



SERVICE MANUAL 2-30DS Global

VERSION 3.3



Inspection comments

Inspection before initial operation on:	_____
By:	_____
Date of initial operation:	_____
Serial number & Year of manufacture:	_____

Recurring inspections / maintenance log

Date	Findings	Repairs / Cleaning	Test on	By*

*competent person



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1. Spare parts

Fig. 01 Blasthousing

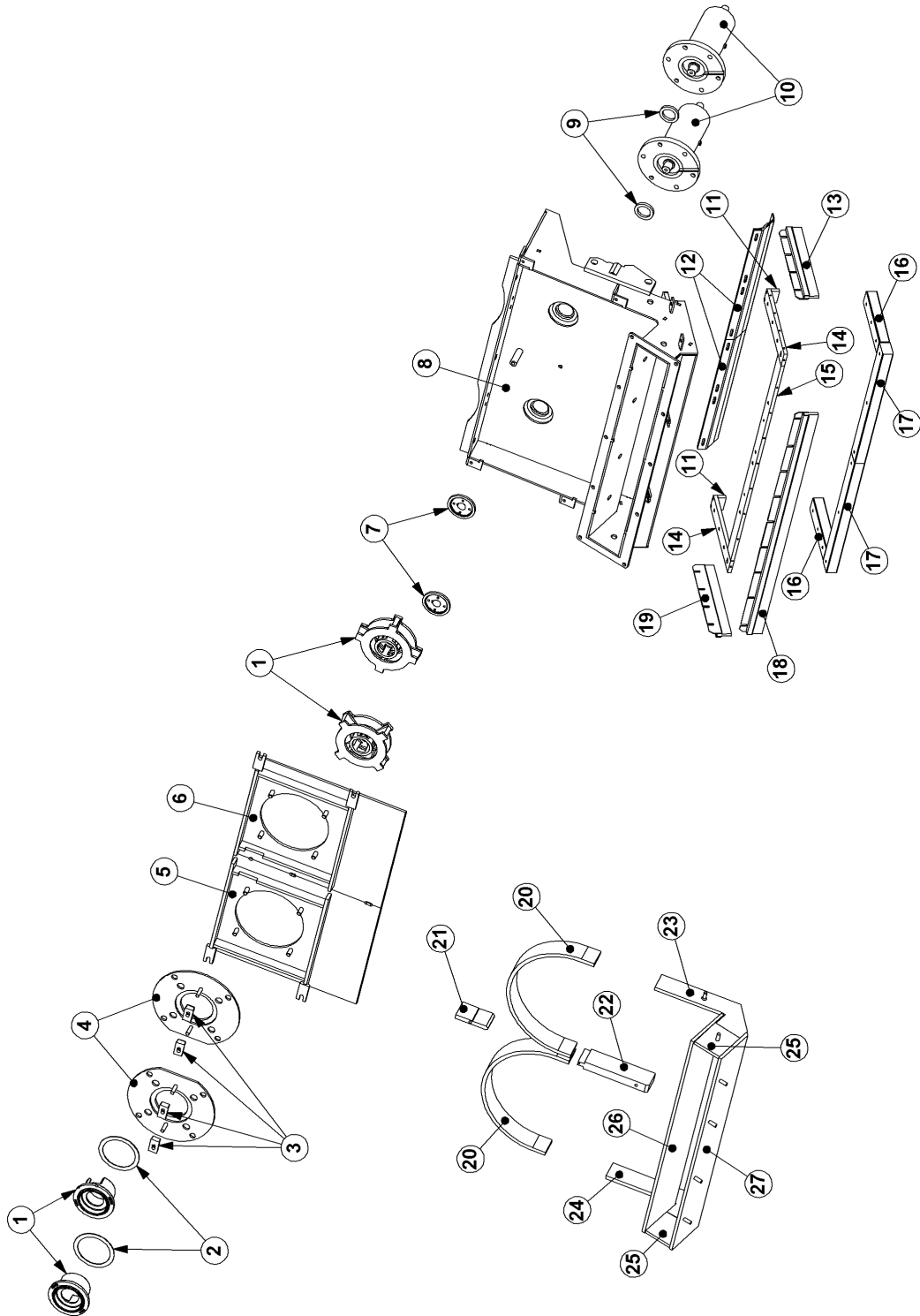




Fig. 01 Blasthousing

Item	Part number	Husqvarna Part Number	Description	Qty.
1	B20536K	531459001	Tune up kit	2
2	972781	534411101	Control cage shim	2
3	969803	534410801	Control cage clamp	4
4	979644	534340601	Blastwheel cover plate	2
5	B22009	534594201	Front plate LH	1
6	B22010	534594301	Front plate RH	1
7	B20397	533762001	Hub	2
8	E07038	534015701	Blast housing	1
8+5+6	E08757	534055501	Blast housing incl. front plates	1
9	B20295	533442501	Felt seal Ø60x8	2
10	E00842	533807401	Bearing unit complete	2
11	481350	534857401	Spacer side magnet rear	2
12	E07577	533743001	Skid seal UNI	2
13	E00457	533805801	Side brush RH	1
14	489945	534644801	Insulator side	2
15	B20806	534593601	Insulator front	1
16	490047	534697301	Magnet side	2
17	B20804	534696701	Magnet front	2
18	B20816	534595101	Front brush	1
19	E00458	533806501	Side brush LH	1
20	B20907	533611101	Top liner	2
21	B21068-2	533614001	Center liner top part	1
22	B21068-1	533727501	Center liner bottom part	1
23	B20395	533722401	Side liner right hand	1
24	B20394	533713101	Side liner left hand	1
25	970153	533572901	Plenum bottom side liner	2
26	B20815	534766701	Plenum liner top	1
27	B20814	534765301	Plenum liner bottom	1

