

MANUAL

ROLLER CONVEYOR TYPE AUTO BLAST
MACHINE

MODEL NO: SY-2400-CV

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1. MACHINE DESCRIPTION

1) Personnel

This chapter describes property for the system and function for each parts. Everyone can get general knowledge for the system who read this part.

2) SY-2400-CV

The machine blasts stainless plate continually. Coated rubber rollers in the machine are driven by bevel gear so all rollers roll the same time and moved stainless plate . And moving plate blasts by glass bead on the rollers. You should control air pressure, nozzle angle and roller speed depend on media and work plate requirement. Almost dust move out on the plate after blasting because air blower work to the plate.

3) Each parts

(1) BLAST CHAMBER

This part is blasting space. There are square hole both sides to get in and out the plate and hole plates side to not fall into screw some piece. There are five doors at hopper to overhaul material is SS41 steel.

(2) CYCLONE

This part separate dust from using glass bead. Then dust go to dust collector, glass bead go to the bottom of the cyclone

(3) NOZZLE PART

This part shot media to the plate and suck air and media even rate nozzle unit consist of blasting gun air nozzle and boron carbide nozzle.

(4) NOZZLE OSCILLATOR UNIT

This part oscillate blasting nozzle uniform speed. This part consist of UCFL bearing, driving motor cam, $\varnothing 25$ shaft. There are two unit. One is upside and another is down side. Totally, 42 nozzles in the part.

(5) ROLLER CONVEYOR UNIT

This part move work plate. On the rollers surface coated rubber to protect the plate. The rollers speed can be controlled and driven by connecting bevel gears.

(6) SCREW UNIT

This part gather dropped glass bead after blasting one place. Two screws are the bottom of hopper and one screw connects at the two screw. The screws rotate and send the glass bead to bucket elevator.

(7) BUCKET ELEVATOR

This part removes glass bead to cyclone continually with many bucket from a screw.

(8) AIR BLOWING UNIT

This part removes glass bead on the work plate after blasting as power of air blower.

(9) DUST COLLECTOR

Dust collector gather dust from cyclone. There are 72bag filter in the dust collector. Dust sticked on the bag filter so only clean air get out to the sky.

(10) CONTROL PANEL

This part is for power supply and operate of the machine automatic and manual.

(11) PNEUMATIC SYSTEM

This part can adjust air pressure pull a cap the top of regulator and turn to CW to increase air pressure or turn to CCW to decrease air pressure. Push the cap after adjusting air pressure.

2. TECHNICAL DATA

1) BLAST CHAMBER

- * Ceiling: 6t, ss41
- * Other plate: 4.5t, ss41
- * Chamber size: 2800(L) x 2400(W) x 1200(H)
- * Max work size: 2200(L) x 40(H)

2) CYCLONE

- * Cyclone thickness: 6t, \varnothing 850, ss41
- * Flange: 9t, ss41
- * Duct to dust collector: \varnothing 250

3) NOZZLE PART

- * Nozzle quantity: 42EA
- * Nozzle size: 50(L) x \varnothing 19.5(OUT DIA.) x \varnothing 9.5(INNER DIA.),
- * Nozzle material: BORON CARBIDE
- * Nozzle style: VENTURY SUCTION TYPE

4) NOZZLE OSCILLATOR UNIT

- * MOTOR: 1/2HP(0.4kW) x 2EA, 10:1
- * DRIVING: Cam & universal joint
- * BEARING: RBL14(2EA), RBL12(44EA), UCFL205(44EA)

5) ROLLER CONVEYOR UNIT

- * MOTOR: 2HP(1.5kW), 120:1
- * DRIVING: CHAIN & SPROCKET(RS60)
- * SPEED: MAX 2M/min
- * SPEED CONTROL: VOLUME SETTING
- * BEARING: UCF207(54EA)

6) SCREW UNIT

- * MOTOR: 1HP(0.75kW), 30:1
- * DRIVING: CHAIN & SPROCKET(RS60)
- * PIPE SIZE: 6"(2SET), 8"(1SET)
- * BEARING: UCF208(6EA)

7) BUCKET ELEVATOR UNIT

- * MOTOR 1HP(0.75kW), 10:1
- * DRIVING: CHAIN & SPROCKET(RS60)
- * BEARING: UCF208(4EA)

8) AIR BLOWING UNIT

(1) Removing glass bead on surface stainless on the blasting

- * Capacity: 28m³/min x 220mmAq
- * Fan: 2HP(1.5kW) x 2P

(2) Removing dust after blasting

- * Capacity: 42m³/min x 220mmAq
- * Fan: 3HP(2.2kW) x 2P

9) DUST COLLECTOR

- * Capacity: 100m³/min x 250mmAq *6000 m³/h*
- * Bag filter: Ø125 x 2200mm(72ea)
- * Fan: 7.5HP(5.5kW) x 2P
- * Body: 4.5t, ss41
- * Ceiling: 6t, ss41
- * Dust disposal type: AUTO PULSE TYPE(1")

10) CONTROL PANEL

Item	Quantity	Power
TURBO FAN 10HP(DUST COLLECTOR)	1SET	7.5kW
NOZZLE OSCILLATOR MOTOR 0.5HP	2SET	0.8kW
ROLLER CONVEYOR MOTOR 2HP	1SET	1.5kW
SCREW DRIVING MOTOR 1HP	1SET	0.75kW
BUCKET ELEVATOR MOTOR 1HP	1SET	0.75kW
FAN BLOWER 3HP(DUST CLEANING)	1SET	2.2kW
FAN BLOWER 2HP(MOVING OUT GLASS BEAD)	1SET	1.5kW
ROTARY VALVE 0.5HP(DSUT COLLECTOR)	1SET	0.4kW
LAMP 60W	3EA	0.18kW
TOTAL		15.58kW

- * Power supply: 440V x 3P
- * Control switch power supply: 220V x 1P
- * Electrical power supply

11) PNEUMATIC SYSTEM

- * AIR SUPPLY PIPE: 50A (2 LINE)
- * BLASTING PIPING LINE: 1/2"(8 LINE)
- * AIR BLOWING LINE: 1"
- * ABLE PRESSURE: 0~6kgf/cm²
- * NEEDS AIR (Raise 5kgf/cm²)

Item	Capacity
BLASTING NOZZLE 42EA	200HP(24m ³ /min)

3. INSTALLATION

1) Personnel

This chapter addresses about installation. If the method is right the machine can be driven rightly. Installer have to finish testing after installation on automatic.

2) Power supply

This unit needs 440V x Ø3 power.

If cables connect incorrectly the unit will not work or make wrong motor direction .

When the machine drive wrong motor direction, change two main power cable of the three main cable.

3) Air supply

Air line must be connect same ball valve size(2" or 50A).

4) Notice for installation

- * Install even place.
- * Avoid humid place.
- * Install good ventilation place.
- * Make enough installation place because the unit needs clean and check often.

