GRITFLEX	8D REPORT

Clean Blast International LLC		Gritflex Hose	
Customer Complaint No	-	**Complaint No**	120-000097.2026.0001
Date Open:	20/01/2026	**8D Date:**	19/05/2026
Customer Code:	B250081	**Gritflex Code:**	M003701 - SAND/D12-032 B250081
Complaint Type:	Official	**Defect Type:**	FUNCTIONAL DEFETCS -> BULGING / BLISTERING
Complaint Quantity		***Accepted Quantity:***	

D1 -TEAM (LEADER, MEMBERS)	
TEAM LEADER	Gritflex Team
TEAM MEMBERS	Gritflex Team

D2 - PROBLEM DEFINITION

Bulging (bubble formation) was observed on the surface of the 32 mm hoses. Customer reported hose "bursting" and blister/bulging formation near the nozzle holder and CQT coupling area on 32 mm blast hoses supplied.
Preliminary inspection identified that the observed issue was mainly concentrated within approximately 1–2 meters from the coupling ends.



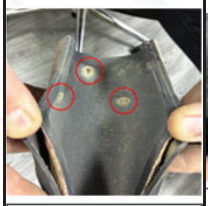
D3 - IMMEDIATE ACTIONS

ACTION

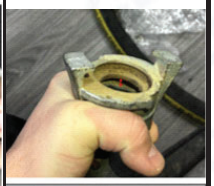
customer yard was visited from our technical person and sales person on receipt of complaint
taken samples of hose for testing . samples were sent to Turkey factory for labortary testing.
detailed testing and inspection was performed.

During visual inspection, two main findings were identified:
-The screw penetrated up to the lowest layer of the hose during crimping.
-The fitting was not fully seated at the hose beginning and approximately 5 - 8 mm gap was observed.
It was evaluated that these two conditions may cause high local pressure at the hose inlet area and allow the medium to move through the wire reinforcement, which could lead to blister formation.

Laboratory test results are compliant. No issue was detected, especially regarding interlayer adhesion.



The screw went through the hose up to the lowest layer.



The hose is not fully seated into the fitting, and a visible gap is observed at the hose–fitting interface.

D4 - ROOT CAUSE ANALYSIS OF OCCURRENCE (Findings)

During detailed visual and technical inspection, the following findings were identified:
• Incorrect screw length was used during coupling installation.
• Screws penetrated excessively into the hose structure and inner tube. (Pictures as per above)
• Couplings were not fully seated properly during fitting. (Pictures as per above)
• Gap observed between hose end and coupling seating area.

These conditions can allow compressed air leakage from the inner tube into reinforcement layers, causing localized pressure buildup and outer cover separation/blistering.

No evidence of actual hose bursting or pressure-related structural failure was identified during inspection.



The blast hose outer cover functions primarily as abrasion and weather protection.
Outer cover separation does not indicate a hose pressure burst.
The hose construction is designed and tested for:
• Working Pressure: 12 Bar
• **Burst Pressure: 36 Bar**
Incorrect screw penetration into the inner tube can create internal air leakage paths, leading to blistering near the coupling area.

Pin-pricking on the hose cover allows trapped gases or vapours to escape from the hose. Steam, air, and other gaseous products can permeate slowly through the tube and build up in the reinforcement area. Therefore, manufacturers apply pin-pricking on hoses to release this trapped pressure

Correct installation and approved screw length selection are critical to maintaining hose integrity and service life.

Actual Picture of Burst Test Done in Factory Labortary

D2 Continued

D2 Picture or Diagram of Problem, Part or Process

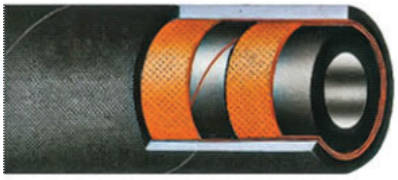






When we do the burst test to this type hoses, we investigate that burst pressure is more than 36 bar.

Classfication Of Each layers in Blasthose (INNER TUBE,REINFORCEMENT,COVER)



HEAVY DUTY SANDBLAST

≤ 60 mm³

TUBE	: ABRASION RESISTANT, ANTISTATIC NATURAL RUBBER.
REINFORCEMENT	: HIGH TENSILE SYNTHETIC TEXTILE AND ANTISTATIC COPPER WIRE.
COVER	: ABRASION, OZONE AND WEATHER RESISTANT PIN-PRICKED NATURAL AND SYNTHETIC RUBBER.

D5 - CORRECTIVE ACTIONS

•In such scenarios, our standard practice is to measure the extent of the affected area, cut the hose accordingly, and refit it using the correct length of screws and proper couplings. A re-evaluation is then carried out to ensure the hose is safe and suitable for continued use.

Step 1



Cut the end of the blast hose square and clean (not with a hacksaw) so that the end of the hose can seal against flange face .
KleenCut Hose Cutter Tool can be used .

If the hose is not perfectly square, there will be a gap between the hose end and the coupling lip which can lead to premature leakage and coupling failure.

