

**CONTRACTORS SERIES 2 CU. FT.
BLAST MACHINE WITH MILLENNIUM PNEUMATIC
PRESSURE RELEASE REMOTE CONTROLS
O. M. 21939**

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 WARNING

Do not proceed with these instructions until you have READ the preface of this MANUAL and YOU UNDERSTAND its contents. These WARNINGS are included for the health and safety of the operator and those in the immediate vicinity. Keep this manual for future reference.

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⚠ WARNING

- Read and follow ALL instructions before using this equipment.
- Failure to comply with ALL instructions can result in serious injury or death.
- In the event that the user, or any assistants of the user of this equipment cannot read or cannot completely understand the warnings and information contained in these instructions, the employer of the user and his assistants must thoroughly educate and train them on the proper operation and safety procedures of this equipment.

NOTICE TO PURCHASERS AND USERS OF OUR PRODUCTS AND THIS INFORMATIONAL MATERIAL

The products described in this material, and the information relating to those products, is intended for knowledgeable, experienced users of abrasive blasting equipment.

No representation is intended or made as to the suitability of the products described herein for any particular purpose or application. No representations are intended or made as to the efficiency, production rate, or the useful life of the products described herein. Any estimate regarding production rates or production finishes are the responsibility of the user and must be derived solely from the user's experience and expertise, and must not be based on information in this material.

The products described in this material may be combined by the user in a variety of ways for purposes determined solely by the user. No representations are intended or made as to the suitability or engineering balance of the combination of products determined by the user in his selection, nor as to the compliance with regulations or standard practice of such combinations of components or products.

Abrasive Blast Equipment is only a component of the range of equipment used in an abrasive blasting job. Other products may include an air compressor, abrasive, scaffolding, hydraulic work platforms or booms, paint spray equipment, dehumidification equipment, air filters and receivers, lights, ventilation equipment, parts handling equipment, specialized respirators, or equipment that while offered by Clemco may have been supplied by others. Each manufacturer and supplier of the other products used in the abrasive blasting job must be contacted for information, training, instruction and warnings with regard to the proper and safe use of their equipment in the particular application for which the equipment is being used. The information provided by Clemco is intended to provide instruction only on Clemco products. All operators must be trained in the proper, safe, use of this equipment. It is the responsibility of the users to familiarize themselves with, and comply with, all appropriate laws, regulations, and safe practices that apply to the use of these products. Consult with your employer about training programs and materials that are available.

Our company is proud to provide a variety of products to the abrasive blasting industry, and we have confidence that the professionals in our industry will utilize their knowledge and expertise in the safe efficient use of these products.

GENERAL INSTRUCTIONS

Described herein are some, BUT NOT ALL, of the major requirements for safe and productive use of blast machines, remote control systems, operator respirator assemblies, and related accessories. Completely read ALL instruction manuals prior to using equipment.

The user's work environment may include certain HAZARDS related to the abrasive blasting operation. Proper protection for the blaster, as well as anyone else that may be EXPOSED to the hazards generated by the blasting process, is the responsibility of the user and/or the employer. Operators MUST consult with their employer about what hazards may be present in the work environment including, but not limited to, exposure to dust that may contain TOXIC MATERIALS due to the presence of silica, cyanide, arsenic or other toxins in the abrasive, or materials present in the surface to be blasted such as lead or heavy metals in coatings. The environment may also include fumes that may be present from adjacent coatings application, contaminated water, engine exhaust, chemicals, and asbestos. The work area may include PHYSICAL HAZARDS such as an uneven work surface, poor visibility, excess noise, and electrical hazards. The operator MUST consult with his employer on the identification of potential hazards, and the appropriate measures that MUST be taken to protect the blaster and others that might be exposed to these hazards.

ALL machines, components and accessories MUST be installed, tested, operated and maintained only by trained, knowledgeable, experienced users.

DO NOT modify or substitute any Clemco parts with other types or brands of equipment. Unauthorized modification and parts substitution on supplied air respirators is a violation of OSHA regulations and voids the NIOSH approval.

OPERATIONAL INSTRUCTIONS

OPERATOR SAFETY EQUIPMENT

⚠ WARNING

- Blast operators and others working in the vicinity of abrasive blasting must always wear properly-maintained, NIOSH-approved, respiratory protection appropriate for the job site hazards.
- DO NOT USE abrasives containing more than one percent crystalline (free) silica. Ref. NIOSH Alert #92-102
- Inhalation of toxic dust (crystalline silica, asbestos, lead paint and other toxins) can lead to serious or fatal disease (silicosis, asbestosis, lead or other poisoning).

- ALWAYS wear NIOSH-approved supplied-air respirators as required by OSHA, in the presence of any dust including, but not limited to, handling or loading abrasive; blasting or working in the vicinity of blast jobs; and cleanup of expended abrasive. Prior to removing respirator, an air monitoring

instrument should be used to determine when surrounding atmosphere is clear of dust and safe to breathe.

- NIOSH-approved, supplied-air respirators are to be worn ONLY in atmospheres:
 - NOT IMMEDIATELY dangerous to life or health and,
 - from which a user can escape WITHOUT using the respirator.
- Clemco supplied-air respirators **DO NOT REMOVE OR PROTECT AGAINST CARBON MONOXIDE (CO) OR ANY OTHER TOXIC GAS.** Carbon monoxide and toxic gas removal and/or monitoring device must be used in conjunction with respirator to insure safe breathing air.
- Air supplied to respirator **MUST BE AT LEAST GRADE D QUALITY** as described in Compressed Gas Association Commodity Specification G-7.1, and as specified by OSHA Regulation 1910.139 (d).
- ALWAYS locate compressors to prevent contaminated air (such as CO from engine exhaust) from entering the air intake system. A suitable in-line air purifying sorbent bed and filter or CO Monitor should be installed to assure breathing air quality.
- ALWAYS use a NIOSH-approved breathing air hose to connect an appropriate air filter to the respirator. Use of a non-approved air hose can subject the operator to illness caused by the release of chemical agents used in the manufacture of non-approved breathing air hose.
- ALWAYS check to make sure air filter and respirator system hoses are NOT CONNECTED to in-plant lines that contain nitrogen, acetylene or any other non-breathable gas. NEVER use oxygen with air line respirators. NEVER modify air line connections to accommodate air filter/respirator breathing hose WITHOUT FIRST testing content of the air line. **FAILURE TO TEST THE AIR LINE MAY RESULT IN DEATH TO THE RESPIRATOR USER.**
- Respirator lenses are designed to protect against rebounding abrasive. They do not protect against flying objects, glare, liquids, radiation or high speed heavy materials. Substitute lenses from sources other than the original respirator manufacturer will void NIOSH-approval of this respirator.

BLAST MACHINES AND REMOTE CONTROLS

WARNING

- **ALWAYS equip abrasive blast machines with remote controls.**
- **Abrasive blast machine operators must wear NIOSH-approved supplied-air respirators (ref: OSHA regulations 1910.94, 1910.132, 1910.139 and 1910.244).**

- NEVER modify OR substitute remote control parts. Parts from different manufacturers are NOT compatible with Clemco

equipment. If controls are altered, involuntary activation, which may cause serious injury, can occur.

- Inspect the air control orifice DAILY for cleanliness. NEVER use welding hose in place of twinline control hose. The internal diameter and rubber composition are UNSAFE for remote control use.
- UNLESS OTHERWISE SPECIFIED, maximum working pressure of blast machines and related components MUST NOT exceed National Board approved 125 psig (8.5 BAR).
- NEVER weld on blast machine. Welding may affect dimensional integrity of steel wall and WILL VOID National Board approval.
- Point nozzle ONLY at structure being blasted. High velocity abrasive particles WILL inflict serious injury. Keep unprotected workers OUT of blast area.
- NEVER attempt to manually move blast machine when it contains abrasive. EMPTY machines, up to 6 cu. ft.(270kg) capacity, are designed to be moved:
 - on flat, smooth surfaces by AT LEAST two people;
 - with the Clemco "Mule"; or
 - with other specially designed machine moving devices.
- Larger empty blast machines or ANY blast machine containing abrasive MUST be transported by mechanical lifting equipment.

AIR HOSE, BLAST HOSE, COUPLINGS, AND NOZZLE HOLDERS

- Air hose, air hose fittings and connectors at compressors and blast machines MUST be FOUR times the size of the nozzle orifice. Air hose lengths MUST be kept as short as possible AND in a straight line. Inspect DAILY and repair leakage IMMEDIATELY.
- Blast hose inside diameter MUST be THREE to FOUR times the size of the nozzle orifice. AVOID sharp bends that wear out hose rapidly. Use SHORTEST hose lengths possible to reduce pressure loss. Check blast hose DAILY for soft spots. Repair or replace IMMEDIATELY.
- ALWAYS cut loose hose ends square when installing hose couplings and nozzle holders to allow uniform fit of hose to coupling shoulder. NEVER install couplings or nozzle holders that DO NOT provide a TIGHT fit on hose. ALWAYS use manufacturers recommended coupling screws.
- Replace coupling gaskets FREQUENTLY to prevent leakage. Abrasive leakage can result in dangerous coupling failure. ALL gaskets MUST be checked SEVERAL times during a working day for wear, distortion and softness.
- Install safety pins at EVERY coupling connection to prevent accidental disengagement during hose movement.
- ALWAYS attach safety cables at ALL air hose AND blast hose coupling connections. Cables relieve tension on hose and control whipping action in the event of a coupling blow-out.

MAINTENANCE

- ALWAYS shut off compressor and depressurize blast machine BEFORE doing ANY maintenance.
- Always check and clean ALL filters, screens and alarm systems when doing any maintenance.
- ALWAYS cage springs BEFORE disassembling valves IF spring-loaded abrasive control valves are used.
- ALWAYS completely follow owner's manual instructions and maintain equipment at RECOMMENDED intervals.

ADDITIONAL ASSISTANCE

- Training and Educational Programs.
Clemco Industries Corp. offers a booklet, Blast-Off 2, developed to educate personnel on abrasive blast equipment function and surface preparation techniques. Readers will learn safe and productive use of machines, components and various accessories, including selection of abrasive materials for specific surface profiles and degrees of cleanliness.
- The Society for Protective Coatings (SSPC) offers a video training series on protective coatings including one entitled "Surface Preparation." For loan or purchase information, contact SSPC at the address shown below.

TECHNICAL DATA AND RESEARCH COMMITTEES

- The following associations offer information, materials and videos relating to abrasive blasting and safe operating practices.

The Society for Protective Coatings (SSPC)

40 24th Street, Pittsburgh PA 15222-4643
Phone: (412) 281-2331 • FAX (412) 281-9992
Email: research@sspc.org • Website: www.sspc.org

National Association of Corrosion Engineers (NACE)

1440 South Creek Drive, Houston TX 77084
Phone: (281) 228-6200 • FAX (281) 228-6300
Email: msd@mail.nace.org • Website: www.nace.org

American Society for Testing and Materials (ASTM)

100 Barr Harbor Dr., West Conshohocken, PA 19428
Phone (610) 832-9500 • FAX (610) 832-9555
Email: service@astm.org • Website: www.astm.org

NOTICE

This equipment is not intended to be used in an area that might be considered a hazardous location as described in the National Electric Code NFPA 70 1996, article 500.

WARRANTY

The following is in lieu of all warranties express, implied or statutory and in no event shall seller or its agents, successors, nominees or assignees, or either, be liable for special or consequential damage arising out of a breach of warranty. This warranty does not apply to any damage or defect resulting from negligent or improper assembly or use of any item by the buyer or its agent or from alteration or attempted repair by any person other than an authorized agent of seller. All used, repaired, modified or altered items are purchased "as is" and with all faults. In no event shall seller be liable for consequential or incidental damages. The sole and exclusive remedy of buyer for breach of warranty by seller shall be repair or replacement of defective parts or, at seller's option, refund of the purchase price, as set forth below:

1. Seller makes no warranty with respect to products used other than in accordance hereunder.
2. On products seller manufactures, seller warrants that all products are to be free from defects in workmanship and materials for a period of one year from date of shipment to buyer, but no warranty is made that the products are fit for a particular purpose.
3. On products which seller buys and resells pursuant to this order, seller warrants that the products shall carry the then standard warranties of the manufacturers thereof, a copy of which shall be made available to customer upon request.
4. The use of any sample or model in connection with this order is for illustrative purposes only and is not to be construed as a warranty that the product will conform to the sample or model.
5. Seller makes no warranty that the products are delivered free of the rightful claim of any third party by way of patent infringement or the like.
6. This warranty is conditioned upon seller's receipt within ten (10) days after a buyer's discovery of a defect, of a written notice stating in what specific material respects the product failed to meet this warranty. If such notice is timely given, seller will, at its option, either modify the product or part to correct the defect, replace the product or part with complying products or parts, or refund the amount paid for the defective product, any one of which will constitute the sole liability of seller and a full settlement of all claims. No allowance will be made for alterations or repairs made by other than those authorized by seller without the prior written consent of seller. Buyer shall afford seller prompt and reasonable opportunity to inspect the products for which any claim is made as above stated.

Except as expressly set forth above, all warranties, express, implied or statutory, including implied warranty of merchantability, are hereby disclaimed.

DAILY SET-UP CHECK LIST

WARNING

- ALL piping, fittings and hoses MUST be checked DAILY for tightness and leakage.
- ALL equipment and components MUST be thoroughly checked for wear.
- ALL worn or suspicious parts MUST be replaced.
- ALL blast operators MUST be properly trained to operate equipment.
- ALL blast operators MUST be properly outfitted with abrasive resistant clothing, safety shoes, leather gloves and ear protection.
- BEFORE blasting ALWAYS use the following check list.

☐ 1. PROPERLY MAINTAINED AIR COMPRESSOR sized to provide sufficient volume (cfm) for nozzle and other tools PLUS a 50% reserve to allow for nozzle wear. Use large compressor outlet and large air hose (4 times the nozzle orifice size). FOLLOW MANUFACTURERS MAINTENANCE INSTRUCTIONS.

☐ 2. BREATHING AIR COMPRESSOR (oil-less air pump) capable of providing Grade D Quality air located in a dust free, contaminant free area. If oil-lubricated air compressor is used to supply respirator, it should have high temperature monitor and CO monitor or both. If CO monitor is not used, air MUST be tested FREQUENTLY to ensure proper air quality.

☐ **3. Clean, properly maintained NIOSH-APPROVED SUPPLIED-AIR RESPIRATOR.** ALL components should ALWAYS be present. NEVER operate without inner lens in place. Thoroughly inspect ALL components DAILY for cleanliness and wear. ANY substitution of parts voids NIOSH approval i.e. cape, lenses, breathing hose, breathing air supply hose, air control valve, cool air or climate control devices.