5) Testing

- (1) Power on
- (2) Turn mode on manual
- (3) Lamp on
- (4) All manual operating Switch on
- (5) Adjust blasting condition what speed, time etc.
- (6) Check right working on all driving unit on manual mode
- (7) Turn mode auto on
- (8) Push the start button
- (9) Check right working all driving unit
- (10) Push the stop button

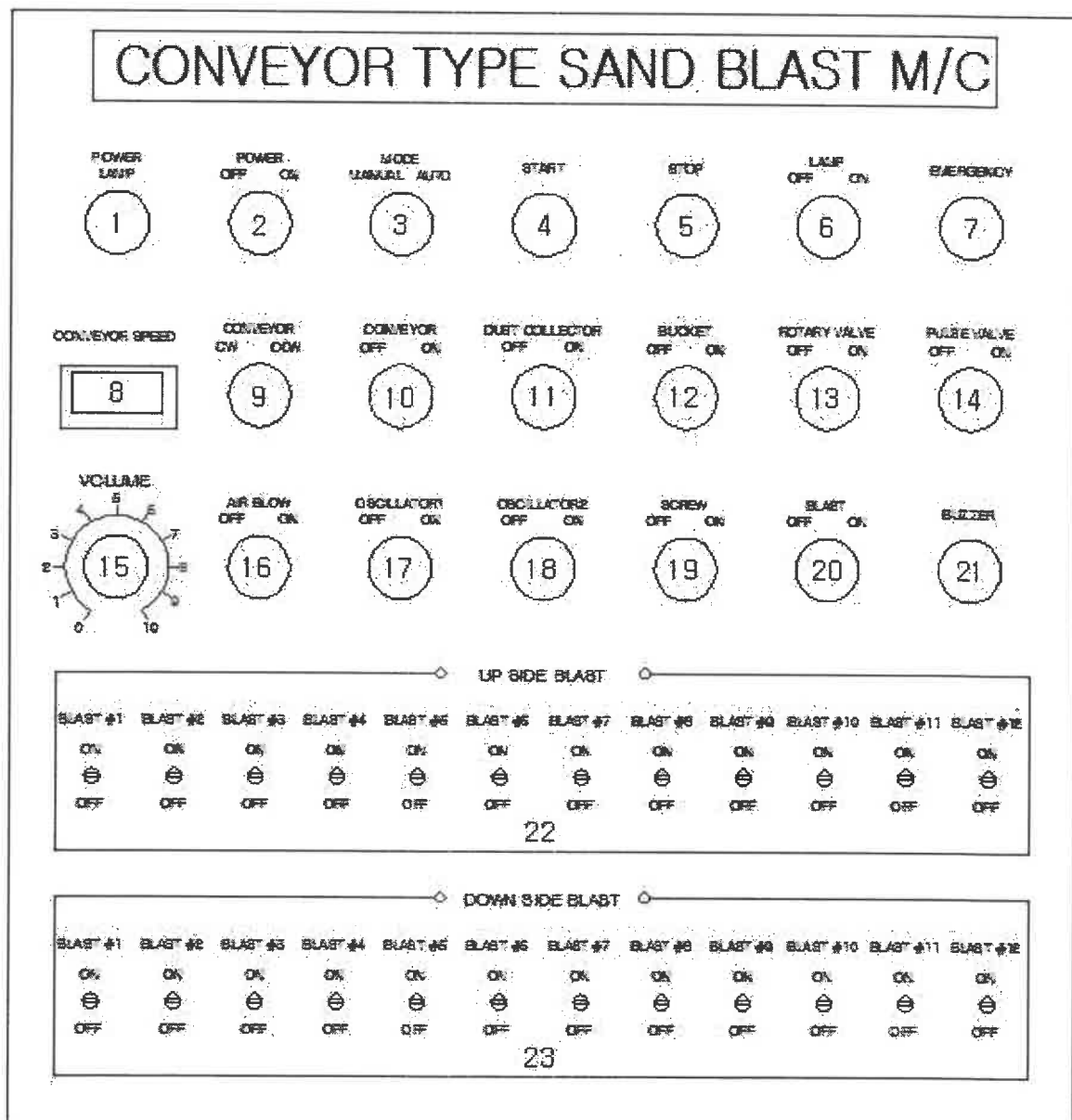
4. OPERATING

1) Personnel

This chapter addresses about operating way of control panel to drive all system.

2) Operating parts name and function

(1) Operating panel drawing



(2) Name and function

No	Name	Function
1	POWER LAMP	When turn power switch on this lamp light.
2	POWER OFF ON	Power supply switch
3	MODE MANUAL AUTO	Automatic or manual mod select switch
4	START	Automatic start button
5	STOP	Automatic stop button
6	LAMP OFF ON	Lamp turn on switch
7	EMERGENCY	Emergency switch
8	CONVEYOR SPEED	Roller conveyor speed indicator
9	CONVEYOR CW CCW	Roller conveyor direction select switch
10	CONVEYOR OFF ON	Roller conveyor on/off switch
11	DUST COLLECTOR OFF ON	Dust collector on/off switch
12	BUCKET OFF ON	Bucket elevator and the below screw on/off switch
13	ROTARY VALVE OFF ON	Rotary valve at the dust collector on/off switch
14	PULSE VALVE OFF ON	Pulse valve at the dust collector on/off switch
15	VOLUME	Roller conveyor speed adjustor
16	AIR BLOW OFF ON	Air blow on/off switch
17	OSCILLATOR1 OFF ON	Upside nozzle oscillating motor on/off switch
18	OSCILLATOR2 OFF ON	Downside nozzle oscillating motor on/off switch
19	SCREW OFF ON	Glass bead moving screw on/off switch
20	BLAST OFF ON	Blasting on/off switch
21	BUZZER	Emergency speaker
22	UP SIDE BLAST	This part is upside nozzle on/off switch. When blasting auto or manual, operator can turn on only needs nozzle switch
23	DOWN SIDE BLAST	This part is downside nozzle on/off switch. When blasting auto or manual, operator can turn on only needs nozzle switch

3) Manual operating

- ① Power switch on("2" switch)
- ② Check lighting lamp switch("1" switch)
- ③ Select manual mode("3" switch)
- ④ Confirm right working each driving motor and blasting nozzle with every each switch on

4) Automatic operating

- ① Power switch on("2" switch) and Check lighting lamp switch("1" switch)
- ② Select auto mode("3" switch)
- ③ Select conveyor directing CW or CCW("9" switch)
- ④ Dust collect switch on("11" switch)
- ⑤ Wanted shooting blast nozzle switch on("22", "23" switch, operator can select switch on and off when the machine driving)
- ⑥ Lamp switch on("6" switch, It is up to operator)
- ⑦ Turn off the switch driving by motor ("10", "12", "16", "17", "18", 19" switch)
- ⑧ Push start button("4" switch)
- ⑨ Push start button("5" switch)

5. MAINTENANCE

1) Personnel

This chapter addresses about maintenance. Reader can get knowledge for maintenance How to and How often.

2) Glass bead supply

- (1) Dust collector switch on
- (2) Bucket switch on
- (3) Screw switch on
- (4) Supply abrasive both side of the blasting chamber at roller parts about 200kg

3) Glass bead changing

- (1) Dust collector switch on
- (2) Drive at idle about 3 minute
- (3) Shot air by air gun to clean blasting chamber. Then gather all glass bead under the chamber to get screw and bucket elevator
- (4) Prepare a media box under the media change pipe
- (5) Open a cap at the media changing pipe
- (6) When glass bead get out of the cyclone, close the cap.
- (5) shot air to cyclone through the media changing pipe
- (6) After then supply same method like "1)"(Glass bead supply)

4) Changing bag filter

- (1) Open ceiling cover on dust collector
- (3) Release air pulse pipe and remove ventury
- (4) Get out bag filter with bag cage
- (5) Separate bag filter from bag cage
- (6) Put bag cage in new bag filter and assemble in reverse orde

! Caution : Information about risks, that might cause

- When you supply glass bead dust collector must be turned on so that hopper isn't choked by the abrasives.
- If you supply the abrasives much deal all abrasives choke mesh screen in the hopper and they don't inhale to cyclone and they don't circulate.

