	1-2	medium	outdoor blasting
Garnet	7	angular	147	pink	<2%	4-5	medium	outdoor blasting
Steel Shot	8	spherical	280	steel grey	none	200	low	cleaning and peening
Steel Grit	8	angular	280	steel grey	none	200	medium	removing heavy scale
Aluminum Oxide	9	angular	120	brown	<1%	6-8	medium	cleaning and finishing, deburring and etching

NOTES

13.0 Blasting Data

13.1 Table 1 Approximate Air Consumption (CFM) Per Blast Nozzle

		NOZZLE PRESSURE							
NOZZLE SIZE		60 psi	70 psi	80 psi	90 psi	100 psi	120 psi	140 psi	150 psi
No.2	1/8"	14	16	18	20	22	26	30	33
No.3	3/16"	32	36	41	45	49	58	66	73
No.4	1/4"	57	65	72	80	90	105	121	135
No.5	5/16"	90	101	113	125	150	160	185	205
No.6	3/8"	126	145	163	182	200	235	270	300
No.7	7/16"	170	193	215	240	270	315	360	400
No.8	1/2"	230	260	290	320	350	410	470	525
No.10	5/8"	360	406	454	500	550	640	740	825
No.12	3/4"	518	585	652	720	790	925	1060	1180

13.2 Table 2 Abrasive Consumption (lbs. per hour) Per Blast Nozzle*

		NOZZLE PRESSURE							
NOZZLE SIZE		60 psi	70 psi	80 psi	90 psi	100 psi	120 psi	140 psi	150 psi
No.2	1/8"	30	35	40	45	50	55	65	70
No.3	3/16"	65	75	85	95	105	120	140	155
No.4	1/4"	115	130	145	155	170	205	235	260
No.5	5/16"	155	170	190	220	235	275	315	350
No.6	3/8"	220	250	275	305	325	385	445	495
No.7	7/16"	300	340	380	420	455	535	615	680
No.8	1/2"	330	375	420	450	505	600	675	750
No.10	5/8"	495	560	625	675	760	885	1025	1135
No.12	3/4"	710	810	900	970	1090	1280	1465	1625

*NOTE: The data shown above for abrasive consumption has been updated based on comprehensive testing completed by Axxiom in 2021.

13.3 Table 3 Hose Selection Guide (blasting @ 100 psi)

NOZZLE SIZE	No.4 1/4"	No.5 5/16"	No.6 3/8"	No.7 7/16"	No.8 1/2"
CFM @ 100psi	90	150	200	270	350
AIR HOSE	1 1/4"	1 1/4"	1 1/2"	1 1/2"	2"
BLAST HOSE	1"	1 1/4"	1 1/4"	1 1/2"	1 1/2"
ABRASIVE (lbs. per hr.)	170	235	325	455	505

13.4 Additional Information on Blasting Productivity

Air volume and pressure are very important. The blasting production rate will increase with higher blasting pressures and decrease with lower blasting pressures. The National Association of Corrosion Engineers' data suggests that for each 1 psi reduction in nozzle pressure, there is a 1.5% production loss. Pressure drop through a Schmidt® blast unit is normally less than 1 psi, while blast units manufactured by competitors have pressure losses as high as 12 psi resulting in an 18% loss of production. Air pressure loss can also be avoided by using the shortest possible hose of adequate size. The inside diameter of both the blast hose (other than whip hose) and the air hose should be approximately three times the diameter of the orifice in the blast nozzle.

Standard Schmidt blast units are rated at a maximum pressure of 175psi or 150psi. However, equipment manufactured prior to 2005 may be rated at 125psi. Refer to pressure vessel nameplate.