☐ **4. OSHA required BREATHING AIR FILTER** for removal of moisture and particulate matter from breathing air supply. THIS DEVICE DOES NOT REMOVE OR DETECT CARBON MONOXIDE (CO). ALWAYS USE CO MONITOR ALARM.

☐ **5. ASME CODED BLAST MACHINE** sized to hold 1/2 hour abrasive supply. ALWAYS ground machine to eliminate static electricity hazard. Examine pop up valve for alignment. Blast machine MUST be fitted with a screen to keep out foreign objects and a cover to prevent entry of moisture overnight.

☐ **6. AIR LINE FILTER** installed AS CLOSE AS POSSIBLE to machine inlet. Sized to match inlet piping or larger air supply line. Clean filter DAILY. Drain OFTEN.

☐ **7. REMOTE CONTROLS** MUST be in PERFECT operating condition. ONLY use APPROVED spare parts, including twin- line hose. DAILY: test system operation and check button bumper and spring action of lever and lever lock. DO NOT USE WELDING HOSE.

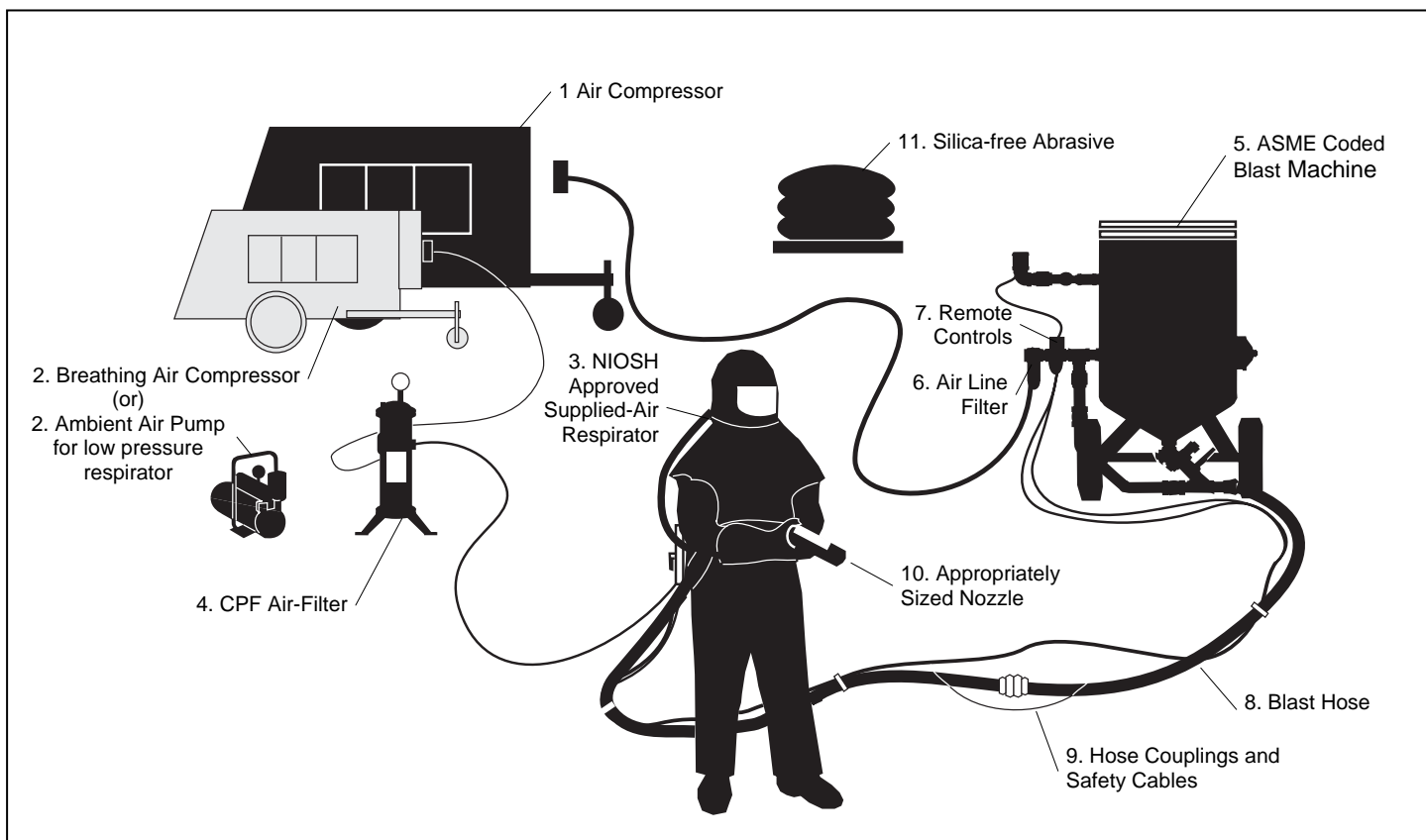
☐ **8. BLAST HOSE** with ID 3 to 4 times the nozzle orifice. Lines MUST be run AS STRAIGHT AS POSSIBLE from machine to work area with NO sharp bends. Check DAILY for internal wear and external damage.

☐ **9. HOSE COUPLINGS, NOZZLE HOLDERS** fitted SNUGLY to hose end and installed using PROPER coupling screws. Coupling lugs MUST be snapped FIRMLY into locking position. Gasket MUST form positive seal with safety pins inserted through pin holes. Check gaskets and replace if ANY sign of wear, softness or distortion. ALWAYS install safety cables at every connection to prevent disengagement. Check nozzle holder for worn threads. NEVER MIX DIFFERENT BRANDS OF COMPONENTS. Check each of these components DAILY.

☐ **10. Inspect NOZZLE and GASKET** DAILY for wear. Replace nozzle when 1/16" larger than original size or if liner appears cracked. Check nozzle threads for wear.

☐ **11. Use abrasive** that is properly sized and free of harmful substances; such as, free silica, cyanide, arsenic or lead. Check material data sheet for presence of toxic or harmful substances.

☐ **12. Test surface** to be blasted for toxic substances. Take appropriate, and NIOSH required, protective measures for operator and bystanders which pertain to substances found on the surface to be blasted.



1.0 INTRODUCTION

1.1 Scope of manual

1.1.1 These instructions cover the set-up, operation, maintenance, troubleshooting, and replacement parts for the 16" diameter, 2 cu. ft. capacity Clemco Contractor Series Blast Machine.

1.1.2 These instructions also contain important information required for safe operation of the machine. All blast operator(s) and machine (pot) tenders must be trained in the safe operation of the blast machine, remote control system, and all blasting accessories. Before using the machine, all personnel involved with the blast machine operation must read this entire manual, including the orange cover, and all accessory manuals.

1.1.3 All personnel involved with the abrasive blasting process must be made aware of the hazards associated with abrasive blasting. The Clemco booklet "Abrasive Blasting Safety Practices" is included with every blast machine, and contains important safety information about abrasive blasting that may not be included in equipment operation manuals. Additional copies are available from Clemco Industries.

1.2 Safety Alerts

1.2.1 Clemco uses safety alert signal words, based on ANSI Z535.4-1998, to alert the user of a potentially hazardous situation that may be encountered while operating this equipment. ANSI's definitions of the signal words are as follows:



This is the safety alert symbol. It is used to alert the user of this equipment of potential personal injury hazards.

Obey all safety messages that follow this symbol to avoid possible injury or death.

CAUTION

Caution used without the safety alert symbol indicates a potentially hazardous situation which, if not avoided, may result in property damage.

CAUTION

Caution indicates a potentially hazardous situation which, if not avoided, may result in minor or moderate injury.

WARNING

Warning indicates a potentially hazardous situation which, if not avoided, could result in death or serious injury.

DANGER

Danger indicates an imminently hazardous situation which, if not avoided, will result in death or serious injury.

1.3 Components and Operating Principles

1.3.1 Components

1.3.1.1 The primary components of the Contractor machines are shown in Figure 1. They include the blast machine with Millennium Remote Controls, manually operated Quantum Abrasive Metering Valve, frame assembly, optional compressed air filter, and optional CPF air filter.

1.3.2 Instruction Maintenance Manuals

1.3.2.1 Individual manuals are included with the following optional accessories:

- CPF Air Filter
- Apollo Respirator
- Cool Air Tube

1.3.2.2 The front leg contains a storage area for owner's manuals. After reviewing all the manuals, and start-up and adjustments are completed, remove the urethane cover plate and store manuals in the compartment, for future reference.

1.3.3 Blast Machine

1.3.3.1 Clemco blast machines (pressure vessels) are manufactured to American Society of Mechanical Engineers (ASME) standards, as described in Section VII, Div. 1, and carry a National Board certification. It is the owner's responsibility to maintain the integrity of the vessel as may be required by some states. This may include regular inspection and hydrostatic testing as

described in National Board Inspection Code and Jurisdictional Regulations and /or Laws.

⚠ WARNING

Welding, grinding, or drilling on the blast machine could weaken the vessel. Compressed air pressure could cause a weakened blast machine to rupture, resulting in death or serious injury. Welding, grinding, or drilling on the blast machine vessel, without a National Board "R" stamp voids the ASME and National Board certification.

1.3.3.2 All welding repairs done on the vessel must be performed by certified welders, at shops holding a National Board "R" Stamp. Welding performed by any welder not properly qualified per the ASME Code voids ASME and National Board certification of the vessel.

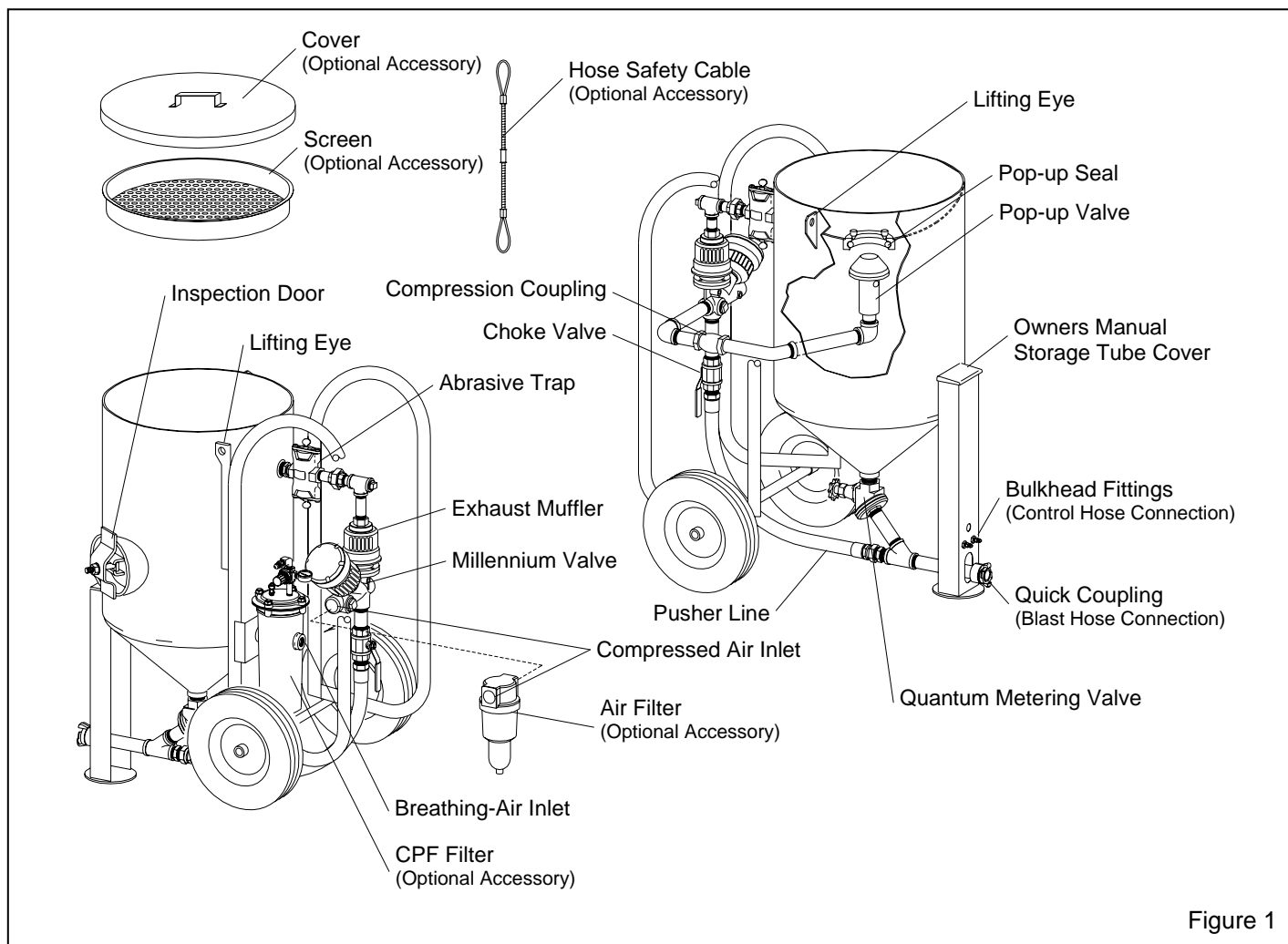
1.3.3.3 This blast machine is rated for a maximum of 150 psi (pounds per square inch); do not exceed the rated pressure.

⚠ WARNING

Excessive air pressure could cause a blast machine to rupture. To prevent serious injury or death, do not exceed the rated pressure of the blast machine vessel.

1.3.3.4 Use lifting eyes to assist in loading and unloading the blast machine. Do not use a sling around the cart handles or piping.

1.3.3.5 The blast machine is equipped with remote controls that allow the operator to pressurize the machine to start blasting, and depressurize it to stop blasting, at the nozzle.



1.3.3.6 OSHA does not require pressure relief valves on blast machines when air compressors supplying air to the blast machines are built to ASME ⁽¹⁾ specifications and comply with OSHA ⁽²⁾ regulations. ASME Manual section VIII, Division 1, UG-125, paragraph A90 (g) states that pressure relief valves or protective devices **"...need not be installed directly on a pressure vessel when the source of pressure is external to the vessel and is under such positive control that the pressure in the vessel cannot exceed the maximum allowable working pressure at the operating temperature..."**. OSHA regulation 1910.169 refers to the above ASME code when describing the necessity of pressure relief valves on compressed air equipment. **DO NOT** operate blast machines with air compressors that are not equipped with properly functioning pressure relief valves.

⁽¹⁾ American Society of Mechanical Engineers, Boiler and Pressure Vessel Code, 1989

⁽²⁾ Occupational Safety and Health Administration, 29 CFR 1910, Subpart M - Compressed Gas and Compressed Air Equipment.

1.3.4 Remote Controls

1.3.4.1 The components of the Millennium remote control system are shown in Figure 2. They include the Millennium Valve, RLX Control Handle, 50-foot twinline control hose and 4-foot twinline control hoses, and all necessary fittings.

