

HYDRO HONE

Installation * Operation * Maintenance * Replacement Parts

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INSTALLATION

- 1.0 Locate your Hydro Hone machine as close as possible to plant compressed source.
 - 1.1.1 Be sure air line bringing compressed air to the Hydro Hone is large enough not to starve the machine. Connect air supply to pipe marked "air." 3/4" pipe if less than 10 feet from compressed air source, 1" pipe if more than 10 feet, but less than 20 feet, 1-1/4" pipe if over 20 feet to source.
- 1.2 Allow ample room for the blast cabinet door to open and for loading and unloading.
- 1.3 Plumb plant watermarked "water." This water can be used for filling Hydro Hone as well as a supply for the window wash spray.
- 1.4 If possible, vent the exhaust blower outside. This will avoid increasing the humidity in the plant area because of exhausted water vapor.

OPERATION

2.0 OPERATION:

2.1 Charging the machine with slurry.

2.1.1 First place proper amount of water in machine hopper:

Model 12 = 3 Gallons
Model 25 = 7 Gallons
Model 36 = 10 Gallons
Special Machine =

2.1.2 Turn slurry pump "on."

2.1.3 Slowly pour proper amount of desired abrasive into machine hopper:

Model 12 = 1 Gallon
Model 25 = 2 Gallons
Model 36 = 3 Gallons
Special Machine =

2.1.4 If it is necessary to prevent rusting of parts that are to be treated, add proper amount of Hydro formula 123 Rust Inhibitor:

Model 12 = 1/2 Cup
Model 25 = 1 Cup
Model 36 = 1-1/2 Cup
Special Machine =

OPERATION

2.0 OPERATION:

- 2.2 Be sure the machine is charged with proper amount of water and abrasive.
- 2.3 Turn cabinet lights and slurry pump "on."
- 2.4 Place parts to be cleaned or finished in blast chamber and close door.
- 2.5 Reach through gauntlet openings and place rubber gloves into hands.
- 2.6 Hold part in left hand, grasp blast gun in right hand.
- 2.7 Turn compressed air "one" by pressing foot switch to first position.
- 2.8 Direct blast at part, move gun slowly and in an organized pattern over the part.
- 2.9 Wash window as needed by pressing foot switch to second position.
- 2.10 To turn air "off." Touch kick plate with toe, this will release foot pedal from the "air on" position.

OPERATION

3.0 DAILY START-UP CHECK:

- 3.1 Check water for proper level in hopper (add or remove as necessary)
- 3.2 Turn left panel switch "on."
- 3.3 Fill glass container from blasting gun, allow abrasive to settle. Mixture should be at least 25% Abrasive. Add abrasive as needed.

4.0 CHANGING ABRASIVES:

- 4.1 Turn machine "on."
- 4.2 Place blasting gun in 2 gallon container outside cabinet.
- 4.3 Wash cabinet interior thoroughly with fresh water and hose while abrasive is being pumped out.

OPERATION

5.0 **IMPORTANT:**

5.1 Remove air filter from upper rear of machine and wash after 8 hours of operation.

5.2 If visibility in cabinet becomes bad, wash filter more frequently. Wash it with a sponge in clean water.

5.3 Keep window wash drain troughs free of abrasives.

MAINTENANCE

6.0 MAINTENANCE:

- 6.1 The schematic drawing in this manual indicates the parts that may require adjustment, service, or replacement.
- 6.2 The pump has no bearings and need not be lubricated. The electric motor has sealed ball bearings.
- 6.3 The blower motor requires no lubrication. The motor has sealed ball bearings.
- 6.4 High wear items are the abrasive guns, hoses, gauntlets, gloves and the viewing window.
- 7.0 **BE SURE THE SMALL PARTS SCREEN IS KEPT IN THE MACHINE HOPPER!**
- 7.1 The small parts screen is extremely important. 95% of all immediate problems or future problems can be traced to the fact that the small parts screen has been removed.
- 7.2 **EXERCISE CARE WHEN REMOVING THE SMALL PARTS SCREEN. DO NOT TIP OR PULL TOO FAST SO THAT THE SLURRY WILL WASH THE SCREEN PARTICLES OFF INTO THE HOPPER!**

MAINTENANCE

8.0 **SLURRY PUMP:**

8.1 The slurry pump is designed to operate with a definite proportioned mixture of water and abrasive. When too many particles or different size enter the system, the following problems can be expected:

8.2 Abrasive or slurry hose becomes clogged:

If this occurs, remove hose and flush.