Fig. 02 Wheel and motor bracket

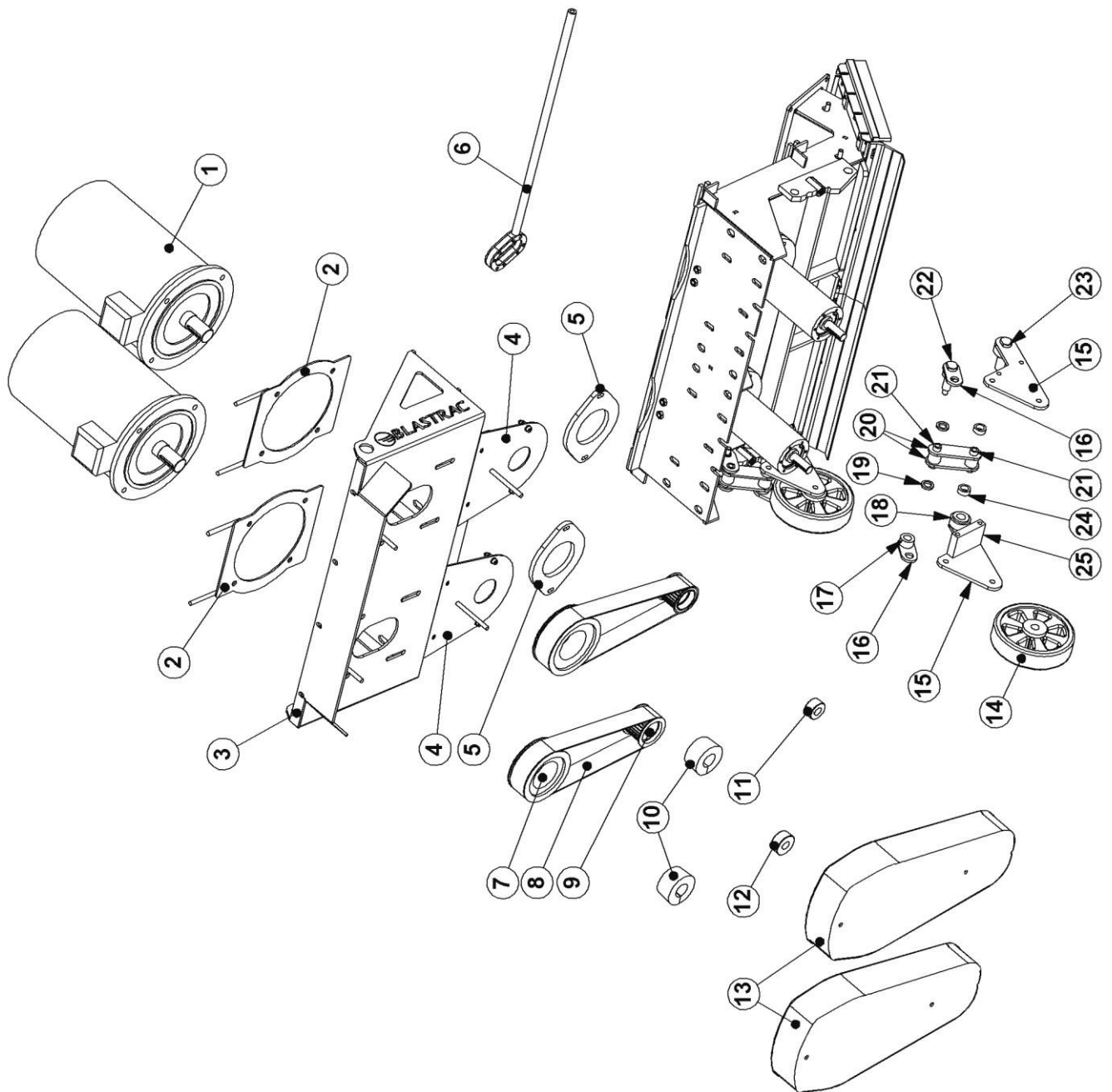


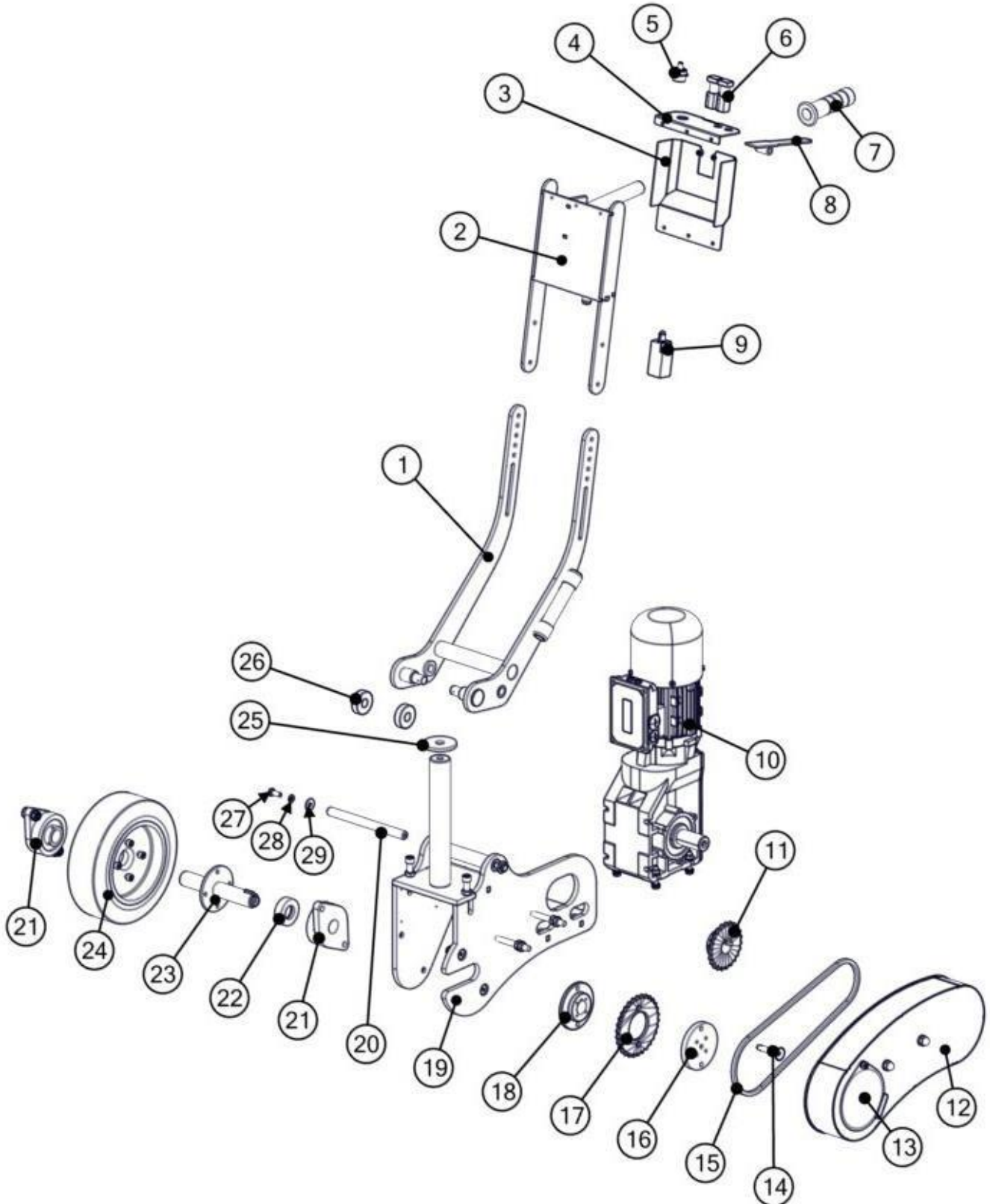


Fig. 02 Wheel and motor bracket

Item	Part number	Husqvarna Part Number	Description	Remarks	Qty.
1	E06511-IE2	533724201	Blastmotor 15 kW		2
2	E06513	533725901	Fill up plate blastmotor		2
3	E07015	535213001	Motor bracket		1
4	E07037	533112101	Back plate		2
5	E06940	531484801	Dust plate		2
6	B21917	531472201	Lever		1
7	B20429-1	535715301	Pulley	50Hz	2
	B21340	533695601	Pulley	60Hz	2
8	B20428	533471901	Belt	50Hz	2
	E04009	533843101	Belt	60Hz	2
9	B20430-1	535715501	Pulley	50Hz	2
	B21341	533697901	Pulley	60Hz	2
10	E00425	533378101	Taperlock	50/60Hz	2
11	222-2172-V	533782401	Taper lock	50Hz	2
12	B21342	533599201	Taper lock	60Hz	2
13	B20224ST	534322501	Belt guard		2
14	B20842	533845201	wheel		2
15	E06465	533721101	Wheel bracket side plate		4
16	E06467	533470801	Top lever		4
17	E06474	533264801	Lever bush top		4