1.3.4.2 The remote control system is an OSHA-required safety device. The control handle, located near the blast nozzle, is the activator for the remote control system. When the operator intentionally or unintentionally removes hand-held pressure from the remote control handle, the machine depressurizes, stopping air and abrasive flow through the nozzle. The remote control system "fails to safe", which means any interruption in the control-air circuit for reasons, such as a break in the line, the compressor stops running, or the operator drops the blast hose, the remote controls deactivate the blast machine.

WARNING

Never modify or substitute remote control parts. Parts from other manufacturers are not compatible with Clemco equipment. If ANY part of the remote control system is altered, involuntary activation, which may cause serious injury, can occur.

1.3.4.3 Millennium Remote Controls are pressure-release-style systems, which control the pressurization and depressurization of the blast machine. Pressurization, which starts blasting, occurs when the control handle is pressed. Depressurization, which stops blasting, occurs when the handle is released.

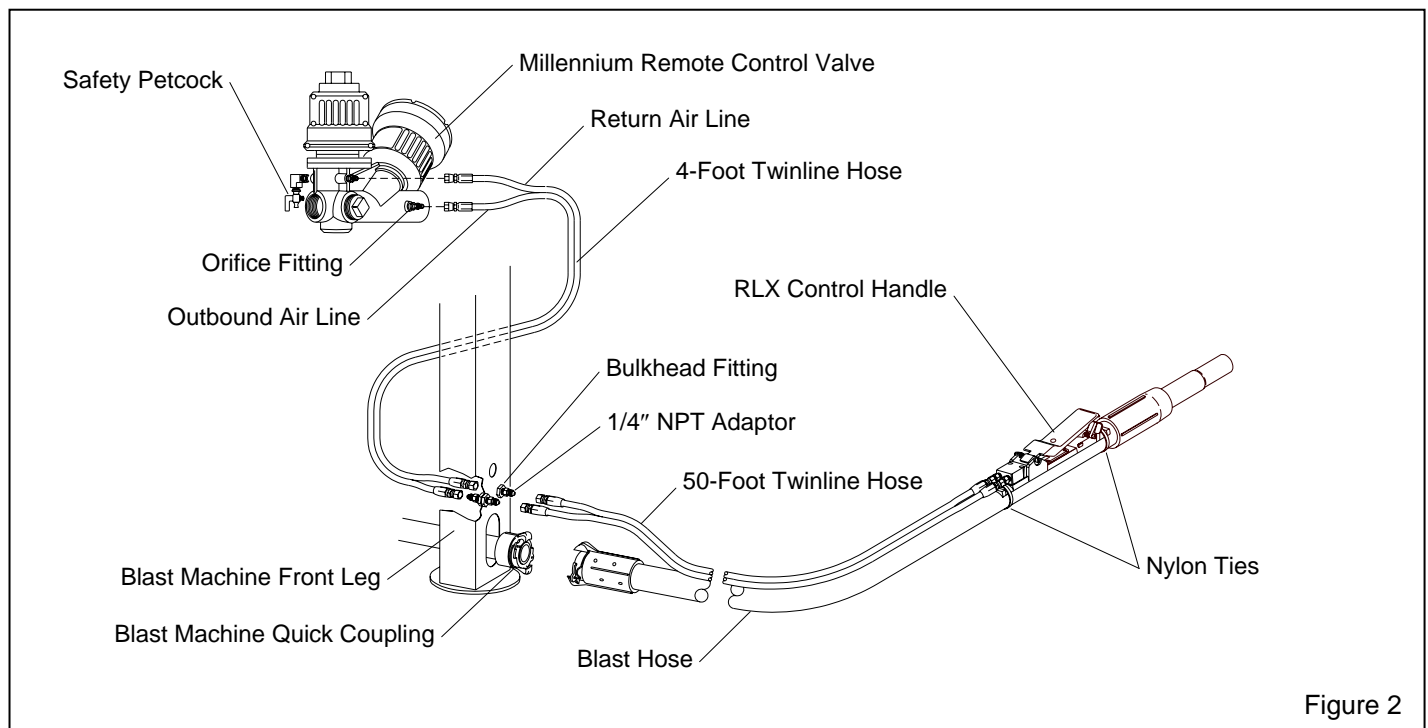


Figure 2

1.3.4.4 Millennium Remote Controls operate pneumatically on the "return air" principle (See Figure 2). One stream of air travels down the outbound twinline and escapes through an opening located under the control handle lever. As long as air escapes through the opening, the remote control system remains inactive. When the lever is pressed, the opening is sealed, and air from the outbound line returns through the return line to open the inlet segment and close the outlet segment of the Millennium valve. This pressurizes the blast machine and begins the blasting process. Releasing the handle exhausts the control air, which closes the inlet segment, and opens the outlet segment to depressurize the machine and stop the blasting.

1.3.5 Electric Remote Control Option

1.3.5.1 Electric remote controls (electro-pneumatic) are recommended when the nozzle and remote control handle are farther than 100 feet from the blast machine. Pressure drop of pneumatic systems over longer distances increases actuation time, which prevents fast, safe operation. Contact your local Clemco Distributor for more information.

1.3.6 Air Filter, Optional

1.3.6.1 The optional filter removes particles and condensed moisture from the compressed air before it enters the machine. Water is drained by use of a manual drain located at the bottom of the filter.

1.3.7 Frame and Cart

1.3.7.1 The frame assembly provides added protection for the piping, valves and accessories. This protection keeps the piping aligned and tight. The wheeled cart assists in the mobility of the machine over smooth flat surfaces. See transporting and moving in Section 3.1.

2.0 INITIAL SET-UP

WARNING

Moist air that freezes could cause blockage at the control handle or in the control lines. Blockage could cause involuntary activation of the remote controls, or prevent the controls from deactivating upon release of the control handle. This situation could result in serious injury or death. If remote controls are operated in freezing or near freezing weather, install a Clemco Anti-Freeze Injector, stock no. 05537, on the remote control air supply line.

2.1 Blast Hose and Control Hose Connections, Ref. Figure 2.

2.1.1 Locate the two 1/4" NPT adaptors, packaged in the accessory box. The adaptors are boxed, to prevent damage in transit.

2.1.2 Screw the adaptors tightly into the bulkhead fittings on the lower part of the front leg.

2.1.3 Uncoil the blast hose, and lay the 50-ft. twinline hose alongside it. Hoses should be of equal lengths.

2.1.4 Band the control handle to the blast hose close to the nozzle holder, using the two nylon ties provided. Once the control is firmly attached, clip the tie ends so they will not snag the operator's clothing or interfere with the operation of the control handle.

WARNING

Where two or more blast machines are used, carefully trace control lines and blast hose when making connections. Cross-connecting control hose or blast hose could lead to serious injury, death, or property damage from unintentional actuation of a blast machine. To prevent cross connections, hoses should be of equal lengths, and the hoses and blast machine couplings clearly marked. Use optional hose identification kits, part no. 15890 for use with two blast machines, or part no. 15891 for up to four machines. Mark each hose and connection per the instructions supplied with the kit, and carefully trace and verify each connection before operating.

2.1.5 Attach the 50-foot twinline hose to the two fittings on the control handle. Either side of the hose can be attached to either fitting.

2.1.6 Working from the control handle back, band the twinline hose to the blast hose every four to six feet, and as close to the couplings as possible.

2.1.7 Place the nozzle washer in the nozzle holder, and screw the nozzle into the holder. The nozzle must seat tightly against the nozzle washer.

2.2 Compressed-Air Supply Hose Connection

2.2.1 Install an air supply hose fitting to the optional air filter or air inlet that is compatible with the compressed-air supply hose from the compressor. See Section 3.2.2.

2.3 Breathing Air Connections, optional CPF Filter

WARNING

Air supply to the respirator system is critical to the safety of the user. Read the CPF Filter and Apollo Respirator manuals carefully. Poor quality air will cause serious respiratory injury or death to the user.

2.3.1 Breathing air must meet the requirements for Grade D or higher quality, as described in Compressed Gas Association Commodity Specification pamphlet G-7.1., titled Commodity Specification For Air, Published by Compressed Gas Association Inc., Arlington, VA. (CFR Title 30 Chapter 1).

DANGER

Do not connect the CPF Filter, or any other regulator or filter, to bottled air or any other air source that does not have a pressure reducing valve that reduces pressure to maximum of 125 psi. Failure to comply with this warning will cause low pressure devices to explode under the high pressure of bottled air. Such an explosion could cause severe injury or death.

2.3.2 Connect an air supply hose fitting to the filter inlet that is compatible with the air supply hose from an air source that meets OSHA requirements for respirable

air, to the CPF Filter inlet as shown in Figure 1. Pressure supplied to the filter must not exceed 125 psi.

2.3.3 Refer to the Apollo Respirator and CPF Filter manuals for instructions concerning their operation.

3.0 OPERATION

3.1 Transporting and Moving

3.1.1 Transporting a blast machine

3.1.1.1 Always empty the machine before transporting. Transporting the machine containing abrasive could increase the weight to an unsafe handling limit, and could cause abrasive to settle in piping.

WARNING

- **Always empty the blast machine before lifting or hoisting.**
- **Use the lifting eyes when lifting the machine. Never hoist the machine by the handle or piping, or with a sling through the handle or piping.**
- **Always use lift equipment that is rated higher than the weight of the machine and accessories.**
- **When transporting a machine on a pallet, always securely attach the machine to a sturdy pallet.**
- **Always securely anchor the machine to the transport vehicle.**
- **Anyone using material handling equipment to move, transport, or lift the machine must be experienced, and able to recognize and avoid hazards associated with handling this type of machinery, and to safely operate the equipment.**
- **Failure to observe these warnings could result in serious injury or death.**

3.1.2 Moving a blast machine

WARNING

Never attempt to manually move a blast machine when it contains abrasive. An empty machine may be moved when the following criteria are met:

3.1.2.1 An empty machine may be moved manually, on level flat surfaces.

WARNING

Do not manually move the machine on an incline, or on a slippery or irregular surface that could cause the operator to slip or lose balance. Sudden weight shifts when the machine is tilted on an incline, and slipping or tripping while moving the machine will cause the operator to lose control of the machine, causing severe injury and property damage.

3.1.2.2 Move the machine by pushing it forward. Do not back-up while moving the machine, as potential tripping hazards may be out of view.

3.1.2.3 Use the lifting eyes when lifting the machine. Do not use a sling around the cart handles or piping.

3.1.2.4 If the machine contains any abrasive, keep the machine upright. Laying down a machine containing abrasive could cause abrasive to lodge in the piping and cause the machine to malfunction, or cause damage to the valves.

3.2 Start-Up

3.2.1 Locate the compressor upwind from the blasting operation to prevent contaminated air from entering the compressor intake.

3.2.2 Connect an air line from the compressor to the air supply hose connector installed on the blast machine inlet. For best blasting performance, use 1-1/4" ID or larger air line when using up to a 5/16" orifice nozzle, 1-1/2" or larger when using up to a 3/8" nozzle, and 2" or larger when using up to a 1/2" nozzle. See the compressed air and abrasive consumption chart in Figure 3 for approximate air consumption.

3.2.3 Make sure the coupling gaskets are in place and in good condition before connecting the blast hose to the

quick coupling on the blast machine. When connecting the hose make sure the coupling spring lock pins are at 180 degrees (Pins should enter the unused hole of the adjoining coupling). The spring lock pins help prevent accidental separation of hose couplings during blasting.

3.2.4 Make sure that all compressed-air supply hose connections are secured with safety lock pins and safety cables to prevent accidental separation or disconnection. Safety cables are listed in Section 8.1 of this manual.

WARNING

Hose disconnection while under pressure could cause serious injury or death. Use safety lock pins and safety cables on all coupling connections to help prevent hose couplings from accidental disconnection.

3.2.5 Connect the ends of the 50-foot twinline hose to the adaptors in the bulkhead fittings on the front leg. Either side of the hose can be attached to either fitting. Make sure all fittings are tight. Leaks will cause the system to malfunction.

3.2.6 Connect an air line between a source of respirable breathing air meeting the requirements for Grade D or higher quality, and the CPF filter inlet. See Section 2.3. The maximum inlet pressure for the CPF Filter must not exceed 125 psi.

DANGER

Do not connect the CPF Filter, or any other regulator or filter, to bottled air or any other air source that does not have a pressure reducing valve that reduces pressure to a maximum of 125 psi. Failure to comply with this warning will cause low pressure devices to explode under the high pressure of bottled air. Such an explosion could cause severe injury or death.

WARNING

If twist-on type air hose couplings are used, they must be secured by safety pins or wires to prevent accidental disconnection. Hose disconnection while under pressure could cause serious injury or death.

Compressed Air and Abrasive Consumption Consumption rates are based on abrasive that weigh 100 pounds per cubic foot									
Orifice Size (in.)	Pressure At The Nozzle (psi)								Air, Power and Abrasive Requirements
	50	60	70	80	90	100	125	140	
No. 2 1/8"	11	13	15	17	19	20	25	28	Air (cfm)
	67	77	88	101	112	123	152	169	Abrasive (lbs/hr)
	2.5	3	3.5	4	4.5	5	5.5	6.5	Compressor (hp)
No. 3 3/16"	26	30	33	38	41	45	55	61	Air (cfm)
	150	171	196	216	238	264	319	353	Abrasive (lbs/hr)
	6	7	8	9	10	10	12	14	Compressor (hp)
No. 4 1/4"	47	54	61	68	74	81	98	108	Air (cfm)
	268	312	354	408	448	494	608	676	Abrasive (lbs/hr)
	11	12	14	16	17	18	22	24	Compressor (hp)
No. 5 5/16"	77	89	101	113	126	137	168	186	Air (cfm)
	468	534	604	672	740	812	982	1085	Abrasive (lbs/hr)
	18	20	23	26	28	31	37	42	Compressor (hp)
No. 6 3/8"	108	126	143	161	173	196	237	263	Air (cfm)
	668	764	864	960	1052	1152	1393	1538	Abrasive (lbs/hr)
	24	28	32	36	39	44	52	59	Compressor (hp)
No. 7 7/16"	147	170	194	217	240	254	314	347	Air (cfm)
	896	1032	1176	1312	1448	1584	1931	2138	Abrasive (lbs/hr)
	33	38	44	49	54	57	69	77	Compressor (hp)
No. 8 1/2"	195	224	252	280	309	338	409	452	Air (cfm)
	1160	1336	1512	1680	1856	2024	2459	2718	Abrasive (lbs/hr)
	44	50	56	63	69	75	90	101	Compressor (hp)
<ul style="list-style-type: none"> For nozzle sizes 3/8" to 1/2", blast machines should be equipped with 1-1/4" or larger piping and inlet valve to prevent pressure loss. Air requirements were measured by a flow meter under actual blasting conditions, and are therefore lower than figures for air alone, with no abrasive. Horsepower requirements are based on 4.5 cfm per horsepower. Figures are for reference only, and may vary for different working conditions. Several variables, including metering valve adjustments, can affect abrasive flow. Figures show approximate compressed air and abrasive consumption when nozzles are new. Consumption will increase as the nozzle wears. 									