6. TROUBLE SHOOTING

1) Personal

This chapter addresses about trouble shooting. If Sometimes the machine make a trouble, see this chapter.

2) When goods quality is poor

CAUSE	CHECK	COUNTERMEASURE
Glass bead lack	1.Check sight glass on cyclone	1.Supply glass bead
Not roller working	1.Driving motor check 2.Bevel gear breakaway	1.Motor repair or change 2.Set bevel gear position
Work surface spot	1.Nozzle position 2.Media contaminate	1.Change nozzle position 2.Change glass bead
Nozzle not working	1.Solenoid valve 2.Air hose separating	1.repair or change 2.Tie air hose to blasting gun

3) Generation of heat, noise, vibration

CAUSE	CHECK	COUNTERMEASURE
Bearing damage	Bearing	Change
Parts wear	Parts wear	Change
loose chain tension	Chain tension	Tighten chain
Cut parts power cable	Cable connecting	Cable connect or change

4) Lack of dust separating ability

CAUSE	CHECK	COUNTERMEASURE
Weak dust suction power	1.Damper 2.Cyclone damage	1.Adjust damper angle 2.Repair cyclone

5) Leak of dust

CAUSE	CHECK	COUNTERMEASURE
Bag filter damage	Bag filter damage	Change
Weak turbo fan power	1.Damper angle 2.Turbo fan belt	1.Adjust damper angle 2.Tighten v-belt

6) Turbo fan vibration

CAUSE	CHECK	COUNTERMEASURE
Turbo fan vibration	1.Fan v-belt 2.Bear ing	1.Tighten v-belt 2.Change bearing

7) Other trouble

(1) If obstruct of vision caused by dust in the machine

- ☞ Check dust collector normal working
- ☞ Check turbo fan direction
- ☞ Check rotary valve normal working
- ☞ Check screw and bucket elevator normal working
- ☞ Check dust collector door open

(2) If glass bead and air aren't supplied.

- ① Check main air connecting and supply .
 - ☞ Connect air line or open ball valve.
- ② In case of air gauge indicates near "0".
 - ☞ Air pressure up by regulator. If it brake change it.
- ③ In case of breakdown of solenoid valve.
 - ☞ Change.
- ④ In case of nozzle is chocking.
 - ☞ Open up the nozzle by sharp thing.
- ⑤ There is nothing abrasives
 - ☞ Supply abrasives.

(3) In case of only supply air without glass bead.

- ① In case of choked nozzle
 - ☞ Get out broken piece of nozzle
- ② In case of choked share tank
 - ☞ Separate blasting hose and clean share tank
- ③ Lack of glass bead
 - ☞ Check sight glass oncyclone
 - ☞ Charge glass bead
- ④ If operator supply a lot of glass then that choked screw part
 - ☞ Separate screw flange and move out screw then remove glass bead from chamber

⑤ In case of air nozzle move other position

☞ Fix air nozzle position rightly

☞ Check pulled out blasting hose with blasting gun

(4) In case of machine not working

☞ Check switch on in distribution panel

☞ Check pushed emergency switch

☞ Check "OCR" under the magnet switch in distribution panel

7. Major parts check and maintenance

1) Personal

The machine needs periodic check some parts for longer life time, increasing efficiency, economical working process. So that check next table.

2) Check table

(1) Blasting chamber

NO	Check list	day	week	month	note
1	Door packing condition	<input type="radio"/>			
2	Dust leak to near machine	<input type="radio"/>			
3	Machine vibrating	<input type="radio"/>			
4	Nozzle oscillating	<input type="radio"/>			
5	Machine body corrosion			<input type="radio"/>	

(2) Roller conveyor unit

NO	Check list	day	week	month	note
1	Even rolling speed of roller	<input type="radio"/>			
2	Each roller normal working	<input type="radio"/>			
3	Driving motor vibration and noise	<input type="radio"/>			
4	Driving motor overheating	<input type="radio"/>			
5	Check abrasion of chain and gear			<input type="radio"/>	
6	Check abrasion fo roller rubber coating	<input type="radio"/>			

(3) Pneumatic unit

NO	Check list	day	week	month	note
1	Check compressor air leak	<input type="radio"/>			
2	Pneumatic unit vibration	<input type="radio"/>			
3	Check each pneumatic parts condition			<input type="radio"/>	
4	Check solenoid valve working		<input type="radio"/>		

(4) Motor driving unit

N0	Check list	day	week	month	note
1	Motor overheating	<input type="radio"/>			
2	Driving motor vibration and noise	<input type="radio"/>			
3	Chain tension condition			<input type="radio"/>	
4	Bucket elevator belt drooping and centering	<input type="radio"/>			
5	Bucket elevator tension condition		<input type="radio"/>		

(5) Dust collector

N0	Check list	day	week	month	note
1	Door packing condition		<input type="radio"/>		
2	Check compressor air at pulse valve and air tank		<input type="radio"/>		
3	Check turbo fan v-belt tension		<input type="radio"/>		
4	Bag filter position and splitting			<input type="radio"/>	
5	Check bag filter breakaway		<input type="radio"/>		
6	Check pulse valve and twin timer working		<input type="radio"/>		

(6) Blow unit

N0	Check list	day	week	month	note
1	Check blower noise		<input type="radio"/>		
2	Motor driving in rated current			<input type="radio"/>	
3	Motor overheating cannot touch		<input type="radio"/>		
4	Blow vibration(within 3mm)			<input type="radio"/>	

8. RECOMMEND SPARE PARTS LIST

1) NOZZLE PARTS

NO	Item	name(Specification)	life time
1	BLASTING GUN	SMNOP1	
2	NOZZLE COVER	SMNOP2	
3	BLASTING HOSE	inner dia Φ 19	1500h
4	BLASTING NOZZLE	SMNOP4	1500h
5	AIR HOSE	inner dia \varnothing 9.5	
6	HOSE NIPPLE	1/2"- Φ 19	

2) NOZZLE OSCILLATOR UNIT

NO	Item	name(Specification)	life time
1	GEARED MOTOR	0.4kw 10:1	
2	CHAIN& SPROCKET	RS-60	
3	BEARING	RBL 14, RBL 12	

3) ROLLER CONVEYOR UNIT

NO	Item	name(Specification)	life time
1	GEARED MOTOR	1.5kw 120:1	
2	SHAFT & ROLLER	REFERENCE DRAWING	
3	CHAIN& SPROCKET	RS-60	
4	BEARING	UCF207,UCP208	

4) SCREW UNIT

NO	Item	name(Specification)	life time
1	GEARED MOTOR	0.75kw 30:1, 3HP	
2	SHAFT & ROLLER	REFERENCE DRAWING	
3	CHAIN& SPROCKET	RS-60	
4	BEARING	UCF207,UCP208	