18	E06472	533733701	Wheel bracket bush		4
19	E06855	533513501	Lever bush middle		4
20	E06466	533212001	Bottom lever		4
21	E06471	533540001	Lever shaft		4
22	E06469	533220401	Top bolt		2
23	E06468	533212101	Bottom bolt		2
24	E06473	533483201	Lever bush bottom		4
25	E06475	533318701	Distance plate		2



Fig. 03 Drive wheel
From serial number 34020B & up





**Fig. 03 Drive wheel
From serial number 34020B &
up**

Item	Part number	Husqvarna Part Number	Description	Remarks	Qty.
1	E10579	534042501	Handle lower part		1
2	E06143	534031901	Handle top part		1
3	E00740	533241401	Control box		1
4	E00741	533571401	Control box top plate		1
5	E00866	533613001	Potential meter complete		1
5.1	E00866/1	533963001	Potmeter only with soldered		1
5.2	E00866/2	533994301	Potmeter holder only		1
6	E00867	533850701	Switch		2
7	453290	534612901	Handle grip		1
8	E00743	533783701	Switch lever		1
9	454796	534668101	Limit switch		1
10	E00664-2/120Hz	534439301	Drive motor 1,1 kW		1
	E19084	534566701	Fan 1,1kW 120Hz		1
	E19085	534567001	Fan cover 1.1kW 120Hz		1
	E19083	534365601	Brake complete		1
11	B21311-1	534862901	Sprocket		1
12	E00744	533068001	Chain guard		1
13	979971	534387301	Cover plate chain guard		1
14	478198	533256401	Quick release pin		1
15	E00237	534024703	Chain		0.9m
15.1	E00238	533930301	Chain link		1
16	477630	534863101	Sprocket retainer		1
17	477631	534640601	Idler sprocket		1
18	488551	534642001	Hub		1
19	E14626	534528201	Drive wheel bracket		1
20	E15554	534681501	Locking shaft		1
21	976682	531474201	Bearing drive wheel		2
22	E07293	533318901	Distance bush drive wheel		1
23	E00742	533956301	Drive wheel shaft		1
24	476405	534907101	Traction wheel		1
25	971860	533843701	Washer for yoke shaft		1
26	B20517	533809801	Bearing		2
27		#N/A	M8x20 Hex bolt		2
28		#N/A	M8 Spring lock washer		2
29	BE0318	533821001	M8 Washer 3xd		2