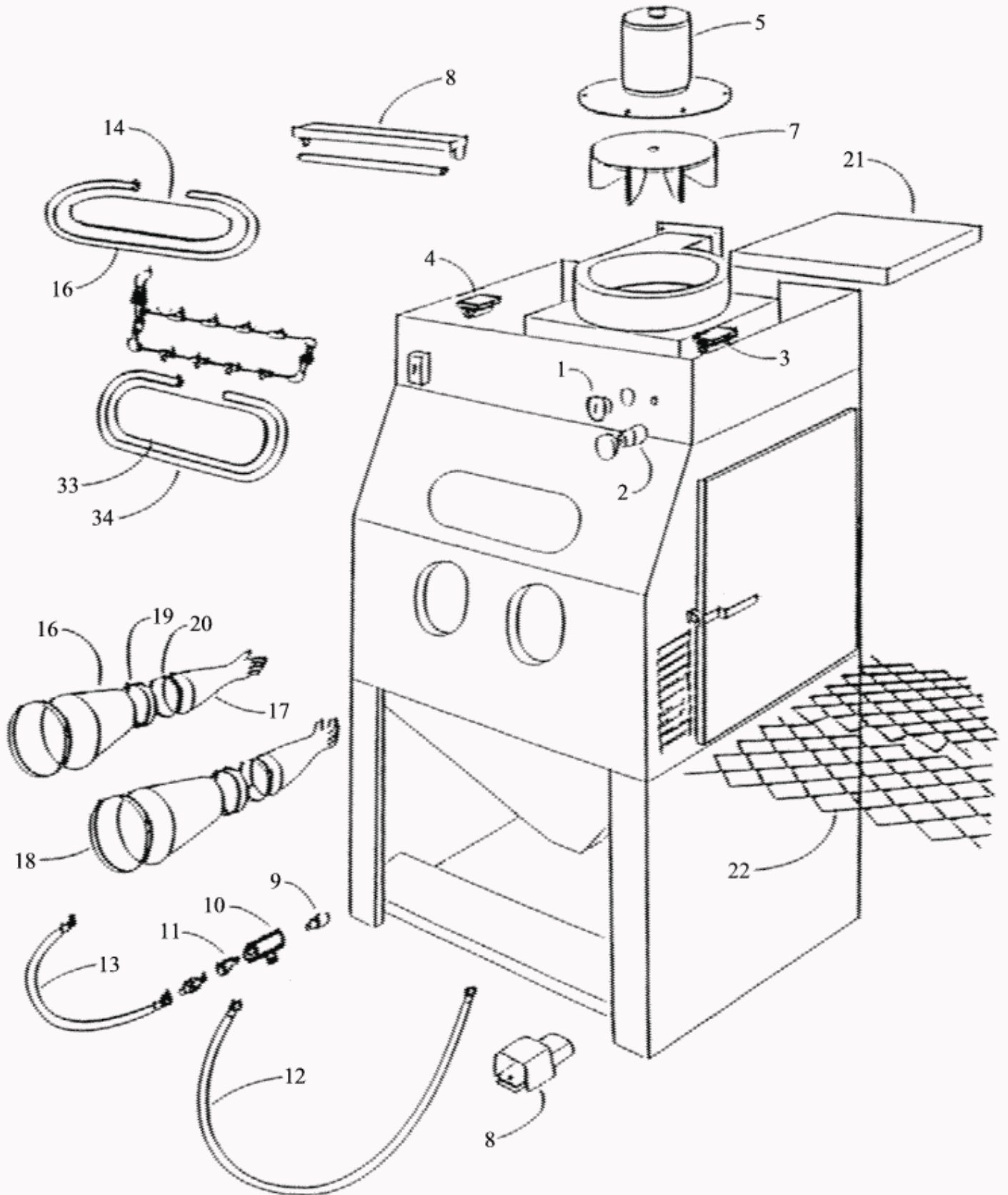
8.3 Pump fails to deliver abrasive:

The foreign particles have settled in the volute of the pump and no room remains in the slurry. Unbolt the volute and remove the foreign particles. Check the impeller blades. The slurry will eventually wear these blades, due to the abrasive quality of the material being pumped.

8.4 Another cause of pump failure can be foreign objects logged in the pump intake. Check and remove.



REPLACEMENT PARTS LIST		DATE: 7 - 86
HYDRO - HONE		REVISION:
UNIT: CABINET	MODEL: 12 - 25 - 36	



REPLACEMENT PARTS LIST

UNIT:	HYDRO HONE
MODEL:	12

ITEM	PART NO.	DESCRIPTION
1	1000A	2" AIR GAUGE
2	1001B	1/2" AIR REGULATOR
3	1002C	1/2" AIR SOLENOID VALVE
4	1002C	1/2" WATER SOLENOID VALVE
5	6K005	1/3 HP 1725 RPM MOTOR
6	2007D	LINE MASTER D SWITCH
7	3005A	9-1/4" IMPELLER
8	4005A	LIGHT FIXTURE
9	5003A	1/4" CARBIDE NOZZLE
10	5002C-1	ALUMINUM GUN BODY
11	5004A	1/8" AIR JET
12	5006B-37	3/8" X 37" ABRASIVE HOSE, 2 FITTINGS
13	5007A-27	1/4" X 27" AIR HOSE, 2 FITTINGS
14	6000B	19-13/16" X 5-3/4" LIGHT WINDOW
15	6002A-52	52" RUBBER MOLDING
16	6003A	GAUNTLETS
17	6005A	RUBBER GLOVES
18	6009C	GAUNTLET CLAMP
19	6006A	GLOVE RINGS (OPTIONAL)
20	6009A	GLOVE CLAMP
21	6011D	1" X 11" X 11" FOAM FILTER
22	6008G-1	WORK GRATE
23	6K005	1/3 HP 1725 RPM MOTOR
24	5014B-1	RISER, FLANGE & VOLUTE
25	5014B-2	PUMP BOTTOM COVER
26	5014B-3	PUMP GASKET
27	5014B-4	PUMP SHAFT & IMPELLER
33	6000A-1	16-3/8" X 9-1/8" VIEW WINDOW
34	6002A-52	52" RUBBER MOLDING