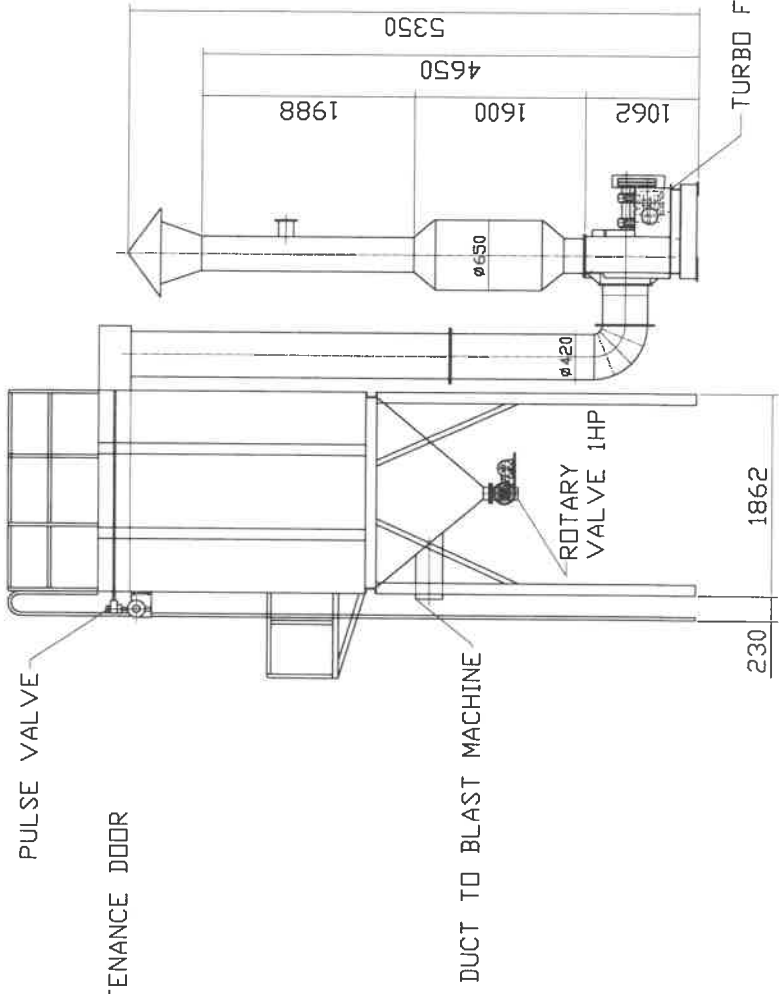
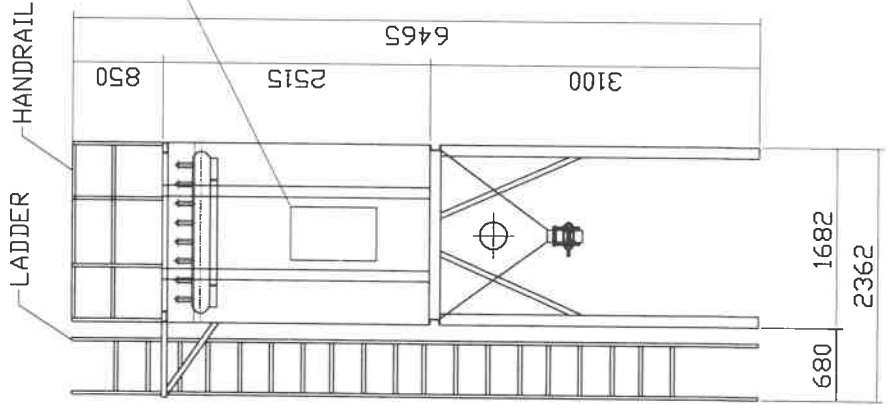
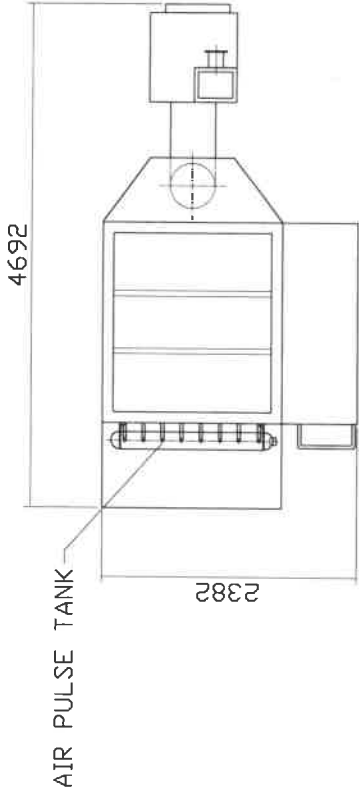
5) DUST COLLECTOR

NO	Item	name(Specification)	life time
1	TURBO FAN	10HP	
2	AIR PULSE VALVE	JIC 25A	
3	BAG FILTER	Ø 1250 x 2200L	
4	TWIN TIMER	6PORT	

6) PNEUMATIC SYSTEM

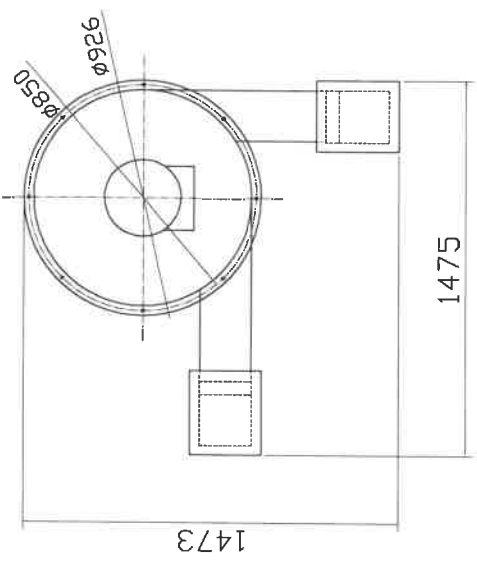
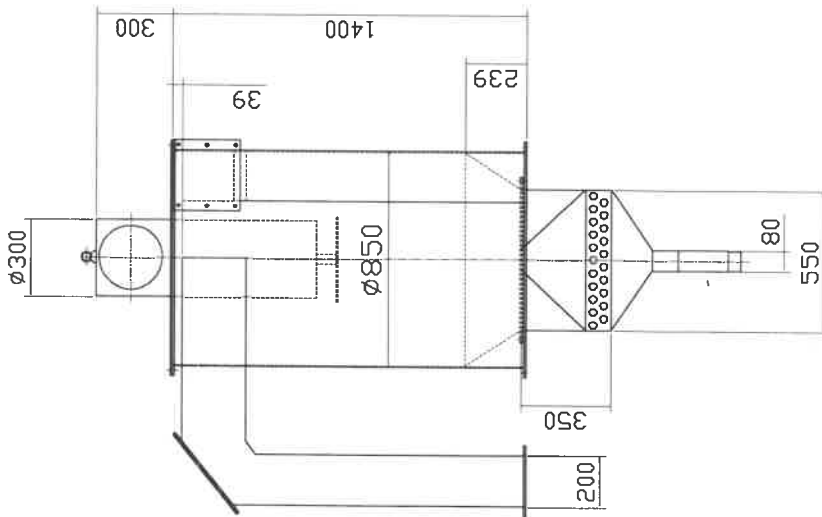
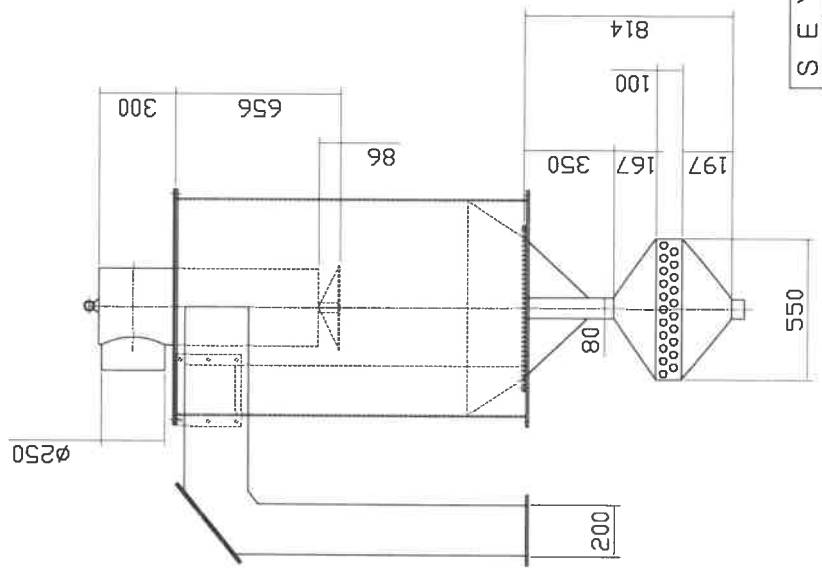
NO	Item	name(Specification)	MAKER	life time
1	REGULATOR(50A)	AR925-20G	SMC	
2	TWO-WAY VALVE(1/2")	VXD2140-04-4G	SMC	
3	PRESSURE GAUGE	G46-10-02M-C	SMC	

