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OPERATING INSTRUCTIONS FOR THE
CONTINUOUS DUSTLESS SPRAYING
"LIMPET" ASBESTOS SPRAY MACHINES.

The purpose of this latest type of spray machine is to introduce an amount of finely atomized water into the Asbestos fibre in order to damp down the fine dust caused by the spraying process, and thus create better working conditions for the operator and those around him. It is therefore of vital interest to the operator personally to become thoroughly familiar with the working of the damping system.

The first thing to be realized is "that only the barest minimum of water should be introduced into the fibre". Excess of water causes the fibres to adhere one to the other and so produce choking in the fan or duct, which in turn creates an uneven fibre stream at the gun.

The quantity of water issuing from the five damping jets is controlled by the amount of air that is allowed to issue from the connection near the pneumatic clutch control, to the damping nozzle via the "air control valve". This is regulated by means of the knurled turnscrew on the valve, and it is important to realise that when the screw is turned clockwise as far as possible, no air is being passed and therefore no water, and the machine is operating exactly as the original models, and dry fibre is being passed to the gun.

From the full "off" position only 3 anti-clockwise revolutions of the screw are required to bring the air, and thus the water, to full "on", so that it will be realised that care must be taken in the setting of this screw down valve. As a rough guide the following settings are appropriate:-

A.340 Fibre	One quarter of a turn from "full off"
R.B.2 Fibre	One half " " " " "
R.S.2 Fibre	One half turn from "full off".
A.M.2 Fibre	One turn from "full off".

It must be stressed that each job will vary in the amount of damping required, and the rule to remember is "always as little as possible" and the better the finished surface of the sprayed Asbestos, the smaller is the amount of water allowable.

The next item requiring attention is the fan duct, and this must be kept smooth and free from rust by applying machine oil and graphite regularly. The method of application is to spread a little oil on to a cloth, dip this into a box containing graphite, and then rub the inside surfaces of the duct.

If the fibre has been over damped, it will be found that the blades of the fan impellor have collected fibre on their edges, and this causes bad spraying. To remove the fibre, all that is necessary is to release the wing nut holding the guard plate over the open end of the fan duct, and swing the plate downwards so that the hand can be inserted in the duct to clean the blades. It is the best to do this at the end of each day, so that there is no possibility of the fibre becoming set.

During the operation of the machine, it is of the utmost importance to make absolutely certain that the machine is never emptied of fibre as the damping spray will be allowed to impinge on the creeper belt and saturate it, thus doing much damage to the fabric of the belt, and what is just as serious, forming a medium for dust and fibre to adhere to the sheet and set hard, almost like cement. If, by chance, this does happen, the only thing to do is to clean the belt and allow it to dry out over night, making a check on it the next morning.

It has always been policy with the original machines to clean the surfaces of the drums driving the creeper belt, and the inside of the belt once a week to avoid hard lumps of fibre building upon them. This operation must not be neglected on the continuous dustless machine and, in addition, the side sheets and the guides for the creeper belt should be removed, and the latter thoroughly cleaned and given a coat of graphite each week.

If it is necessary to test the efficiency of the five jets on the damping nozzle, a piece of stout brown paper should be held under the nozzle to catch the water, before starting up the machine. Only run the machine for such a time as is necessary to see whether the jets are operating.

IMPORTANT. At the end of each day's spraying, the air control valve should be completely closed, and the machine, without fibre, run for a few minutes to thoroughly clean the brushes and the creeper belt.

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