Figure 3

3.2.7 Make sure that all blast hose and compressed-air hose connections are secure, and that coupling lock pins are in place.

3.2.8 Make sure the choke valve is open, (handle in-line with the valve and piping).

3.2.9 Close the Quantum abrasive metering valve. Closed position is when the knob is turned fully clockwise. See Section 4.1.

3.2.10 Open the safety petcock on the inlet section of the Millennium valve. It is open when the lever is in-line with the petcock, as shown in Figure 4.

WARNING

To prevent severe injury or death from accidental activation of the blast machine, open the safety petcock when the blast machine is not in use. Opening the petcock prevents unintentional blasting. The control handle can not activate the machine when the petcock is open.

3.2.11 Make sure that the control handle lever is in the up (no blast) position, and that the handle lever and safety lock move freely.

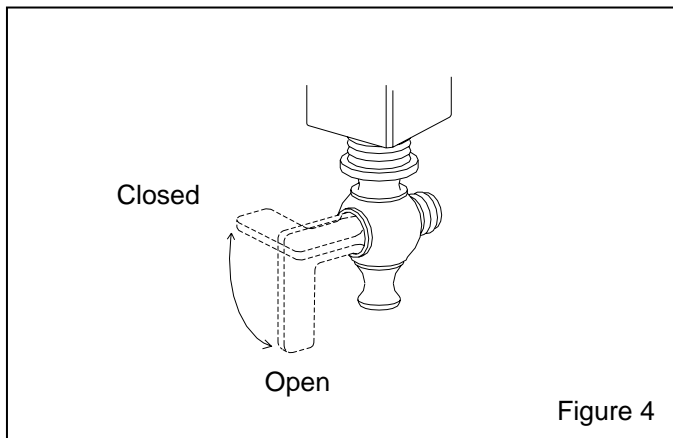


Figure 4

3.2.12 Check to make sure that the handle lever will not seal the opening on the control handle, unless the safety lever lock is pulled down.

⚠ WARNING

Malfunctioning control handles could cause unintentional actuation of a blast machine, or prevent a machine from deactivating upon release. Malfunctioning control handles must be taken out of service immediately and repaired or replaced. Serious injury or death can result from unintentional blasting.

3.2.13 Close the air valve on the compressor. Start the compressor, and bring it to operating temperature and pressure. The pressure must be more than 30 psi, but not exceed 150 psi.

3.2.14 Slowly open the compressor air valve, to pressurize the air supply line. Listen for any open lines or leaks.

3.2.15 Pressurize the breathing air supply line, and adjust pressure on the CPF Filter outlet, to the pressure stated in the respirator manual.

3.2.16 Load abrasive into the machine by following the instructions in Section 3.6.

3.2.17 Do not allow anyone within 10 feet of the blast machine except machine tenders, who are appropriately fitted with approved protective equipment. The blast operator could pressurize and depressurize the machine without warning.

⚠ WARNING

All persons except for the machine tender must stay clear of the blast machine. The blast operator may pressurize or depressurize the machine at any time. The noise generated by the sudden release of compressed air when the machine is pressurized or depressurized, may startle bystanders, and may vent abrasive under pressure. Either condition could result in injury. The machine tender must wear a suitable, approved respirator, plus approved eye, face, and hearing protection.

3.2.18 When the blast operator is ready to blast, either the operator or the machine tender, while standing back and facing away from the concave filling head of the blast machine and the exhaust muffler, closes the safety petcock. Closing the petcock prepares the machine for remote operation at the control handle. Air should be heard escaping from the orifice under the control handle lever but nowhere else. The air escaping at the control handle is an audible signal that air is supplied to the blast machine, and will activate if the control handle is pressed.

3.3 Blasting Attire

⚠ WARNING

- **Before blasting, test the coating and substrate for toxic materials (such as lead or other heavy metals, or asbestos). These hazards require special measures to protect the operators and the environment.**
- **No dust is safe to breathe. Abrasive blasting produces harmful dust. Failure to wear approved respirators could result in serious lung disease or death. Blast operators must wear properly fitted and maintained NIOSH-approved, type-CE supplied-air respirators approved for abrasive blasting.**
- **During abrasive blasting, abrasive particles and dust in the area around the blast machine and blast nozzle become airborne. Everyone working in the vicinity of abrasive blasting must wear properly-maintained, NIOSH-approved, respiratory protection appropriate for the job site hazards.**
- **Loud noise generated by the use of compressed air could cause hearing damage. Everyone in the blasting area must wear approved eye and hearing protection.**

3.3.1 Operators and **anyone else that may be exposed to the hazards generated by the blasting process** must wear appropriate protective gear, including abrasive-resistant clothing, leather gloves, eye and hearing protection, and a NIOSH-approved Type CE Supplied-Air Respirator.

3.4 Blasting

3.4.1 Hold the blast hose securely and point the nozzle only at objects intended to be blast cleaned.

3.4.2 Pull back the safety lever lock and depress the remote control handle. Within a few seconds, the pop-up valve automatically closes, and the blast machine will pressurize to start blasting.

CAUTION

Be prepared for the recoil from the blast hose. Blasting should begin within a few seconds after pressing the control handle lever.

WARNING

OSHA requires the use of remote controls on all blast machines. To comply with OSHA regulations, the remote control handle, which starts and stops the flow of air and abrasive, must be held down manually. Do not tie down the control handle lever or attempt to bypass any part of the remote control system. Doing so will defeat the purpose of the fail-to-safe feature of the remote control. Serious injury or death could result from uncontrolled blasting. Ref. 29 CFR 1910.244 (b).

3.4.3 If the metering valve is closed, as instructed, only air will exit the nozzle.

3.4.4 Adjust abrasive flow per Section 4.1.

3.5 Stop Blasting

3.5.1 To stop blasting; release the control handle lever. The outlet section of the Millennium valve opens, and the blast machine depressurizes. The pop-up valve automatically drops when air is expelled from the machine and pressure equalizes.

3.5.2 When the control handle lever is released, the control handle safety lever will flip up to lock the handle lever in the up (no blast) position.

3.5.3 Make sure that the control handle safety lever lock is up, and that it prevents the handle lever from engaging.

3.5.4 Always open the safety petcock during work breaks and before filling the blast machine. Opening the petcock prevents unintentional blasting.

3.6 Loading Abrasive into the Blast Machine

WARNING

Obtain a material safety data sheet (MSDS) for the blast abrasive. Abrasive blasting with sands containing crystalline (free) silica can lead to serious or fatal respiratory disease. As NIOSH recommends, do not use abrasives containing more than trace amounts (more than one percent) free silica.

When approaching an idle blast machine, and before loading the blast machine with abrasive, always check to make sure the safety petcock is open. If it is closed, open it while standing back and facing away from the concave head and exhaust muffler. This step is especially important if one worker (a machine tender) loads the machine with abrasive while another worker (the blast operator) controls the blasting. The blast operator could pressurize the machine before the machine tender has moved away from the machine. During pressurization, abrasive could be forced out of the top of the machine, and cause injury.

3.6.1 Load abrasive into the machine by pouring it through the screen into the concave head. Use a screen placed over the head to prevent objects from falling inside. Foreign objects will jam the machine. Abrasive flows through the filling port into the machine. Keep the abrasive level below the pop-up valve. Abrasive resting on the pop-up valve could be forced up and out of the top of the machine when the machine is pressurized.

NOTE: Use only abrasives specifically manufactured for blast cleaning, that are compatible with the surface being blasted. Abrasive produced for other applications may be inconsistent in size and shape, and contain particles that could jam the abrasive metering valve, or cause irregular wear. Some abrasive may contain salts, corrosives, or other materials that could contaminate the surface being blasted.

3.6.2 When the blast operator is ready, either the operator or the machine tender, while standing back and

facing away from the concave filling head and exhaust muffler, closes the safety petcock.

3.7 Emptying the Machine of Abrasive

3.7.1 When working in environments subject to extreme temperature changes, or very humid conditions, condensation may develop inside the machine. Condensation dampens abrasive and causes flow problems. To prevent this, empty the machine of all abrasive when shutting down for the day. This will eliminate trouble from moist abrasive when starting a new day's blasting. One way to avoid having to empty the machine is to load only as much abrasive as will be used during the work period. If the machine must be purged of abrasive, do the following.

3.7.2 With the blast machine off, turn the blast pressure down to approximately 40-50 psi, close the choke valve and set the abrasive metering valve at full open.

3.7.3 To prevent rapid wear of the nozzle holder threads, the nozzle should be firmly attached to the nozzle holder. Removal of the nozzle is not recommended. If circumstances require the nozzle to be removed, also remove the nozzle washer. Purging the machine without a nozzle in place will erode the thread area of the nozzle holder, which could cause a hazardous condition.

3.7.4 Point the nozzle into a drum or suitable container, or in the direction the abrasive is to be disposed.

3.7.5 Hold the hose securely (do not leave the hose unattended), and pressurize the machine by activating the control handle. Be prepared for surging, or recoil of the hose, which can be severe.

3.7.6 When the machine is empty, release the control handle lever, open the safety petcock, and open the choke valve.

⚠ WARNING

The threads on the nozzle and nozzle holder must be inspected each time the nozzle is secured to the holder. Make sure the threads are not worn, and that the nozzle holder securely grips the nozzle. The nozzle washer must also be inspected for wear. Worn nozzle washers cause thread erosion. A loose fitting nozzle may eject from the holder under pressure and could cause severe injury.

3.7.7 If the nozzle was removed, thoroughly inspect the nozzle holder threads for wear before installing the nozzle washer and attaching the nozzle.

3.8 Shutdown

3.8.1 Close the compressed-air supply valve at the compressor.

3.8.2 Drain receiver tank, air filters, and water collecting devices, and bleed the compressed-air supply hose.

3.8.3 Shutdown the compressor.

3.8.4 Cover the blast machine when not in use.

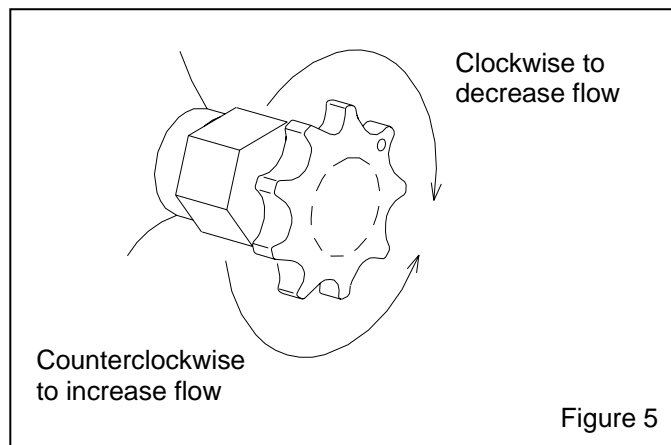
4.0 ADJUSTMENTS

4.1 Abrasive Metering, Figure 5

4.1.1 Abrasive flow is adjusted at the metering valve located at the bottom of the blast machine. Use the metering knob to adjust abrasive flow.

4.1.2 The hole in the knob enables the operator to monitor its rotation and count turns as the knob is turned. This helps return the setting to its original position, should temporary adjustments be required.

4.1.3 The valve is closed when the knob is fully clockwise. Begin with the knob set 1-1/2 turns from fully closed. While the operator is blasting, the machine tender turns the knob no more than 1/4 turn counterclockwise, to increase abrasive flow. Allow 10 to 15 seconds for the flow to stabilize before readjusting. Continue making adjustments as described until the correct flow is attained.



4.1.4 Optimum abrasive flow depends on the type and size of abrasive and blasting pressure, and can best be determined by experience. Use as little abrasive as possible while maintaining the maximum cleaning rate. The air/abrasive mixture should be mainly air. As a rule, the stream of abrasive coming out of the nozzle should barely discolor the air when seen against a contrasting background.

5.0 PREVENTIVE MAINTENANCE

5.1 Daily Inspection

5.1.1 With the air off, before blasting, do the following:

- Empty the abrasive trap and clean the abrasive trap screen. Do this at least twice a day, or more often if the machine is frequently cycled. Failure to clean the abrasive trap on a regular basis is a major cause of system malfunction. See Section 6.10.
- Inspect the blast hose for wear; look for soft spots. Soft spots mean the hose is worn. Replace the blast hose before the tube wears as far as the fabric plies.

WARNING

Worn blast hose could suddenly fail by bursting. Couplings and nozzle holders may not adequately grip worn hose causing them to blow-off under pressure. Compressed air and abrasive escaping from a burst hose, or disconnected coupling or nozzle holder, could cause severe injury.

- Check to make sure that couplings are secure and lock pins and safety cables are in place.
- Make sure the nozzle washer is in place and not worn.

WARNING

The threads on the nozzle and nozzle holder must be inspected each time the nozzle is secured to the holder. Make sure the threads are not worn, and that the nozzle holder securely grips the nozzle. The nozzle washer must also be inspected for wear. Worn nozzle washers cause thread erosion. A loose fitting nozzle may eject from the holder under pressure and could cause severe injury.

- Inspect the RLX Control Handle, look for the following:
 - The lever must not seal the opening on the control, unless the safety lever lock is pulled down.
 - The **handle lever** must return to the "up" position when released.
 - The **safety lever lock** must return to the "up" position when the handle lever is released.
 - Both the handle lever and safety lever lock must move freely with no drag or binding.

WARNING

Malfunctioning control handles could cause unintentional actuation of a blast machine, or prevent a machine from deactivating upon release. Malfunctioning control handles must be taken out of service immediately and repaired or replaced. Serious injury or death can result from unintentional blasting.

5.1.2 During blasting, do the following:

- Check the control handle for leaks.
- Inspect all couplings and coupling gaskets for leaks.
- Check the blast machine for leaks. If leaks are found around the pop-up valve, inspection door, or pipe fittings at the bottom of the cone, stop blasting immediately and repair or replace worn parts. If leaks are allowed to continue, abrasive erosion could cause irreparable damage to the blast machine.
- Check all external piping, control hoses, and valves for leaks. If leaks are found, stop blasting and repair.
- Inspect blast hose, couplings, and nozzle holders for leaks. At the first sign of a leak, stop blasting and inspect all items for wear.

WARNING

Leaks around couplings and nozzle holders indicate worn or loose-fitting parts. Nozzle holders and couplings that do not fit tight on hose, and nozzles that do not fit tight in nozzle holders could disconnect while under pressure. Impact from nozzles, couplings, hoses, or abrasive, from parts disconnected by pressure during operation could cause severe injury.

