



## **INTERNATIONAL MARKETING, INC. TECHNICAL BULLETIN**

**SUBJECT: Suggested Replacement Parts Schedule for 2020 Blaster**

**DATE: November 18, 2005**

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Note: Perform the maintenance per the Daily, Weekly, etc. found in the 2020 Blaster Manual, and perform the timely maintenance called out by the 2020 Blaster's Maintenance Timer via warning lights on the machine (check blades, belt, grease).

Good preventive maintenance and proper operation of the equipment is a presupposition for the parts replacement time frame listed below. If there is a scheduled timely replacement of wearable parts and continuous proper operation habits, the useful life cycle of shot blast equipment can be greatly extended. These time figures are also based on the usage of the IMI 2020 Shot Blast Blend.

### **DOOR**

**(Target Replacement of these items will be between 250-300 hours depending on proper operation and maintenance performance.) The rubber door liner and rubber seals are to be inspected on a daily basis and should be replaced upon any sign of wear or blast media leakage.**

DO-21	(Door liner retainer strip – 3 needed)
DO-34	(Rubber door liner – 1 per machine)
DO-35	(Top Door Seal – 1 per machine)
DO-36	(Door Track seal – 2 per machine)
DO-37	(Bottom door seal – 1 per machine)
WA400	(metal door liner – replaces the rubber door liner – optional)

### **MILL ROLLER**

**(Target Replacement of these items will be between 750-1000 hours depending on proper operation and maintenance performance.) Good daily inspection will help determine the replacement point. Whenever changing out a roller always replace the mill roller seal kits.**

MR-47	(Mill Roller seal kit – 2 per roller)
MRC	(Mill Roller assembly – front roller)
MRC-MNG	(Manganese Roller – back roller)
MRS	(Collar w/shield – 2 per roller)
MR-24	(Mill Roller Bearing – 2 per roller)

### **CABINET “CAST” LINERS**

**(Target Replacement of these items will be between 1000-1500 hours depending on proper operation and maintenance performance.) Proper adjustment of the blast pattern and regular addition of new media could allow these cast plates to last for thousands of hours.**

L-21	(Right top cabinet side liner – 8 x 12 – 1 per machine)
L-22	(Left top cabinet side liner – 6 x 12 – 1 per machine)
L-20	(12x12 cabinet side liner – 4 per machine)
L-16	(bottom pod liner 8.5 x 12 – 4 per machine)

## **TUNE UP KIT**

**(Target Replacement of these items will be between 1000-1500 hours depending on proper operation and maintenance performance.) Tune-up kits include blades, impeller, control cage, centering plate, centering bolt, feed spout seal.**

WE-57 (2 per machine) used with Leeson Motors w/ a tapped shaft for the impeller bolt  
WE-63 (2 per machine) used with Baldor Motors w/ a tapped centering plate for the impeller bolt .

## **WHEEL HOUSING LINERS**

**(Target Replacement of these items will be between 1500-2000 hours depending on proper operation and maintenance performance.) These needed to be checked closely during**

WE-05 (Cast End Liner – 4 per machine)  
WE-06 (Cast Top Liner – 2 per machine)  
WE-14 (Motor Side Liner – 2 per machine)  
WE-12 (Spout Side Liner – 2 per machine)

## **FILTERS (recommended replacement at 2000 hours)**

PI91889-461-436 (Ultra Web Filter – oval 1- 4 needed)  
WRPI48646461340 (Cartridge Filters for the TD486 Dust Collector – 9 needed)

Final Note of Importance: Record all maintenance performed on the machinery utilizing the hour meter reading on the blaster (the actual number must be multiplied by 10. For Example: A 342 hour meter reading would actually be 3,420 hours). This should be kept in a permanent maintenance log with all entries including the following information. Date maintenance performed, the hour meter reading, description of the maintenance performed, parts used and signature of the one performing the maintenance.

**Questions regarding the above technical bulletin may be directed to:**

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