

SUCCESSFUL SODA BLASTING

Blasting with soda and soda-blasting machines is a different process than blasting with standard “sand” blasting media and equipment. The following steps outline the soda blasting process and will serve as a general guide to successful soda blasting.

- 1 SUPPLY THE EQUIPMENT WITH CLEAN, COOL & DRY AIR AT 90-150 PSI.**

Moisture in the air supply will cause the blasting media to clump causing blockages and costly downtime. It is highly recommended that an air dryer be used to ensure moisture does not enter the blasting equipment.
- 2 USE A SCREEN.**

Foreign materials (including pieces or the bag the soda is packaged in) will clog the metering valve resulting in costly down time. Always pour the blasting media through the included screen to prevent foreign materials from entering the equipment.
- 3 FULLY OPEN THE METERING VALVE.**

When using the soda machine with a mutiport fixed orifice sleeve (equipped this way from the factory) it is important to blast with the metering valve completely open. (This is factory set)
- 4 SET THE REGULATOR.**

While a supply of at least 50 PSI is recommended to operate the Soda Blaster, soda Blasting is usually performed at a lower pressure. Use the included regulator to lower the blasting pressure to the desired PSI using procedures described in the “Operating Procedures” section of the manual.
- 5 USE THE VIBRATOR.**

The vibrator aids in the flow of soda through the abrasive timer. Open the Vibrator Activation Valve 1/4 to 1/2 turn to activate the vibrator.
- 6 SET DIFFERENTIAL PRESSURE.**

Differential pressure (slightly increased pressure in the pressure vessel) helps to “push” soda through the small orifices of the Multi-Port Fixed Orifice sleeve in the metering valve. Differential pressure is achieved by partially closing the Differential Pressure Gate Valve until the Differential Pressure Gauge reads 2-4 PSI lower than the Vessel Pressure Gauge when Blasting. See the “Operating Procedures” section of the manual for more details.
- 7 CHECK AND ADJUST FLOW-RATE USING “BAG TEST” METHOD.**

Setting-up soda blasting equipment to achieve an optimal flow rate is essential for getting efficient productivity from the soda you have purchased. Operating soda blasting equipment that is set-up with a flow rate that is too high or too low will result in poor performance and an expensive waste of blasting soda. See the “Successful Soda Blasting - Achieving Optimal How Rates” section of the manual for details on checking and adjusting the flow rate.
- 8 USE A WATER INDUCTION NOZZLE TO REDUCE DUST.**

By using a water induction nozzle such as the WIN System, the amount of air-born dust will be reduced when blasting with soda. (see the “Blasting Set-up” section of the manual WIN System information)