Fig. 04 Separator and rebound

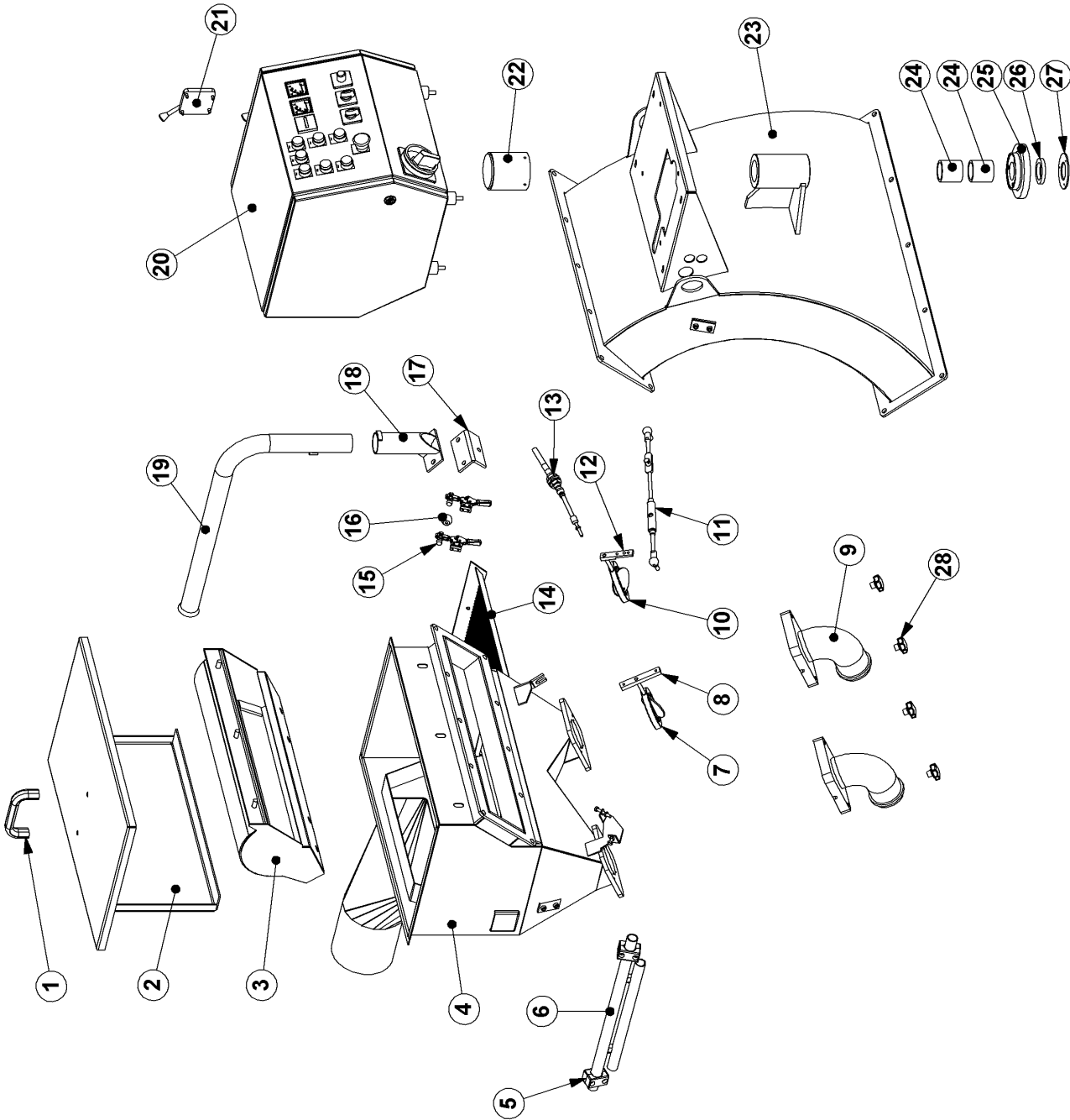
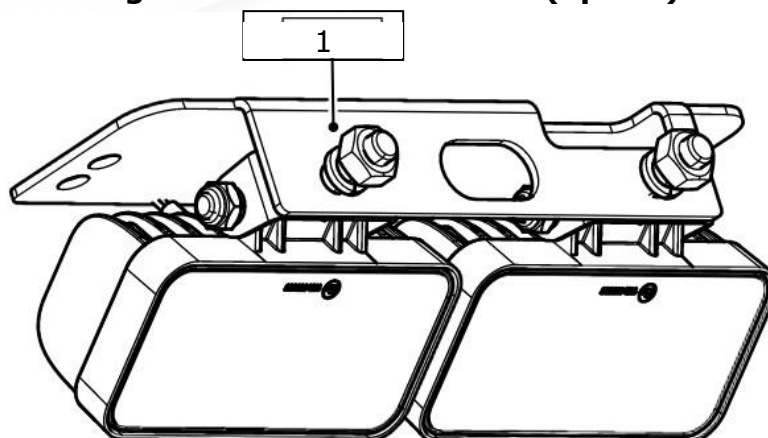