5.2 Weekly Inspection

5.2.1 With the air off, before blasting, do the following:

- Remove the nozzle for inspection. Replace if the orifice diameter is worn 1/16" or more, or if the liner is cracked.
- If the optional air filter is used, inspect the filter element, and clean the bowl.

5.2.2 During blasting do the following:

- Note the time it takes to fully depressurize the machine after the control handle is released. When depressurizing time increases noticeably, inspect the exhaust muffler per Section 6.5.

5.3 Monthly Inspection

5.3.1 With the air off, before blasting, do the following:

- Check the pop-up valve's urethane coating for cracks and grooves. Replace the pop-up valve at the first sign of wear. See Section 6.8.
- Inspect the rubber pop-up seal, and replace at the first sign of wear, drying, or cracking. See Section 6.9.
- Inspect exhaust muffler for blockage and wear, per Section 6.5.

5.4 Periodic Inspection

5.4.1 Millennium Control Valves: For safety and to avoid unscheduled downtime, periodically inspect the internal parts of the inlet and outlet valves, and abrasive trap. Inspect for wear and lubrication on O-rings, pistons, springs, seals, and castings. See Service Maintenance in Sections 6.3, 6.4, and 6.10.

5.4.2 RLX II Control Handle: Periodically clean around the springs, handle lever, and lever lock to ensure that the unit is free of abrasive and debris that may cause the handle lever or lever lock to bind. See Section 6.6.

6.0 SERVICE MAINTENANCE

WARNING

Failure to observe the following before performing any maintenance could cause serious injury or death from the sudden release of compressed air.

- **Depressurize the blast machine.**
 - **Lock-out and tag-out the compressed air supply.**
 - **Bleed the air supply line to the blast machine.**
-

6.1 Removing Damp Abrasive From The Blast Machine.

6.1.1 To clear a minor blockage caused from damp abrasive, during operation, rapidly open and close the choke valve several times.

6.1.2 For more difficult blockages, proceed as follows: See Section 6.2 to check for obstructions in the metering valve.

6.1.2.1 With the blast machine off, disconnect the blast hose and remove the gasket from the quick coupling on the machine.

6.1.2.2 Place the machine so that the outlet is pointed away from any objects or persons.

WARNING

The machine's outlet must be pointed away from any objects or persons. Stand clear of the path of exiting abrasive. It may come out at high velocity. Impact from exiting abrasive could cause severe injury.

6.1.2.3 Close the choke valve and fully open the abrasive metering valve. Pressurize the machine to force out any damp abrasive.

6.1.2.4 When the obstruction has been removed, depressurize the machine. Remove the nozzle and nozzle washer, and reconnect the hose. Open the choke valve and close the abrasive metering valve. Pressurize the machine to clear the hose. When the hose is cleared, depressurize the machine and attach the nozzle washer and nozzle.

⚠ WARNING

The threads on the nozzle and nozzle holder must be inspected each time the nozzle is secured to the holder. Make sure the threads are not worn, and that the nozzle holder securely holds the nozzle. The nozzle washer must also be inspected for wear. Worn nozzle washers could erode nozzle threads. A loose fitting nozzle may eject under pressure and could cause severe injury.

6.1.2.5 With the hose cleared, start the machine using normal procedures.

6.2 Clearing Obstructions In The Abrasive Metering Valve And Blast machine.

6.2.1 If the nature of the obstruction permits emptying the machine of abrasive, do so by following the instructions per Section 3.7.

6.2.2 Turn off the compressed air supply. Lock-out and tag-out the air supply, and bleed the air supply line to the blast machine.

6.2.3 Remove the wing nuts securing the abrasive metering valve's inspection plate.

6.2.4 Check the metering valve for blockage, by inserting fingers into the opening to feel for an obstruction or foreign object.

6.2.5 If the metering valve is clear, remove the blast machine inspection door , and check for foreign objects.

6.2.6 Make sure the inspection door gasket is in good condition and in place before bolting the door onto the machine.

6.2.7 Make sure the abrasive metering valve inspection plate O-ring is in good condition and in place before reassembling the inspection plate.

6.2.8 Check to make sure all inspection doors are secure before starting the air supply.

6.3 Millennium Valve Inlet Segment, Ref. Figure 6.

NOTE: Two service kits are available for the Millennium valve inlet segment. To avoid unscheduled down-time, both kits should be kept on-hand. Replace all the seals provided in the seal service kit whenever the valve is opened. Use the plunger tip kit when replacing the plunger tip.

6.3.1 Unscrew the six socket head screws to remove the cylinder cap, cylinder cap gasket, and spring.

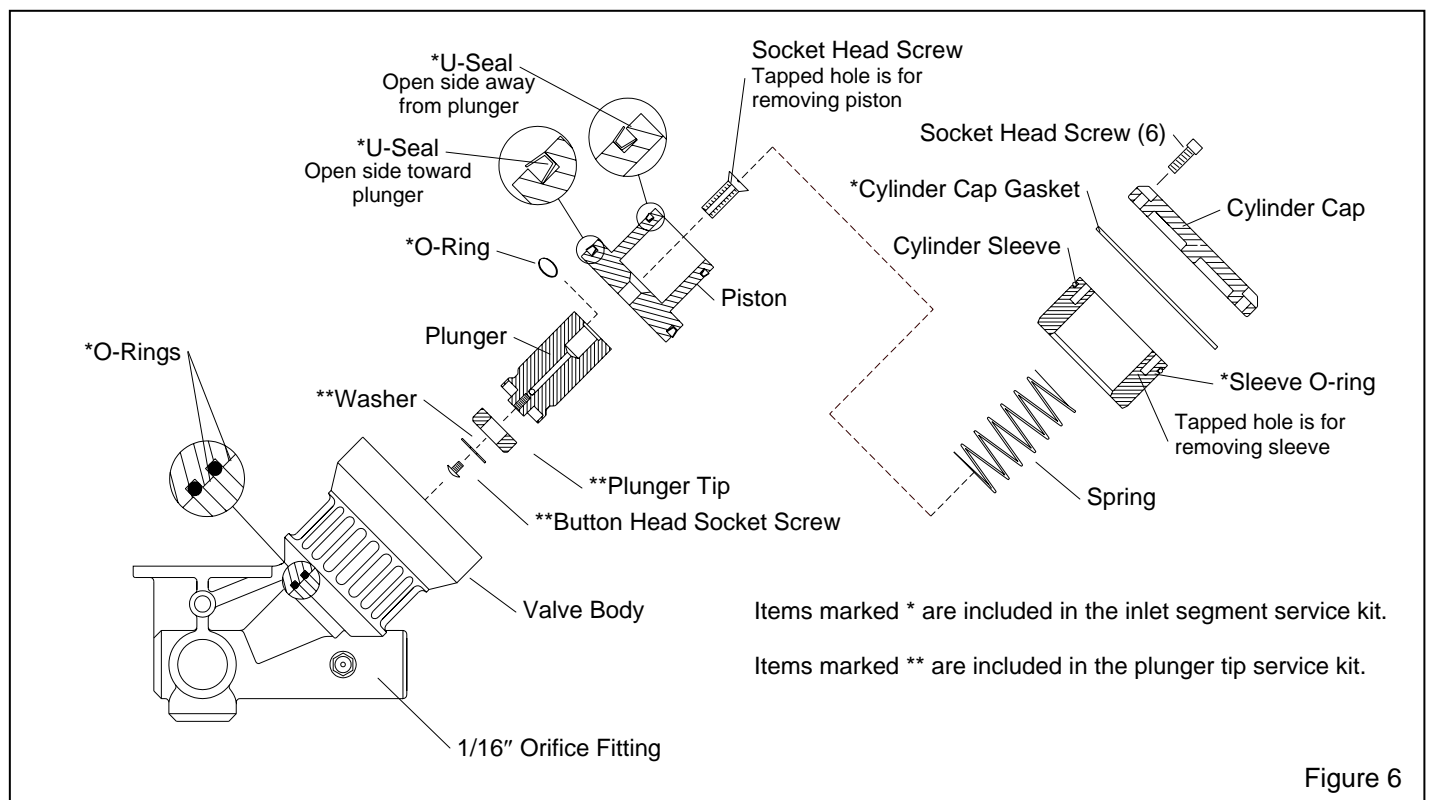


Figure 6

6.3.2 Remove the cylinder sleeve by screwing two 1/4-NC screws into the holes in the end of the sleeve and by pulling the screws to remove the sleeve from the body. If the sleeve is too tight to remove by hand, use a puller. Remove the screws after the sleeve is removed.

6.3.3 To remove the piston, screw a 1/4-NC screw into the center of the socket head screw, grip the screw, and pull out. If the piston is too tight to remove by hand, use a puller. Remove the screw after the piston is removed.

6.3.4 It is not necessary to separate the plunger from the piston unless the metal of either part is scored. To remove the plunger, insert a rod through the hole in the lower part of the plunger. Hold the rod to prevent the plunger from turning, while using a 5/16" hex key to remove the socket screw from inside the piston

6.3.5 If the plunger tip is worn, use a 3/16" hex key to remove the button screw, washer, and tip.

6.3.6 Clean all items and inspect for wear. Replace all seals and O-rings (they are included in the service kit), and replace all worn or damaged parts.

- Inspect the plunger tip. Replace the tip if worn or damaged.
- Inspect the machined plunger seat in the valve body for wear. Replace the body if the seat is worn.

6.3.7 If the plunger and piston were separated as noted in paragraph 6.3.4, apply removable thread sealant to the socket head screw, and reassemble the parts using a new O-ring supplied with the service kit.

6.3.8 Lubricate O-rings and U-seals with a silicon-based lubricant.

6.3.9 Replace both O-rings in the valve body

6.3.10 Place the U-seals into the grooves on the piston, the open side of the large seal faces the plunger, and the open side of the small one faces away from the plunger, as shown in Figure 6.

6.3.11 Install the plunger and piston assembly into the body. Make sure the open side of the large (lower) U-seal does not fold back during assembly. Tucking the lip of the seal in, while applying pressure to the piston eases assembly.

6.3.12 Place the O-ring on the cylinder sleeve, and insert the sleeve (O-ring end faces up) into the body, making sure the open side of the small (upper), piston U-seal does not fold back during assembly.

6.3.13 Install the spring, cylinder cap gasket, and cylinder cap.

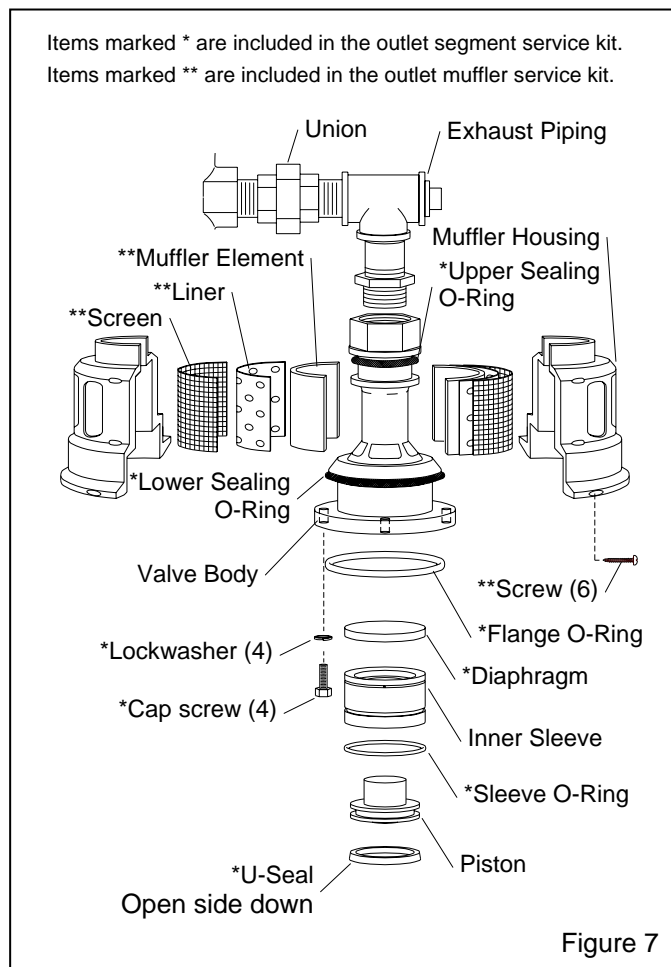
6.3.14 Tighten the six socket head screws in sequence to secure the cap.

6.3.15 If fittings on the body were removed, make sure the 1/16" orifice fitting is threaded into the port as shown in Figure 6.

6.4 Millennium Valve Outlet Segment, Ref. Figure 7

NOTE: Two service kits are available for the Millennium valve outlet segment. To avoid unscheduled down-time, both kits should be kept on-hand. Replace all the seals provided in the service kit whenever the valve is opened, or when replacing the diaphragm. Use the muffler service kit when replacing the muffler.

6.4.1 Loosen the exhaust piping union nut.



6.4.2 Unscrew the four hex head cap screws securing the outlet body to the inlet, and remove the exhaust assembly.

6.4.3 Screw a 1/4-NC screw into the threaded hole in the bottom of the piston. Grip the screw, and pull out to remove the piston. Remove the screw after the piston is extracted.

6.4.4 Screw 1/4-NC screws into the threaded holes in the bottom of the inner sleeve. Grip the screws, and pull out to remove the sleeve. Remove the screws after the sleeve is extracted.

6.4.5 Remove the diaphragm from the bottom of the exhaust valve body.

6.4.6 Clean all items and inspect for wear. Replace the diaphragm, seals and O-rings (they are included in the service kit), and replace all worn or damaged parts.

- Place the piston into the inner sleeve and check movement. If the parts drag, or if abraded or worn they must be replaced.
- Inspect the machined seat in the exhaust body for wear. The body must be replaced if the seat is worn.

6.4.7 Inspect the exhaust muffler per Section 6.5.

6.4.8 Lubricate the U-seal with a silicon-based lubricant, and place the U-seal into the groove in the piston. The open side of the seal must face the bottom of the piston, as shown in Figure 7.

6.4.9 Verify that the inner sleeve O-ring is in the lower groove, not in the upper groove, which has the vent hole.

6.4.10 Insert the piston into the sleeve.

6.4.11 Place the diaphragm in the valve body.

6.4.12 Slide the piston and sleeve assembly into the valve body, the piston faces away from the bottom of the body, as shown in Figure 7.

6.4.13 Place the flange O-ring into the flange groove, and position the outlet assembly onto the inlet section. Align the exhaust piping by hand tightening the four cap screws with lockwashers, and union nut.

