

USER TIPS

I recently was involved with a used suction blast machine installation where the MagnaValves were located under the supply hopper which placed them below the nozzle level. This meant that the nozzle had to lift the shot approximately three feet (1 meter). The machine appeared to work well...at first. Later, two of the hoses were plugged full of shot. Investigation showed that one of the three nozzles had fairly high vacuum and the other two were somewhat less. Contributing to the problem was the shot left in transition at the end of the blast cycle would fall to the lowest hose level. This shot would then accumulate over ten or more machine cycles until the hose would plug full. The stronger suction nozzle was able to clear the accumulation in its line.

MORAL: Locate the MagnaValve (or any media regulator) above the nozzles so suction energy is not required to lift the shot.

While helping calibrate a shot peening machine by performing catch tests, I was surprised at such a low flow rate indication. The results of three consecutive tests were:

TEST	GRAMS	LBS
1	2017	0.91
2	1890	0.86
3	1896	0.86

Although the results looked credible, I doubted the accuracy. I suspected that the catch bucket was leaking during the test. Since the test was "at pressure" and the bucket was inside the cabinet with doors closed, direct observation was not possible. Consequently, I placed a plastic blanket on the floor of the cabinet. The flow rate was actually closer to 6 lbs/min and most of the shot was on the plastic sheet.

MORAL: Be cautious of your test methods even though results appear consistent.



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