9. DRAWING

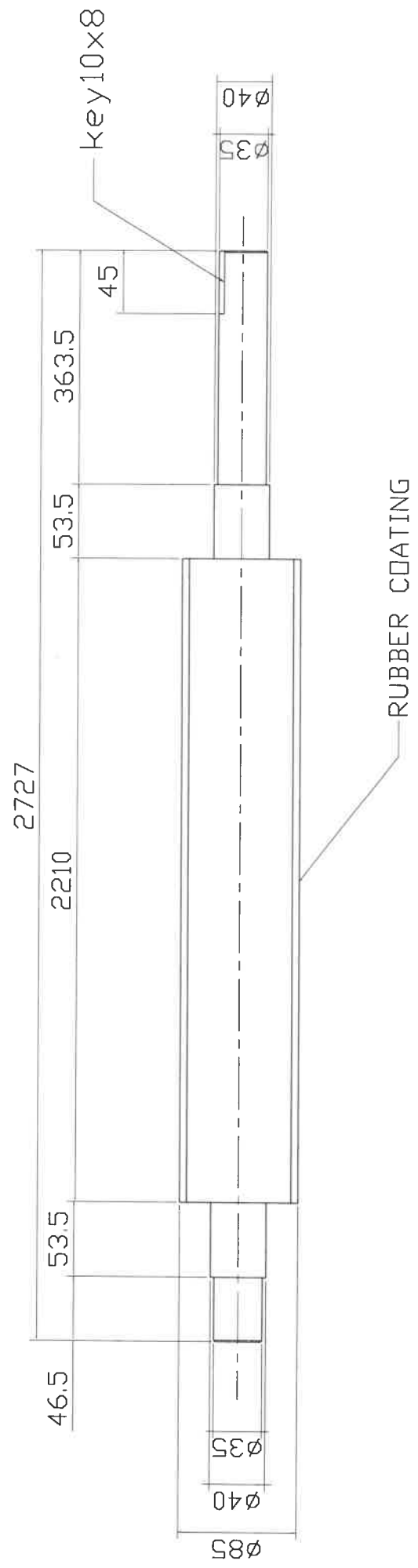
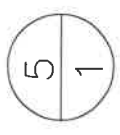


S E Y U	 	SUBMITTER NAME PREPARED BY CHECKED BY APPROVED BY	SIGN. DATE 	CLIENT 	MODEL 	CONVEYOR TYPE BEAD BLAST MC
		DWG. REV. NEXT ASSY	DATE 	WEIGHT 	NET WT 	

SEYU	NAME	SIGN.	DATE	CLIENT
	MODEL			CYCLONE
	WEIGHT			
	PART #			



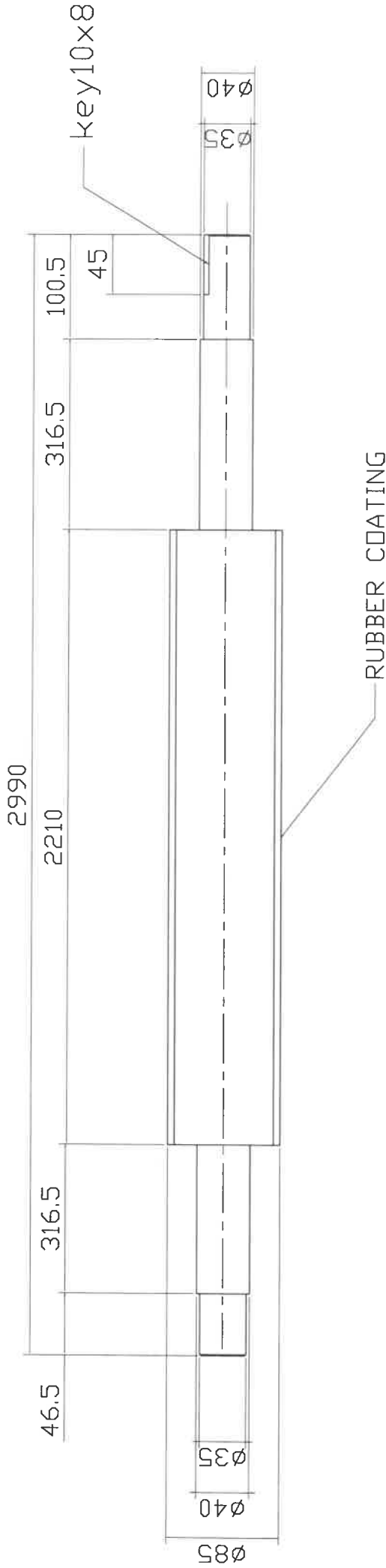
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5/1	ROLLER1	S45C	14EA



S E Y U		DATE	TIME	CLIENT
PREPARED	NAME	SIGN.	DATE	MODEL
CHECKED				ROLLER
APPROVED				date
				DATE
				WEIGHT
				PART NO.

5
2

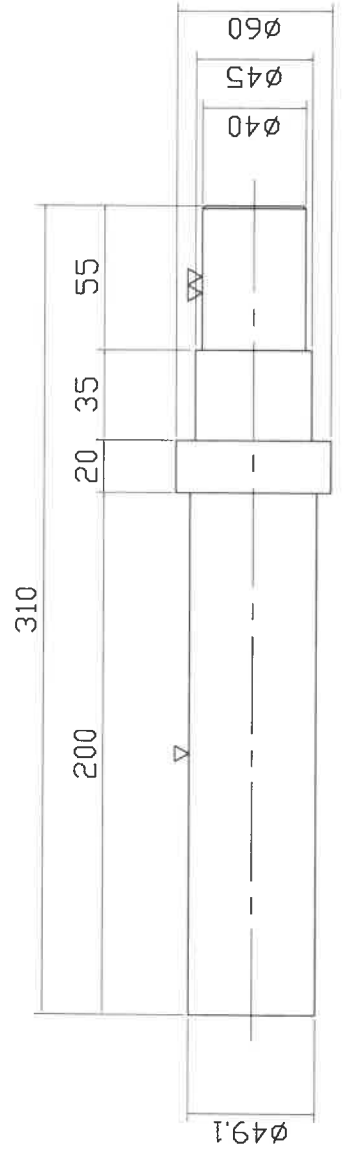
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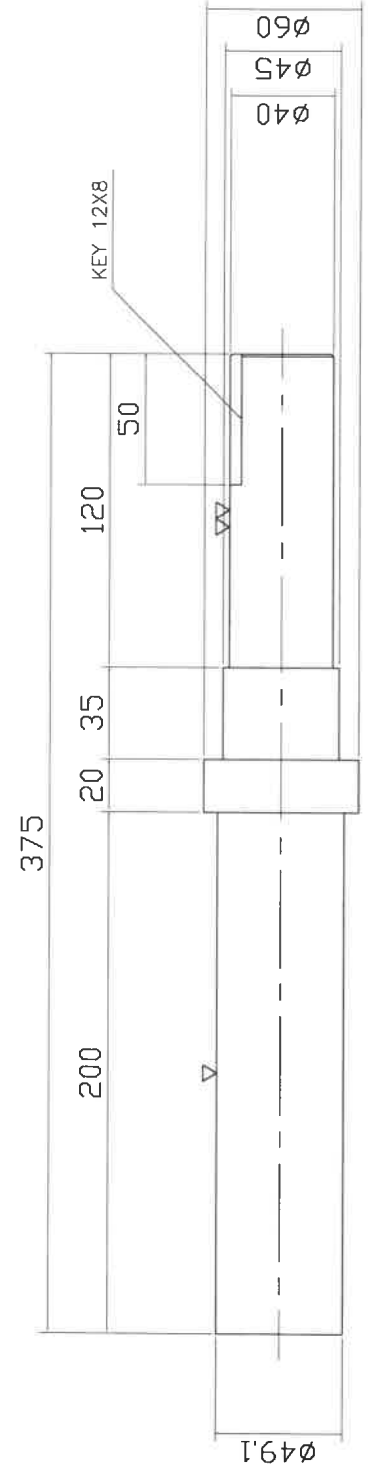
S E Y U	LABORER	NAME	SIGN.	DATE	CLIENT
	CHECKED				MODEL
	APPROVED				ROLLER DRIVING SHAFT
					date
					WEIGHT
					DATE