6.4.14 Tighten the four hex head cap screws. After the screws are secure, tighten the exhaust piping union.

6.5 Exhaust Muffler, Figure 7

6.5.1 Separate the two halves of the muffler housing by removing the six screws, and pry the halves apart. Note that the screw holes in the housing are not the same size. The side of the housing with the hex recess has a smaller diameter than the other. The screw is inserted into the larger diameter hole, and grips the smaller diameter hole.

6.5.2 Remove the muffler element, rubber liner and screen from each housing half.

6.5.3 Inspect the inside of the muffler element for a build-up of deposits that blocks the porosity of the element. Replace the elements if plugged.

6.5.4 Inspect the two sealing O-rings on the exhaust body, and replace them if worn or damaged.

6.5.5 Clean and inspect all parts that are to be reused, replace if worn. Reassemble the exhaust muffler in reverse order.

6.6 RLX II Control Handle

NOTE: A service kit is available for the RLX Control Handle. To avoid unscheduled down-time, a kit should be kept on-hand.

6.6.1 Spring replacement

6.6.1.1 To replace the lever lock spring, follow the instructions in Section 6.6.2. To replace the handle lever spring, follow the instructions in Section 6.6.3.

6.6.2 Lever lock replacement, Figure 8

6.6.2.1 Remove the lock nut from the shoulder screw. Before removing the screw, note the positions of the spacers and spring, as shown in Figure 8. The bent end of the spring is toward the inside and forcing the lever lock up. The straight end is toward the outside facing down and against the tab.

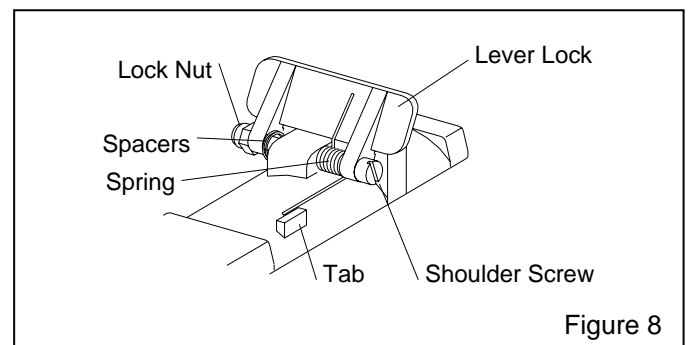
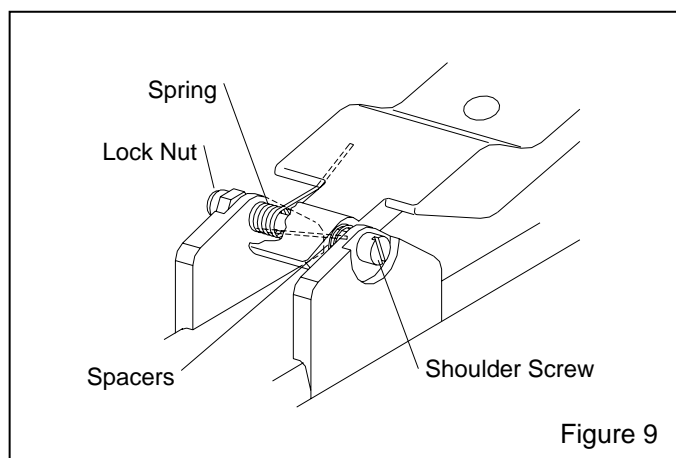


Figure 8

6.6.2.2 Install a new lever lock and spring, and reassemble in reverse order.

6.6.2.3 Make sure the lever lock moves freely, raises to full up position, and that the handle lever will not engage unless the lever lock is pulled down.

6.6.3 Handle lever replacement, Figure 9



6.6.3.1 Remove the lock nut from the shoulder screw. Before removing the screw, note the positions of the spacers and spring as shown in Figure 9. The bent end of the spring is against the handle lever and facing up. The straight end is against the body and facing down.

6.6.3.2 Install a new handle lever and spring, and reassemble in reverse order.

6.6.3.3 Make sure the handle lever moves freely, raises to full up position, and will not engage unless the lever lock is pulled down.

6.6.4 Rubber button replacement

6.6.4.1 Remove the old rubber button.

6.6.4.2 Install the new button, stem first, by pushing it from the bottom side of the handle lever. Pull the stem to seat the button.

6.6.4.3 Trim the button stem flush with the top of the handle lever.

6.6.5 Gasket replacement

6.6.5.1 Remove the handle lever per Section 6.6.3.

6.6.5.2 Remove the six screws holding the pneumatic adapter to the body.

6.6.5.3 Install a new gasket.

6.6.5.4 Place the pneumatic adapter on the gasket and hand tighten all screws before tightening them in sequence to uniformly compress the gasket.

6.6.5.5 Reassemble the handle lever, making sure the spacer washers and spring are in place.

6.6.5.6 Make sure the handle lever moves freely, raise to full up position, and will not engage unless the lever lock is pulled down.

6.7 Quantum Manual Metering Valve, Figure 10

NOTE: A service kits are available for the Quantum metering assembly. Keeping a kit on-hand will avoid unnecessary downtime. Replace all seals provided in the kit whenever the valve is opened.

6.7.1 Empty the machine of abrasive. Turn off the compressed air supply. Lockout and tagout the air supply, and bleed the air supply line to the blast machine.

6.7.2 Remove the inspection plate wing nuts and inspection plate.

6.7.3 Remove the four socket head screws securing the metering housing, and remove the housing assembly.

6.7.4 The upper body and outlet flange do not need to be removed from the blast machine to service the metering assembly. Thoroughly inspect both parts for wear, and replace it if worn.

6.7.5 Turn the metering shaft clockwise to remove the shaft from the metering screw.

6.7.6 Loosen the knob nut, and pull the knob assembly from the housing.

6.7.7 Use a drive pin and hammer to force the roll pin from the knob, and remove the knob.

6.7.8 Remove the metering screw by pushing it out the front of the knob nut.

6.7.9 Inspect the metering screw for damage and any signs of abrasive ingress or metal filings.

6.7.10 Clean the metering screw threads, and test the condition of the threads by screwing it into the metering

plate shaft. Replace the metering screw if there is any resistance, binding or metal filings.

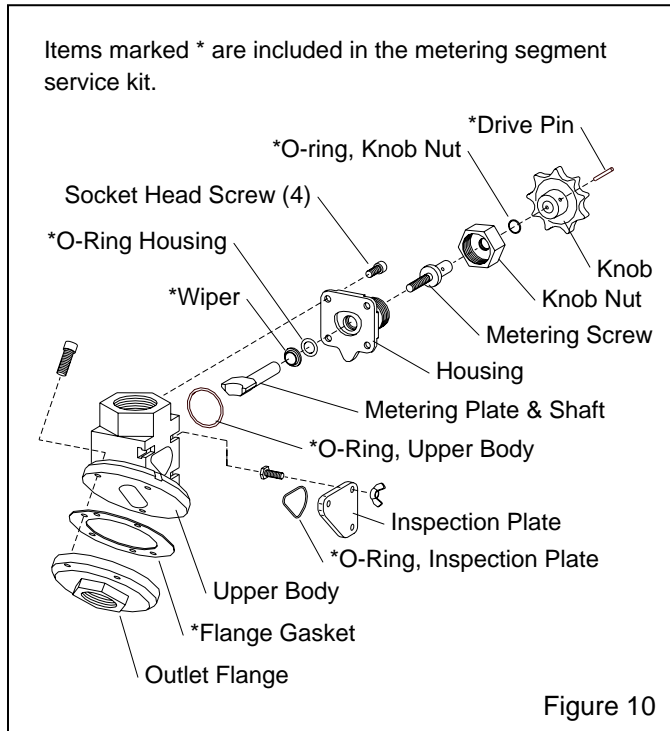


Figure 10

6.7.11 Remove the O-ring from the knob nut, and remove the O-ring and wiper from the housing.

6.7.12 Thoroughly clean and inspect all parts that are to be reused. Replace all worn parts.

6.7.13 Place a new O-ring in the knob nut.

6.7.14 Place a new O-ring and wiper seal in the housing. A generous amount of silicon-based lubricant eases installation. The small side of the wiper seal faces away from the O-ring.

6.7.15 Insert the metering plate shaft through the housing bore, and wipe off any lubricant on the metering plate side of the bore.

6.7.16 Reassemble the metering screw, nut, knob, and drive pin. Note: applying a small amount of silicon-based lubricant on the unthreaded end of the metering shaft eases insertion through the nut O-ring.

6.7.17 Apply a molybdenum disulfide or graphite based anti-seize lubricant to the metering shaft and metering screw threads, and thread the shaft onto the screw.

6.7.18 Place a new O-ring in the groove on the face of the upper body.

6.7.19 Insert the metering plate (flat side up) through the upper body opening. Take care not to displace the O-ring.

6.7.20 Secure the metering housing finger tight before tightening all screws.

6.7.21 Place a new O-ring on the inspection plate, and securely attach the plate.

6.7.22 Service of the metering assembly is complete. Test the machine and piping for air leaks before putting into service.

6.8 Replacing The Pop-Up Valve, Figure 11

6.8.1 All service on the pop-up valve must be done with the compressed air off and the air supply locked-out and tagged-out.

6.8.2 To gain access to the pop-up valve, remove the inspection door assembly.

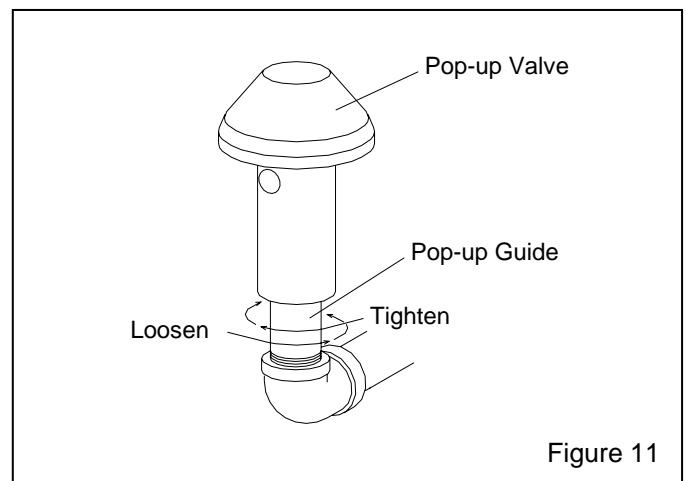


Figure 11

6.8.3 Using a small pipe wrench, unscrew the pop-up valve guide by turning it counterclockwise. Remove the pop-up valve and guide from the machine.

6.8.4 While the pop-up valve is out, check alignment as follows: Screw a 1-1/4" nipple, which is at least 12" long, into the elbow in place of the pop-up guide. Check the alignment through the pop-up filling port. The nipple should be close to the center of the port. If it is not, adjust the horizontal pipe. A misaligned pop-up valve could result in early valve failure, or abrasive leakage when the machine is pressurized or depressurized.

6.8.5 Slide the new pop-up valve over the guide, and then screw the valve guide (with the pop-up valve on it) into position inside the machine. Tighten the guide snug, but not wrench-tight. Over-tightening the guide will make it difficult to remove the next time the pop-up valve needs replacement.

6.8.6 Refer to Figure 12 to check the pop-up height. If the pop-up sits too low, misalignment could occur when the pop-up comes up against the seal. If the pop-up sits too high, it will take longer for abrasive to flow through the opening. Adjust the height by replacing the guide with one that is longer or shorter.

6.8.7 Put a new gasket on the inspection door assembly before bolting the door onto the machine.

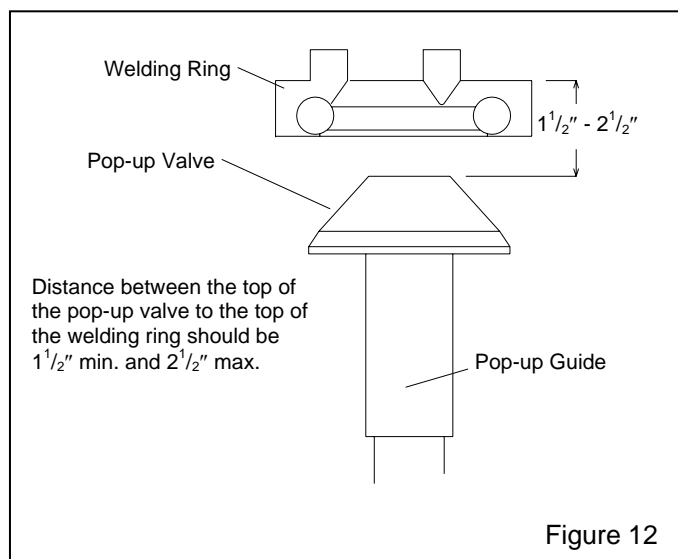


Figure 12

6.9 Replacing The Pop-Up Seal

6.9.1 All service on the blast machine must be done with the compressed air off and the air supply locked-out and tagged-out.

6.9.2 Remove the old seal using fingers, screwdriver, or similar object, to work the seal out of the retaining groove.

6.9.3 Push the new seal all the way through the port and then fit it into the retaining groove. For the last few inches, pull up on the seal and allow it to pop into position.

6.10 Abrasive Trap

NOTE: A service kit is available for the abrasive trap. To avoid unscheduled down-time, a kit should be kept on-hand.

6.10.1 All service on the abrasive trap must be done with the compressed air off and the air supply locked-out and tagged-out.

6.10.2 Clean the abrasive trap screen and trap at least twice a day. **NOTE:** Failure to clean the abrasive trap on a regular basis is a major cause of system malfunction.

6.10.3 To check the abrasive trap screen, loosen the top thumbscrew, and swing the lock bar off the cap, and remove the cap.

6.10.4 Remove the screen and inspect it for wear and blockage. Replace it when it is clogged or worn. Keep spare screens on hand. Do not install the screen in the trap until the bottom section of the trap is cleaned per the following instructions.

6.10.5 To clean the bottom section of the trap, loosen the bottom thumbscrew, and swing the lock bar off the bottom cap, and remove the cap.

6.10.6 Empty all abrasive from the bottom and top sections.

6.10.7 Install the screen in the top section. The small end of the screen must face up.

6.10.8 Reassemble the top and bottom caps. Make sure the O-rings are in place on the caps before assembly, and the screen gasket is in place in the top cap.

7.0 TROUBLESHOOTING

NOTE: This section only identifies conditions and problems in the blast machine and remote control system. Always refer to the appropriate section of this manual, or manuals for accessory equipment, before servicing the equipment.

WARNING

To avoid serious injury, observe the following when troubleshooting the machine and remote controls.

- **Turn off the compressed air, and lock-out and tag-out the air supply.**
 - **When checking the controls requires air, always enlist the aid of another person to operate the control handle while holding the nozzle securely and pointing it in a safe direction.**
 - **Never strap the remote control handle lever down in the operating position.**
-

7.1 Neither Abrasive Nor Air Comes Out Of The Nozzle While The Machine Is Under Pressure

7.1.1 Depressurize the blast machine. After the pop-up valve has dropped, remove the nozzle, and check it for obstruction.