OPTIONS

012A-1	1/4" CARBIDE GUN, COMPLETE
014A	PUMP WITH MOTOR

REPLACEMENT PARTS LIST

UNIT:	HYDRO HONE
MODEL:	25

ITEM	PART NO.	DESCRIPTION
1	000A	2" AIR GAUGE
2	1001B	1/2" AIR REGULATOR
3	1002C	1/2" AIR SOLENOID VALVE
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5	6K005	1/3 HP 1725 RPM MOTOR
6	2007D	LINE MASTER D SWITCH
7	3005A	9-1/4" IMPELLER
8	4005B	LIGHT FIXTURE
9	5003B	3/8" CARBIDE NOZZLE
10	5002C-1	ALUMINUM GUN BODY
11	5004B	3/16" AIR JET
12	5006A-60	1/2" X 60" ABRASIVE HOSE, 2 FITTINGS
13	5008A-40	1/2" X 40" AIR HOSE, 2 FITTINGS
14	6000B	19-13/16" X LIGHT WINDOW
15	6002A-52	52" RUBBER MOLDING
16	6003A	GAUNTLETS
17	6005A	RUBBER GLOVES
18	6009C	GAUNTLET CLAMP
19	6006A	GLOVE RING (OPTIONAL)
20	6009A	GLOVE CLAMP
21	6011E	2" X 15-3/4" X 19-5/8" FOAM FILTER
22	6008H	WORK GRATE
23	2001B	1-1/2 HP 1725 RPM MOTOR
28	5015B-1	RISER WITH TOP & BOTTOM FLANGES
29	5015B-5	PUMP VOLUTE
30	5015B-6	PUMP GASKET
31	5015B-7	PUMP SHAFT
32	5015B-8	PUMP IMPELLER
33	6000C	23-3/4" 8-3/16" VIEW WINDOW
34	6002A-62	62" RUBBER MOLDING

OPTIONS

5012A-2	3/8" CARBIDE GUN, COMPLETE
5015A	PUMP WITH MOTOR

REPLACEMENT PARTS LIST

UNIT:	HYDRO HONE
MODEL:	36

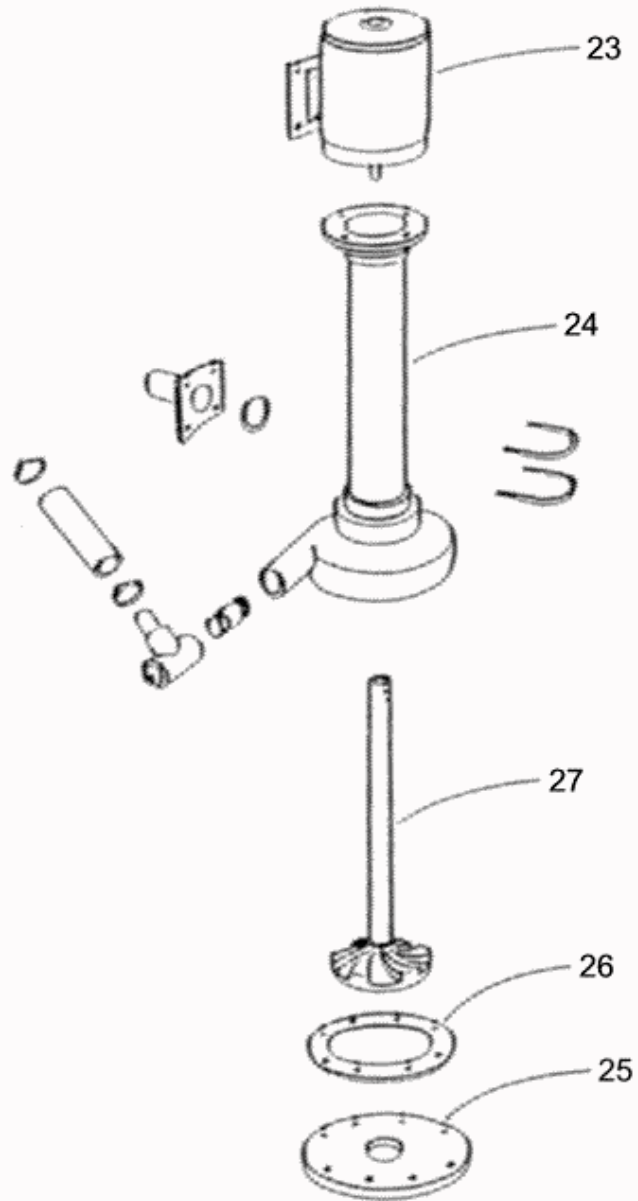
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OPTIONS

5012A-2	3/8" CARBIDE GUN, COMPLETE
5015A	PUMP WITH MOTOR



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HYDRO - HONE		REVISION:
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REPLACEMENT PARTS LIST		DATE: 7 - 86
HYDRO - HONE		REVISION:
UNIT: PUMP	MODEL: 25 - 36	