No	ITEM	MATERIAL	QUANTITY
6/3	SCREW SHAFT1	S45C	3EA
6/4	SCREW SHAFT2	S45C	3EA

③ $\frac{6}{3}$ ~ (▽, ∇, ∇∇)



④ $\frac{6}{4}$ ~ (▽, ∇, ∇∇)

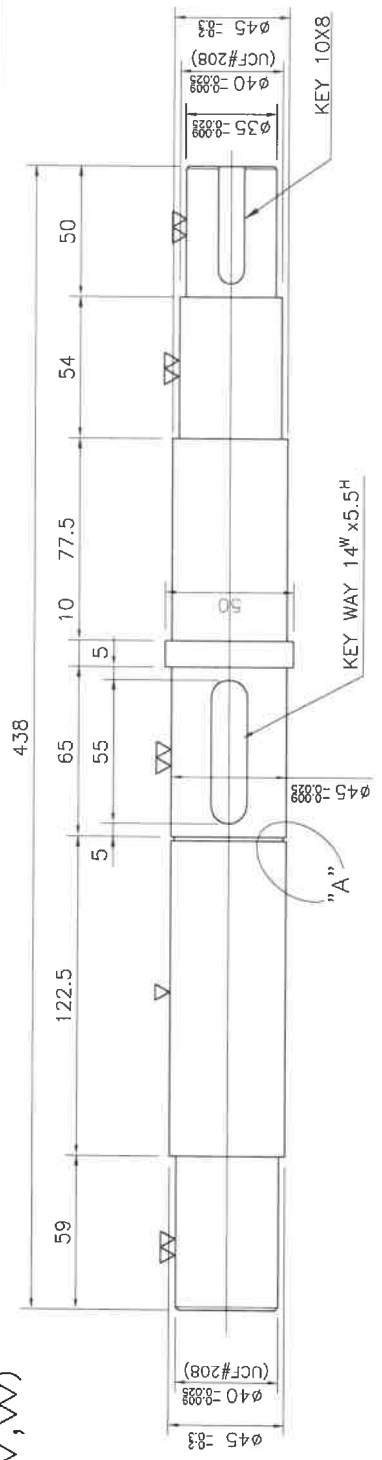


CLASSIFICATION	NAME	SIGN.	DATE	CLIENT
PREPARED				
CHECKED				
APPROVED				

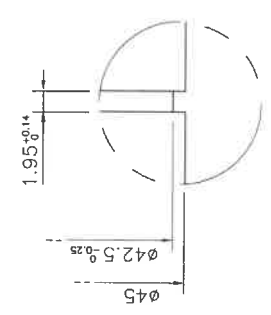
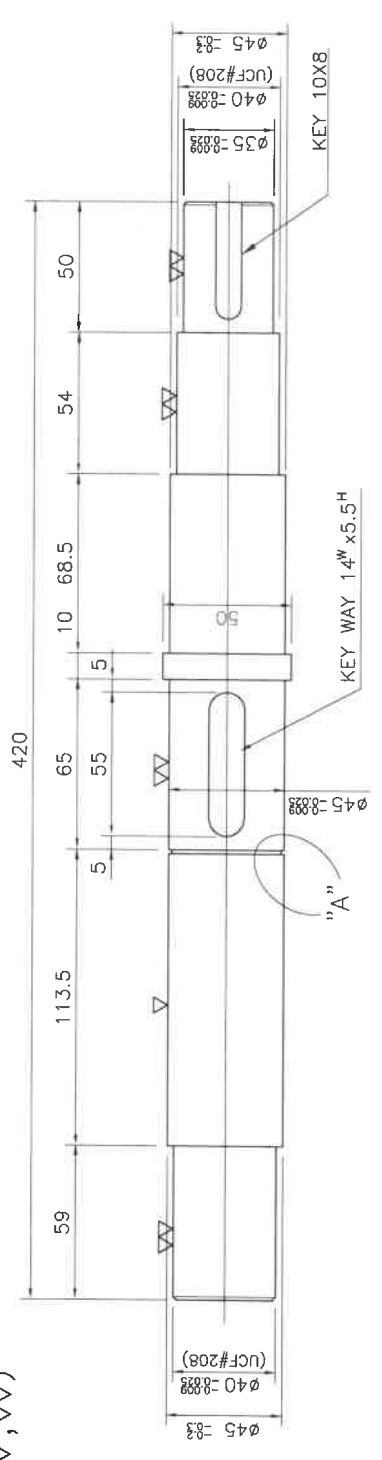
S E Y U		MODEL	SCREW SHAFT
		date	
		SCALE 1 : 1	WEIGHT
			SHEET OF SHEETS

No	ITEM	MATERIAL	QUANTITY
7/3	UPSIDE BUCKET SHAFT	S45C	1EA
7/4	UPSIDE BUCKET SHAFT	S45C	1EA

⑦/3 ~ (▽, ∇)



⑦/4 ~ (▽, ∇)



DETAIL "A" (S:2/1)

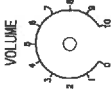
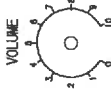
CLASSIFICATION	NAME	SIGN.	DATE	CLIENT
PREPARED				
CHECKED				
APPROVED				

MODEL	BUCKET SHAFT

SCALE	1:1	WEIGHT	date	SHEET OF	SHEETS

600

CONVEYOR TYPE SAND BLAST M/C

POWER LAMP	<input type="radio"/>	POWER OFF	<input type="radio"/>	MODE MANUAL	<input type="radio"/>	START	<input type="radio"/>	STOP	<input type="radio"/>	LAMP	<input type="radio"/>	EMERGENCY	<input type="radio"/>
CONVEYOR SPEED	<input type="text"/>	CONVEYOR ON	<input type="radio"/>	CONVEYOR OFF	<input type="radio"/>	DUST COLLECTOR	<input type="radio"/>	BUCKET	<input type="radio"/>	ROTARY VALVE	<input type="radio"/>	PULSE VALVE	<input type="radio"/>
VOLUME		AIR BLOW OFF	<input type="radio"/>	OSCILLATOR 1 OFF	<input type="radio"/>	VOLUME		SCREW	<input type="radio"/>	BLAST	<input type="radio"/>	BUZZER	<input type="radio"/>