7.1.2 Make sure that both the abrasive metering valve and choke valve are open.

7.2 Air Only (no abrasive) Comes Out The Nozzle

7.2.1 Abrasive metering valve may be closed or needs adjustment. See Section 4.1.

7.2.2 Blast machine may be empty.

7.2.3 Abrasive may be damp. See Section 6.1 to clear damp abrasive.

7.2.4 Check the abrasive metering valve for obstructions. See Section 6.2.

7.3 Heavy Abrasive Flow

7.3.1 Make sure the choke valve is open. The valve is open when the handle is in-line with the piping.

7.3.2 Abrasive metering valve may be open too far. See Section 4.1.

7.4 Abrasive Surging

7.4.1 A certain amount of abrasive surge is normal at start-up. Should the flow of abrasive continue to surge, reduce the amount of abrasive in the air stream by adjusting the metering valve. See Section 4.1.

7.4.2 Check the abrasive trap and exhaust muffler for blockage. Slow depressurization will load the blast hose with abrasive, and cause surging at start-up. See Section 7.7.

7.5 Intermittent Abrasive Flow

7.5.1 Moisture in the blast machine or in the air supply. Drain moisture from the compressor's receiver tank, and the blast machine's air filter. If moisture continues to be a problem, a dryer or after cooler may be required in the air supply line.

7.5.2 Abrasive may be worn from recycling. Replace abrasive.

7.6 Blast Machine Does Not Pressurize

7.6.1 Make sure the compressor is on and all air supply valves to the machine are open.

7.6.2 Make sure the safety petcock on the inlet valve is closed.

7.6.3 Check the rubber button on the control handle for wear or damage, and make sure the opening on the control handle seals when the handle is pressed.

7.6.4 Check for air escaping through the opening under the control handle lever. If no air is escaping, the orifice on the inlet valve (shown in Figure 2) is blocked, or the line from the orifice to the control handle is blocked and must be cleared.

7.6.5 Press the control handle lever. Feel and listen for air leaks anyplace on the handle. No air should escape when the handle lever is pressed. If there is a leak, it must be located and repaired.

7.6.6 Check control lines and fittings for leaks or breaks.

7.6.7 Open the safety petcock, and press the control handle lever; air should come out of the petcock. If it does not, check the following:

- The opening on the control handle is not being sealed off.

- The control handle leaks.
- The line from the control handle to the upper fitting on the inlet valve is blocked.

If air does come out, then the inlet section of the Millennium valve is not functioning. Turn off the compressed air supply and service the valve per Section 6.3.

7.6.8 Close the safety petcock, and press the control handle lever. Verify that no air escapes through the vent hole on the cylinder body of the inlet valve body. Air escaping from this vent indicates worn seals in the inlet valve. See Section 6.3.

7.6.9 Inlet valve malfunctioning. Inspect internal parts for wear, and lubrication. See Section 6.3.

7.6.10 Insufficient-size air supply hose or reduced-size fittings between the compressor and blast machine. See Section 3.2.2.

7.6.11 Dirty filter element in optional air filter. Check filter element.

7.6.12 Pop-up valve stuck, or internal piping worn or out of alignment. Inspect internal piping.

7.7 Blast Machine Does Not Depressurize Or Depressurizes Too Slowly

7.7.1 Abrasive trap screen blocked, or abrasive trap needs cleaning. Clean the trap at least twice daily.

7.7.2 Exhaust muffler blocked. See Section 6.5.

7.7.3 Check the pneumatic adaptor gasket on the control handle for swelling, which restricts air flow through the handle.

7.7.4 Check for blockage in the control hose.

7.7.5 Check the fitting on the inlet valve (shown in Figure 16, Item 13). It must have a 1/16" orifice.

7.7.6 Remote control valves malfunctioning. Inspect the inlet and outlet valves per Section 6.3 and 6.4.

7.8 Outlet Valve Does Not Seal

7.8.1 Outlet valve diaphragm worn, or outlet valve requires service. See Section 6.4.

7.9 RLX II Control Handle Lever Fails To Return To The Non-Blast Position (Up) When Released

7.9.1 Check the handle lever for damage that may cause binding against the body.

7.9.2 Check the spring for damage or fatigue.

7.9.3 Replace the handle lever or spring as necessary.

7.10 Lever Lock Fails To Pop Up When The Handle Is Released

7.10.1 Check the lever lock for damage, or build up of debris or abrasive.

7.10.2 Check the lever lock return spring for damage or fatigue.

7.10.3 Replace lever lock or spring as necessary.

8.0 ACCESSORIES AND REPLACEMENT PARTS

8.1 Accessories

- (-) Cover, for 16" blast machine 02335
- (-) Screen, for 16" blast machine 03099
- (-) Safety Cable, 1-1/2" to 3" OD hose 15013

8.2 Blast Machine, Figure 13

Item	Description	Stock No.
1.	Ball valve, 1-1/4" with handle	02397
2.	Handle, 1-1/4" ball valve	22532
3.	Pusher line, 1-1/4" x 28" coupled	23674
4.	Compression coupling, 1-1/4"	01857
5.	Gasket, compression coupling, 1-1/4"	01886
6.	Coupling, 1-1/4" CFP w/6-1/2" nipple	21733
7.	Metering valve, man. Quantum w/wye	22845
8.	Wheel, 10" dia. x 2.75	20349
9.	Inspection door assembly, 6" x 8"	02377
10.	Gasket, inspection door, 6" x 8"	02369
11.	Seal, pop-up valve	02325
12.	Pop-up valve, 4", with external sleeve	03699
13.*	Air filter, optional, 1" manual drain	22424

14.	Millennium valve	21336
15.*	Gasket, CFP coupling, package of 10	08853
16.	Wye, standard 1-1/4"	01818
17.	Internal pop-up guide, 1-1/4" x 6" toe	01753
18.	Rain cap (manual tube cover)	21517
19.	Axle, 1" dia x 30.5"	02402
20.	Washer, 1" thrust	03825
21.	Retaining ring, 1"	03824
22.	Abrasive trap	02011
23.	Gasket, CQGP-2 coupling, pkg of 10	21584
24.	CPF-20 Air filter, optional	03578
25.	Cartridge, CPF filter	03547
26.*	Coupling, nylon, CQPS-1	21088
27.*	Nozzle holder, nylon, NHP-1	04106
28.*	Hose, 1" ID x 50 ft. Supa-T	23104
29.*	Nozzle, TMP-4	23520
30.*	Washer, nozzle, NW-25, pack of 10	91024
31.	Adaptor, 1-1/4" NPT x JIC	22529
32.**	Hose, 5-ft respirator extension, coupled....	24510
33.**	Fitting, 1/4" NPT bulkhead	05605
34.**	Adaptor, 1/4" NPT x 3/8" hose	01019

* Models shown are supplied with original blast machine systems.

** Supplied with factory-installed CPF-20 Air Filter option only.

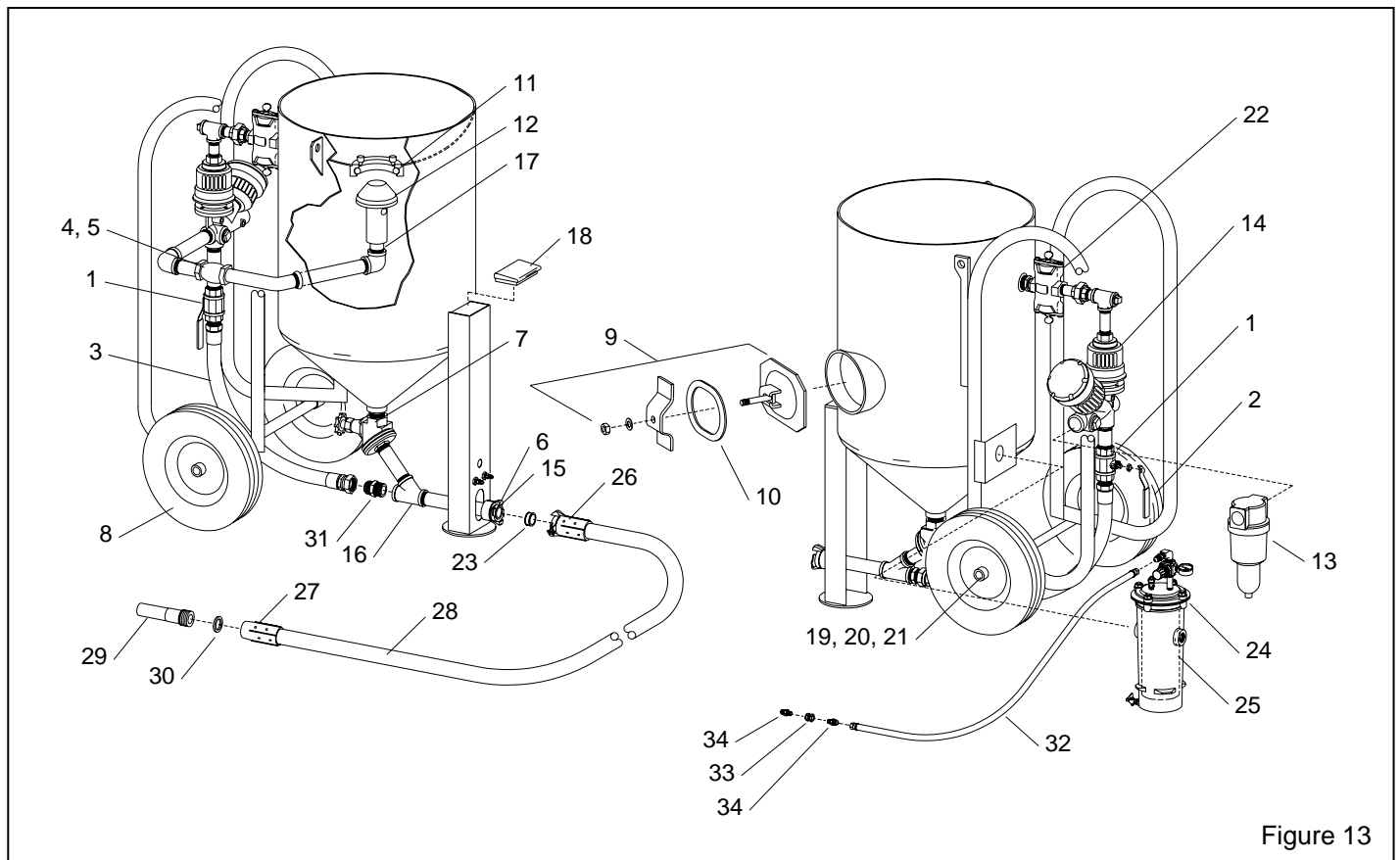
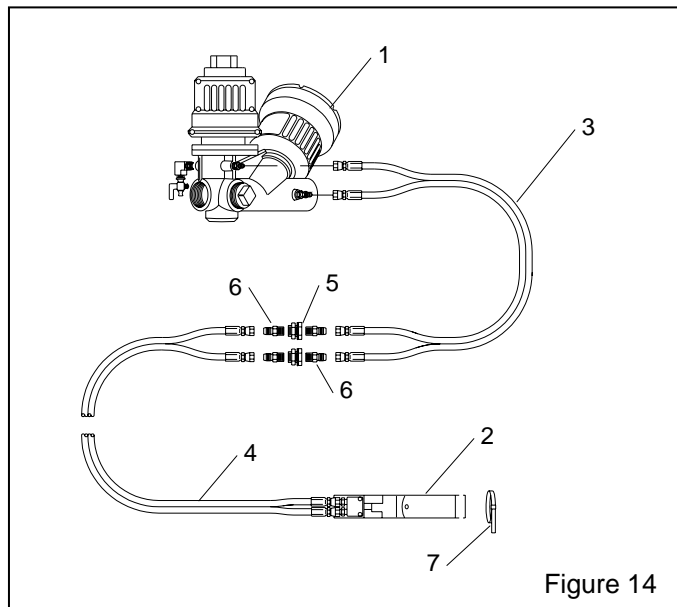


Figure 13

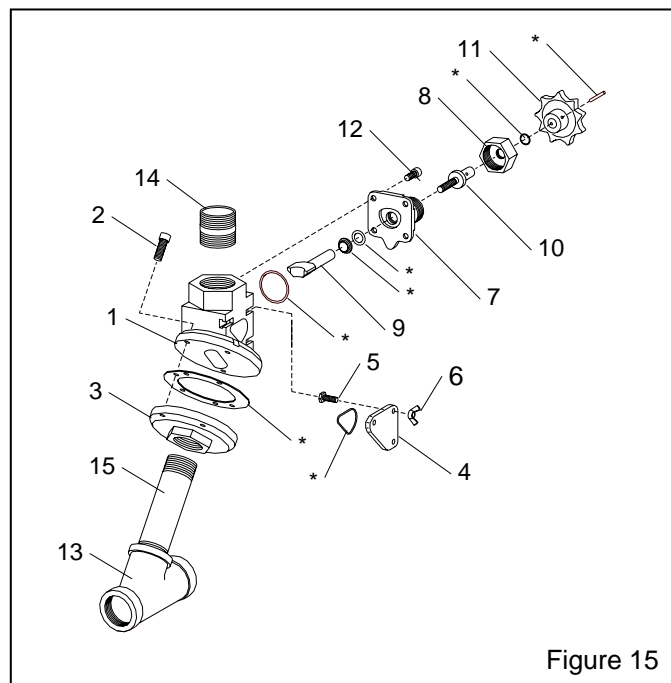
8.3 Remote Control System Parts, Figure 14

Item	Description	Stock No.
1.	Millennium valve	21336
2.	RLX II Control handle	10565
3.	Hose, 4 ft. twinline cpld.	21619
4.	Hose, 50 ft. twinline cpld.	01951
5.	Fitting, 1/4" NPT bulkhead	05605
6.	Adaptor, 1/4" NPT	02494
7.	Tie, nylon	02195



8.4 Quantum Manual Abrasive Metering Valve, Figure 15

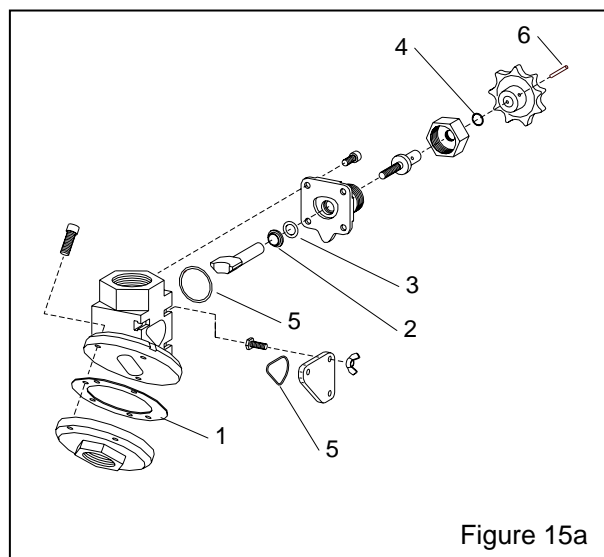
Item	Description	Stock No.
(-)	Quantum manual metering valve w/wye	22845
*	Service kit, metering segment (Fig. 15a) ...	22854
1.	Upper body	21314
2.	Screw, 3/8-NC x 1" socket head	22655
3.	Outlet flange	22621
4.	Inspection plate	22620
5.	Screw, 1/4-NC x 3/4" hex head cap	03052
6.	Nut, 1/4-NC wing	03113
7.	Housing, knob	22761
8.	Nut, knob housing	22762
9.	Metering plate and shaft	22763
10.	Metering screw	22764
11.	Knob, adjustment	22766
12.	Screw, 5/16-NC x 3/4" socket head	22767
13.	Wye, 1-1/4"	01818
14.	Nipple, 1-1/2" x 2" heavy wall	01840
15.	Nipple, 1-1/4" x 5-1/2"	01874



22854 SERVICE KIT QUANTUM METERING SEGMENT

Refer to owner's manual for service instruction.