Fig. 04 Separator and rebound

Item	Part number	Husqvarna Part Number	Description	Qty.
1	970385	533170201	Handle	1
2	B20793	533256301	Separator cover	1
3	B20821	534435001	Deflector	1
4	B20819	535239001	Separator	1
5	DG39	533414301	Pipe clamp Ø25	2
6	E00914	535146701	Cable tube	1
7	B21295	533406601	Magnetic valve assembly	1
8	B21326	534664001	Lever magnetic valve long	1
9	970192	533910601	Feed spout	2
10	B21295R	533437701	Magnetic valve assembly	1
11	B20862	533555701	Turnbuckle	1
12	B21296	534663901	Lever magnetic valve	1
13	B20520	533879301	Control cable	1
14	B20820	534829201	Separator tray	1
15	001084	534391301	Clamp for separator tray	2
16	B21325	533592601	Ball head for separator	1
17	B21384	535272701	Cable pillar bracket	1
18	B20426	533718101	Cable guide support	1
19	B20425	533622401	Cable guide	1
20	E00124-1	534546501	Elektro box 2-30	1
21	B20519	533839501	Cable control unit	1
22	B20515	533224801	Shaft cover	1
23	B20818	534794601	Rebound plenum	1
24	971341	533194601	Oilite bush	2
25	B20511	533783501	Lifting plate	1
26	B20295	533442501	Felt seal	1
27	B20512	533783201	Seal retainer	1
28	000213	533656201	Clamp knob M8	4

Fig. 05 LED kit E14819 (option)



Item	Part number	Description	Qty.
1	E14819	LED light set for shot blasters	1



2. Maintenance box complete 000153 2-30DS 50Hz

Item	Part number	Husqvarna Part Number	Description	Qty.
1	001071	#N/A	Metal box	1
2	B20394	533713101	Side liner LH	1
3	B20395	533722401	Side liner RH	1
4	B21068	535361001	Center liner	1
5	B20907	533611101	Top liner	2
6	B20536K	531459001	Tune up kit	6
7	B20520	533879301	Control cable	1
8	E07577	533743001	Skid seal UNI	2
9	E00457	533805801	Side strip brush RH	1
10	E00458	533806501	Side strip brush LH	1
11	B20816	534595101	Front strip brush	1
12	B20428	533471901	HTD belt	2
13	001017	535752901	Open-end spanner 10 x 11	1
14	001018	535753001	Open-end spanner 13 x 15	1
15	001019	535753101	Open-end spanner 17 x 19	1
16	B21334	535783101	Open-end spanner 24 x 30	1
17	000114	#N/A	Ratchet spanner ½"	1
18	000146	535752001	Box spanner 13	1
19	000147	535752101	Box spanner 17	1
20	000148	535752301	Box spanner 19	1
21	B21335	535783301	Box spanner 30	1
22	B21336	535783401	Extension piece 250mm	1
23	000150	535752501	Box spanner SW 8mm 120lg	1
24	001033	535753601	Allenkey 3	1
25	001016	535752801	Allenkey 6	1
26	001015	535752701	Allenkey 8	1
27	001032	535753501	Screwdriver 5,5x100	1
28	001035	535753701	Insulated screwdriver	1
29	001056	535753901	Water pump pliers	1
30	000151	535752601	Hammer	1
31	001031	535753401	Safety glasses	1



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