Step 2



Optional Step: Run a bead of sealant compound around the inside of the coupling. This assists in creating a better, air-tight seal and will extend the coupling life. It will also act as a lubricant to assist with installation. Note: this DOES NOT act as a 'glue'.

Please Note: Ensure the sealant compound has properly cured before you pressurize the hose after Step 6.

Step 3



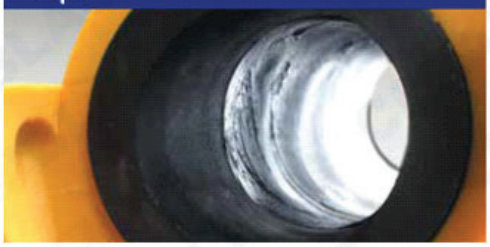
Turn the fitting clockwise onto the hose until the hose end is firmly seated against the coupling flange face **(B)**.

Step 4



Wipe away any excess sealant compound from the inside of the hose.

Step 5



Check that there are no gaps between the end of the hose and the coupling lip.

Step 6



Use the correct screw fasteners in all the available screw holes. Screws which pierce the inner wall of the blast hose will cause premature coupling wear. When being installed, screws will initially 'push' the blast hose off the coupling wall before starting to 'bite'. It is important that the screws continue to be tightened until the hose has been pulled back up against the coupling wall (do not overtighten).

While the above points are related to installation practices and the use of improper screws/cutting methods — matters beyond Clean Blast's direct control — we would like to emphasize the importance of using proper coupling procedures and suitable tools during installation.

Apart from that we have already instructed the manufacturer to increase both the depth and coverage area of the pin-pricking holes as a corrective measure for future production batches.

As a gesture of goodwill and consideration, we have already issued a credit note for the affected hoses.

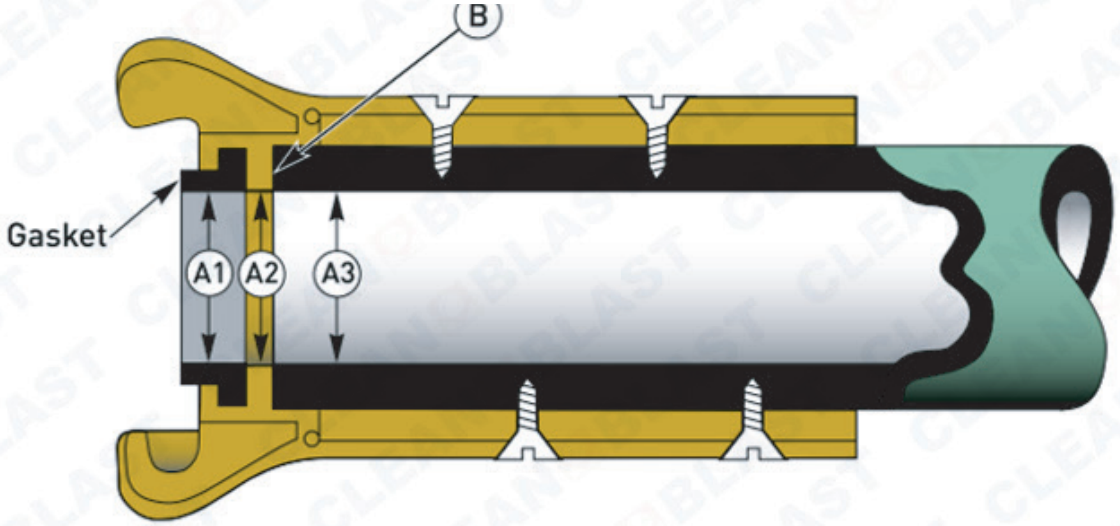
We will also inform you once our next consignment arrives so that you may inspect and verify the hose quality.

D6 - PREVENTIVE ACTIONS

ACTION

Proper Hose Installation Procedure

1. Use only recommended screw sizes and lengths.
2. Ensure screws do not excessively penetrate the hose wall.
3. Fully insert the coupling before tightening screws.
4. Use proper safety lock pins and whip checks.
5. Avoid hose twisting during installation.
6. Maintain smooth hose routing without sharp bends.
7. Support the hose properly during operation.
8. Conduct regular inspection of the hose inner liner and outer cover.
9. Daily Hoses should be visually inspected, and proof tested before being put into service.



TIP: Blast hose bore [A3] should be equal to or smaller than the flange bore [A2] and the gasket bore [A1] so the coupling does not wear prematurely, leaving the gasket unsupported and prone to leaks. Mega Max large bore couplings should be used on any hose with a bore greater than 1 ¼" [32 mm].

D7 - VERIFICATION OF EFFECTIVENESS

The effectiveness of the implemented actions will be monitored.

D8 - CLOSURE

· All open tasks closed by Gritflex HOSE. . All test confrim that Quality of the Hose meet industial standard of working pressure 12 bar and bursting pressure 36 bar. In the senario the issuse was related in outer layer cover given for weather and abrastion protection of blasthose, however the integrity of main inner layer tube with reinforcement remains intact .	**REPORTED BY**	GRITFLEX
	DATE OF COMPLETION	