UP SIDE BLAST

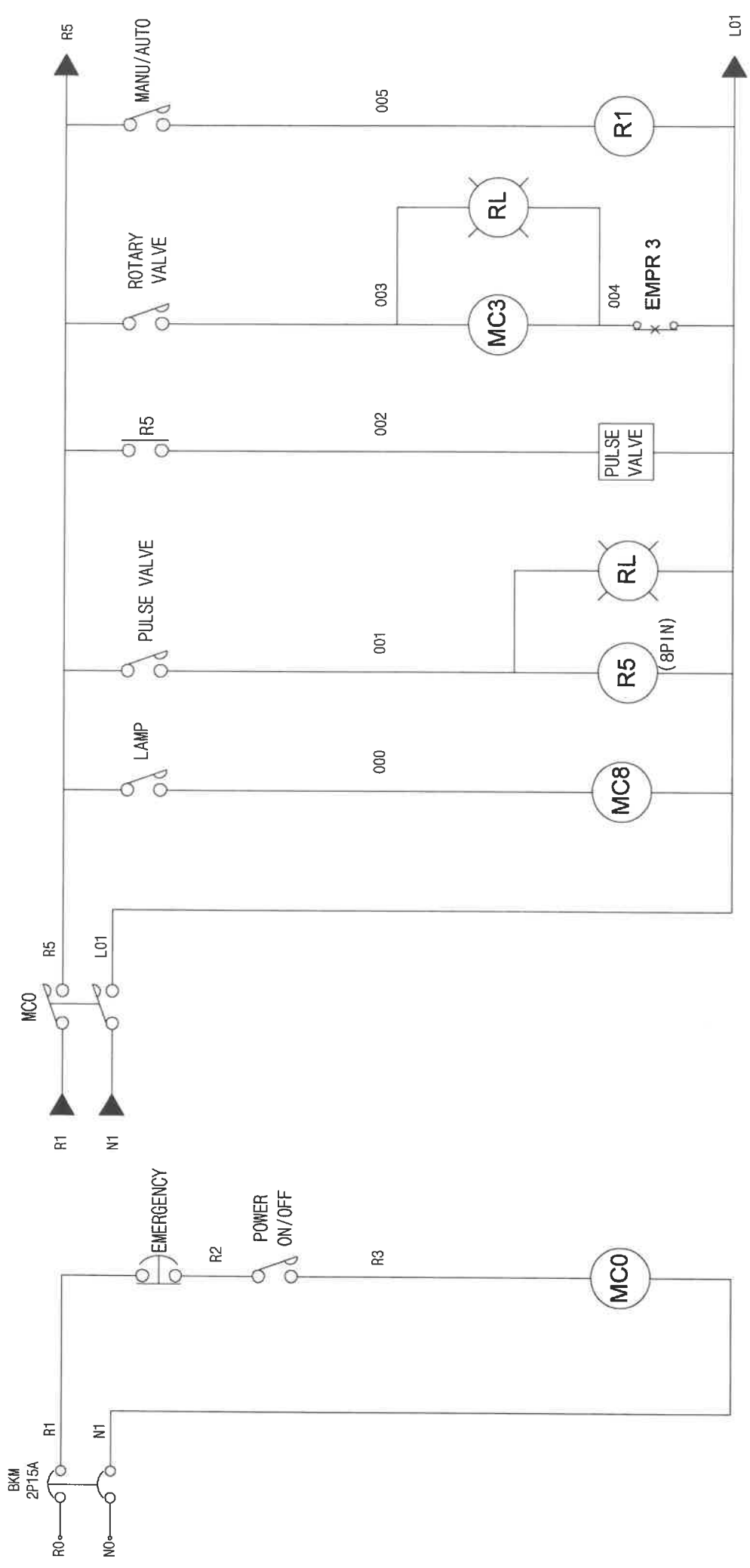
BLAST #1	<input type="radio"/>	BLAST #2	<input type="radio"/>	BLAST #3	<input type="radio"/>	BLAST #4	<input type="radio"/>	BLAST #5	<input type="radio"/>	BLAST #6	<input type="radio"/>	BLAST #7	<input type="radio"/>	BLAST #8	<input type="radio"/>	BLAST #9	<input type="radio"/>	BLAST #10	<input type="radio"/>	BLAST #11	<input type="radio"/>	BLAST #12	<input type="radio"/>
ON	ON	ON	ON	ON	ON	ON	ON	ON	ON	ON	ON	ON	ON	ON	ON	ON	ON	ON	ON	ON	ON	ON	ON
OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF

DOWN SIDE BLAST

BLAST #1	<input type="radio"/>	BLAST #2	<input type="radio"/>	BLAST #3	<input type="radio"/>	BLAST #4	<input type="radio"/>	BLAST #5	<input type="radio"/>	BLAST #6	<input type="radio"/>	BLAST #7	<input type="radio"/>	BLAST #8	<input type="radio"/>	BLAST #9	<input type="radio"/>	BLAST #10	<input type="radio"/>	BLAST #11	<input type="radio"/>	BLAST #12	<input type="radio"/>
ON	ON	ON	ON	ON	ON	ON	ON	ON	ON	ON	ON	ON	ON	ON	ON	ON	ON	ON	ON	ON	ON	ON	ON
OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF

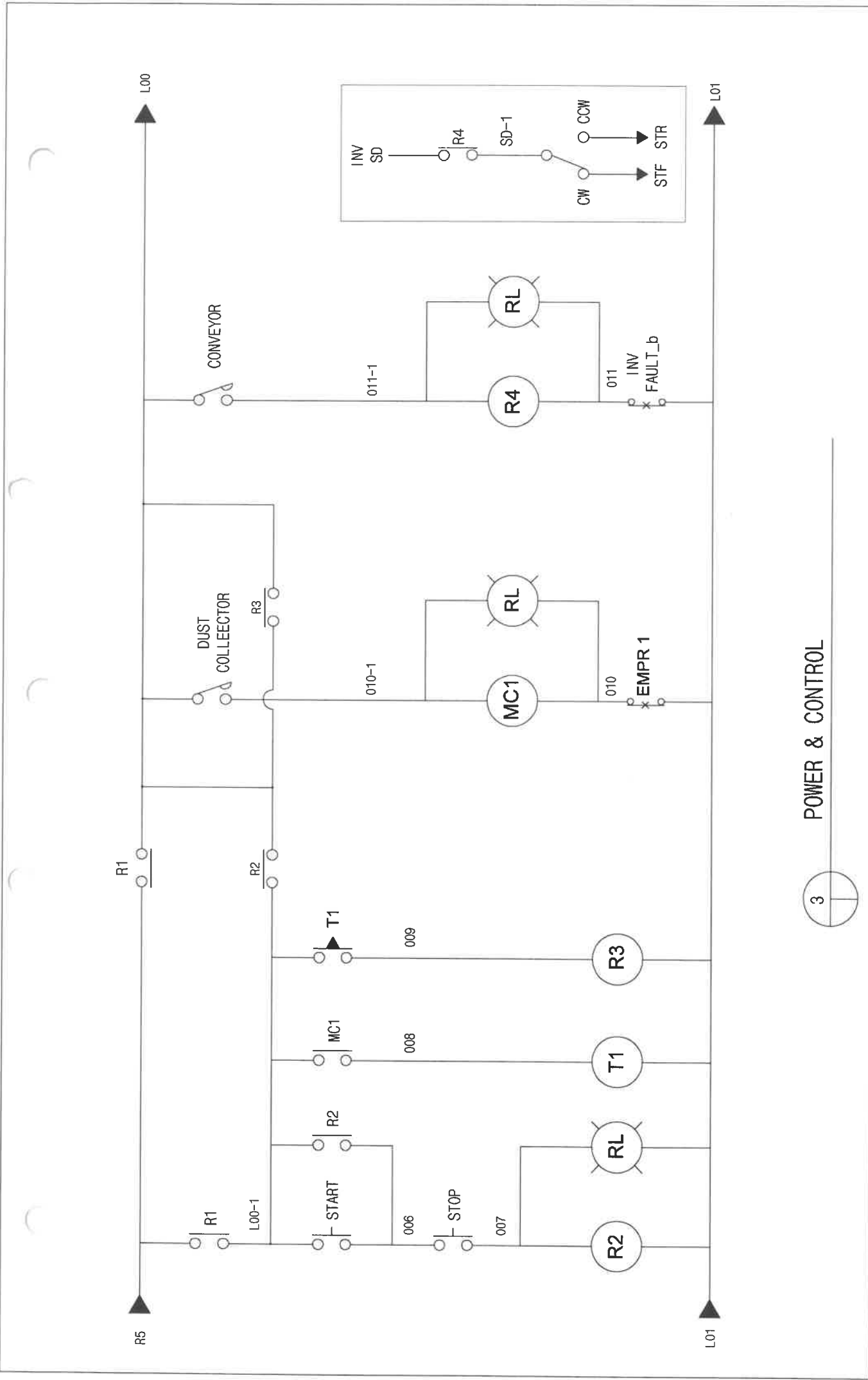
009

S E Y U	DESTINATION	NAME	SIGN.	DATE	CLIENT
	PREPARED				MODEL
	CHECKED				CONTROL PANEL
	APPROVED				date
					SCALE 1 : 1
					WEIGHT
					SHEET OF SHEETS

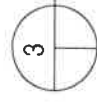


2 POWER & CONTROL

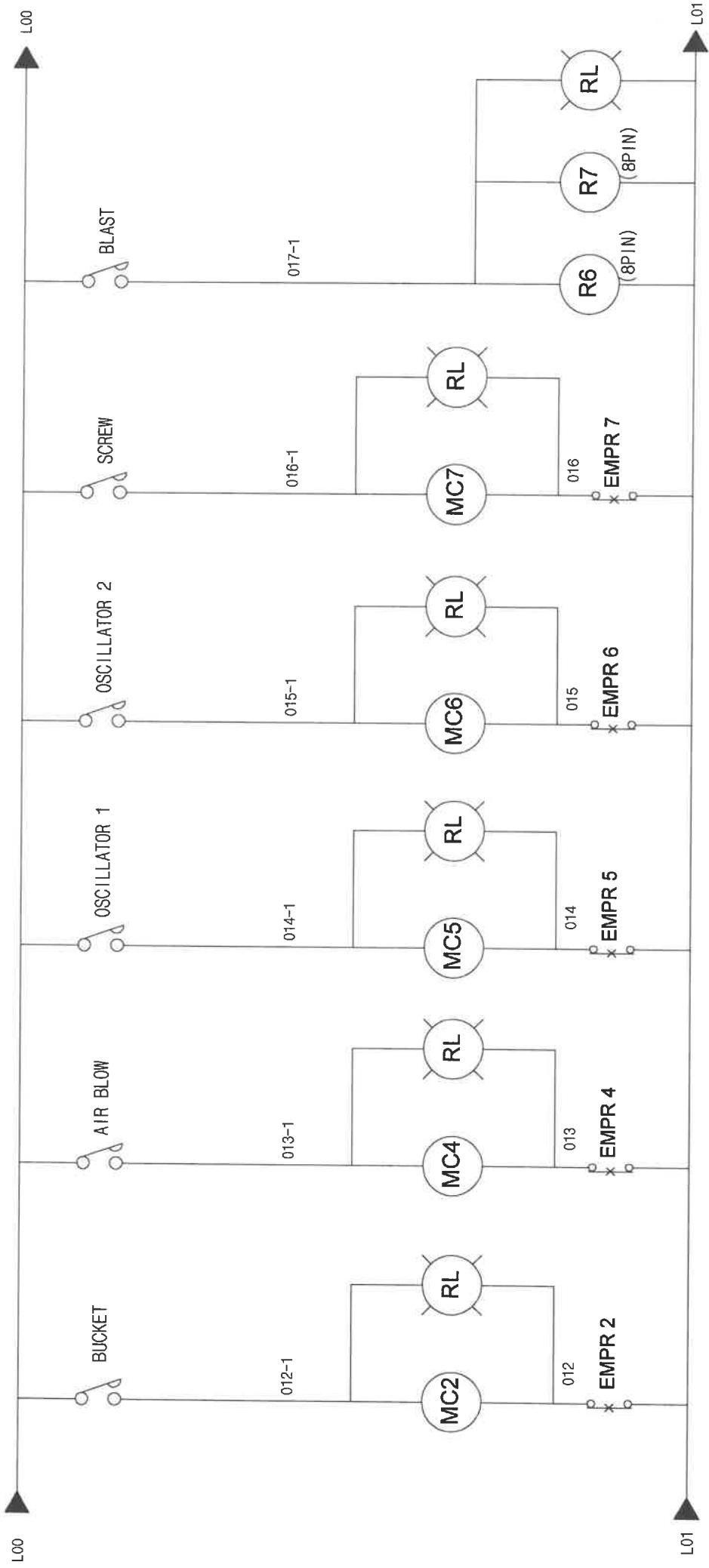
REV	DATE	DESCRIPTION	REV'D BY	CHK'D BY	APP'D BY	PROJECT	CONVEYOR TYPE SAND BLAST M/C	DRAW BY	DESIGNED BY	CHECKED BY	APPROVED BY	TITLE
C												HEATER PANEL
B												FILE NO
A												DWG NO
REV	DATE	DESCRIPTION	REV'D BY	CHK'D BY	APP'D BY			DATE	SCALE	UNIT	ANGLE	
									N.T.S	MM		



POWER & CONTROL



REV	DATE	DESCRIPTION	REV'D BY	CHK'D BY	APP'D BY	PROFECT	CONVEYOR TYPE SAND BLAST M/C	DRAY BY	DESIGNED BY	CHECKED BY	APPROVED BY	TITLE
C												HEATER PANEL
B												
A												
		SCALE		UNIT		ANGLE		DATE				FILE NO
		N.T.S		MM								DWG NO



POWER & CONTROL



REV	DATE	DESCRIPTION	REV'D BY	CHK'D BY	APP'D BY	PROJECT	CONVEYOR TYPE SAND BLAST M/C	DATE	SCALE	N.T.S	UNIT	MM	CHECKED BY	APPROVED BY	TITLE								
A															HEATER PANEL								
B																							
C																							
<table border="1" style="width:100%; border-collapse: collapse;"> <tr> <td style="width: 25%;">FILE NO</td> <td style="width: 25%;">ANGLE</td> <td style="width: 25%;">UNIT</td> <td style="width: 25%;">MM</td> </tr> <tr> <td style="width: 25%;">DWG NO</td> <td colspan="3"></td> </tr> </table>																FILE NO	ANGLE	UNIT	MM	DWG NO			
FILE NO	ANGLE	UNIT	MM																				
DWG NO																							