Item	Qty	Description
1.	1	Flange gasket
2.	1	Wiper seal
3.	1	O-ring, 3/4" OD nominal
4.	1	O-ring, 5/8" OD nominal
5.	2	O-ring 1-1/2" ID nominal
6.	1	Roll Pin



8.5 Millennium Valve Service Kit22899
Includes the following four service kits shown in Sections 8.6 and 8.7: 22856, 22898, 22857, and 22868

8.6 Millennium Valve, Inlet Segment, Figure 16

Item	Description	Stock No.
*	Service kit, Millennium Inlet seals (Fig 16a) .	22856
**	Service kit, Millennium plunger tip (Fig 16b)	22898
1.	Plunger	22600
2.	Dual piston	22602
3.	Spring, 4" long	22604
4.	Screw, socket, w/internal threads	22650
5.	Sleeve, cylinder	22603
6.	Screw, 5/16-NC x 1-1/4", socket head	22611
7.	Body, inlet valve	21338
8.	Cap, cylinder	21339
9.	Plug, 1-1/2" NPT	02477
10.	Nipple, 1/4" NPT hex	02808
11.	Elbow, 1/4" NPT 90° female	06373
12.	Petcock, 1/4" NPT	01993
13.	Adaptor, 1/8" NPT w/1/16" orifice	01945
14.	Bushing, 1/4" x 1/8" brass	02010
15.	Adaptor, 1/4" NPT	02494
16.	Plug, 1-1/4" NPT	01762

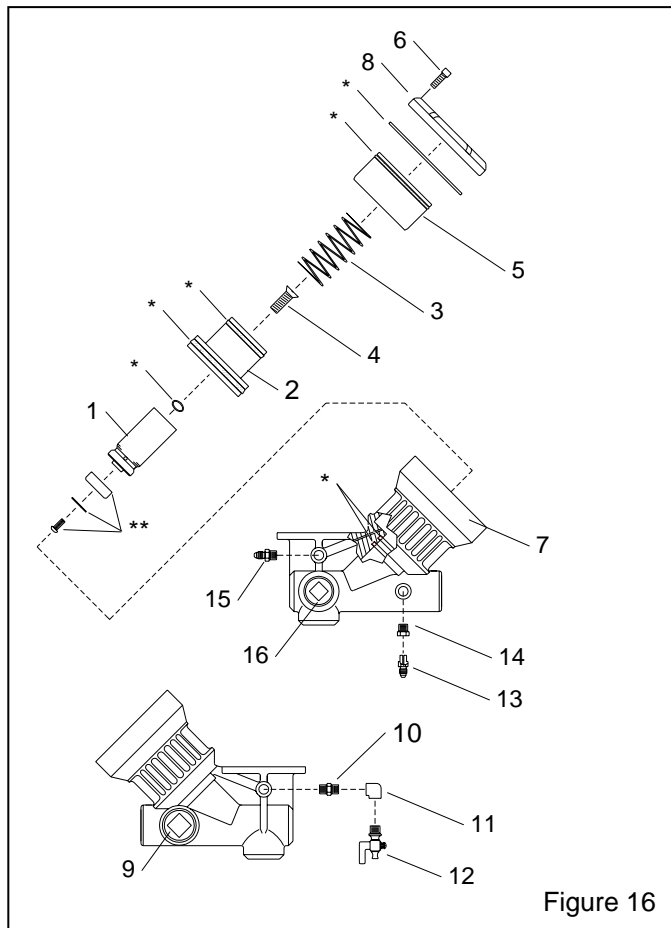


Figure 16

**22856 SERVICE KIT
MILLENNIUM INLET SEGMENT SEALS**

Refer to owner's manual for service instruction.

Item	Qty	Description
1.	2	O-ring, 2-1/8" OD, nominal
2.	1	U-seal, dual piston lower, 3-1/2" ID
3.	1	U-seal, dual piston upper, 2-3/8" ID
4.	1	O-ring, 4-1/8" OD, nominal
5.	1	O-ring, 31/64" ID, nominal
6.	1	Gasket, cylinder cap

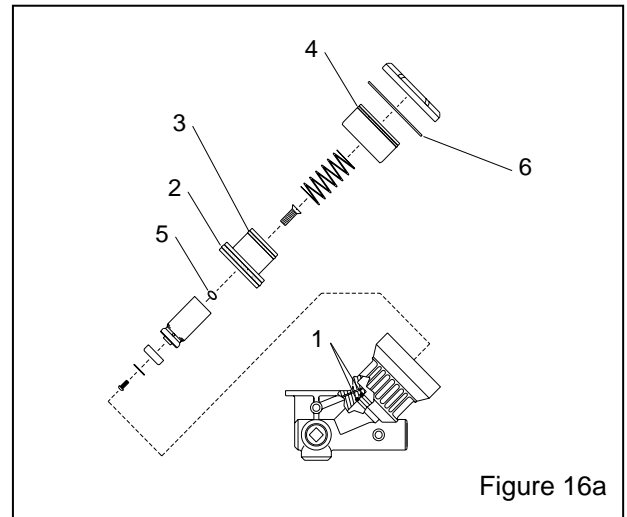


Figure 16a

**22898 SERVICE KIT
MILLENNIUM PLUNGER TIP**

Refer to owner's manual for service instruction.

Item	Qty	Description
1.	1	Screw, 5/16-NC button head
2.	1	Washer, plunger tip
3.	1	Tip, replaceable plunger

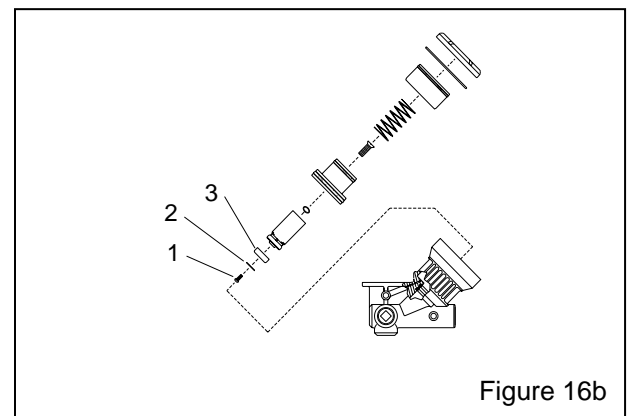


Figure 16b

8.7 Millennium Valve Outlet Segment, Figure 17

Item	Description	Stock No.
*	Service kit, outlet segment (Fig. 17a).....	22857
**	Service kit, muffler (Fig. 17b)	22868
1.	Sleeve, inner	22612
2.	Piston	22613
3.	Housing, muffler, 2 required	21346
4.	Valve body, exhaust	21345

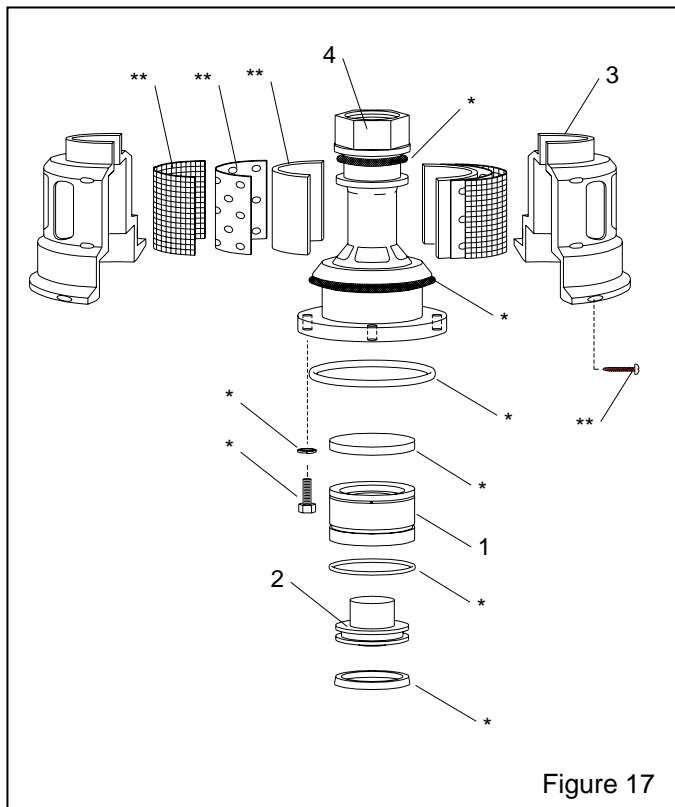


Figure 17

**22857 SERVICE KIT
MILLENNIUM OUTLET SEGMENT**

Refer to owner's manual for service instruction.

Item	Qty	Description
1.	1	O-ring, 1-5/8" ID nominal
2.	1	Diaphragm
3.	1	U-seal, piston
4.	2	O-ring, 3" ID nominal
5.	1	O-ring, 2-7/16" ID nominal
6.	4	Cap screw, 5/16-NC x 1"
7.	4	Lock-washer, 5/16"

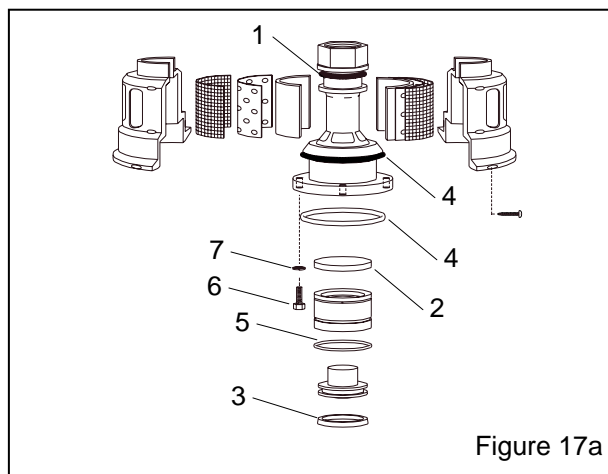


Figure 17a

**22868 SERVICE KIT
MILLENNIUM OUTLET MUFFLER**

Refer to owner's manual for service instruction.

Item	Qty	Description
1.	2	Muffler element
2.	2	Liner, perforated rubber
3.	2	Screen
4.	6	Screw, 12 x 1"

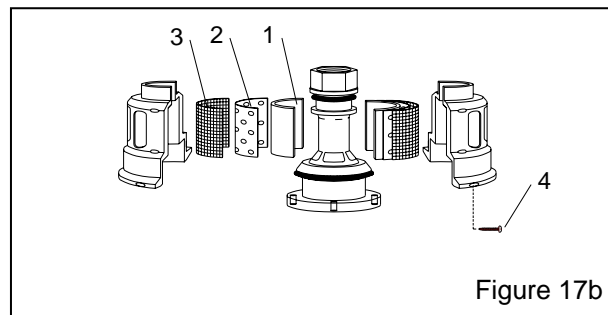
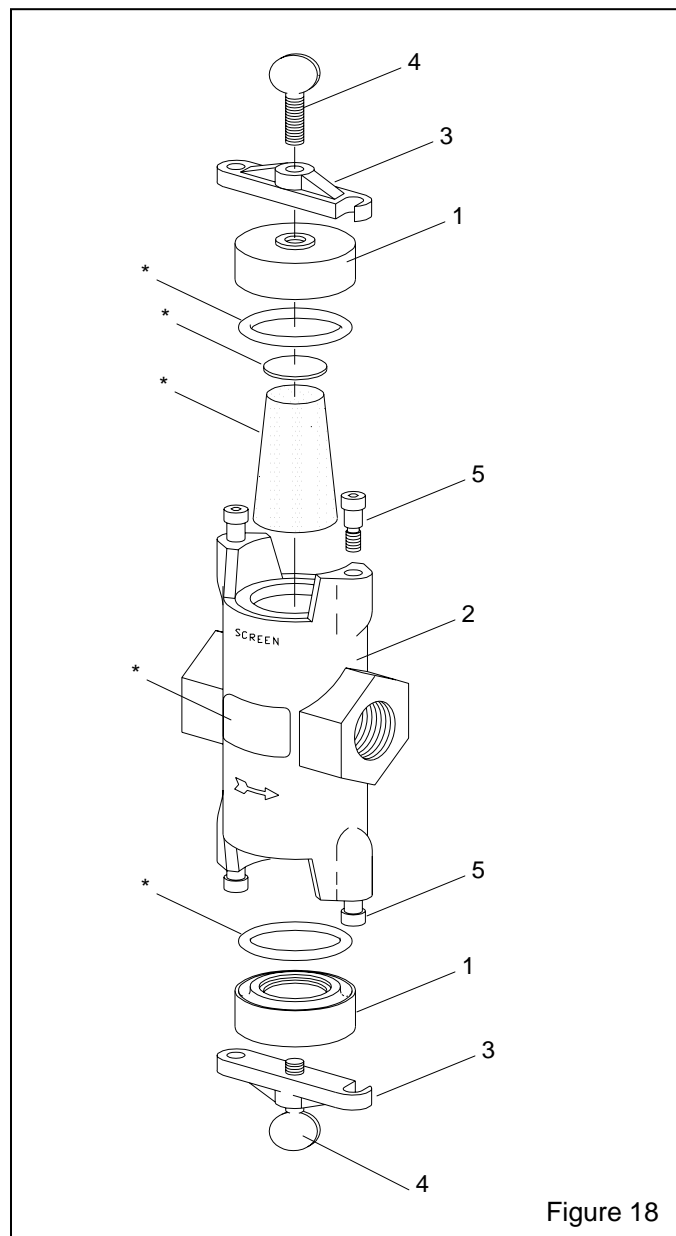


Figure 17b

8.8 Abrasive Trap, Figure 18

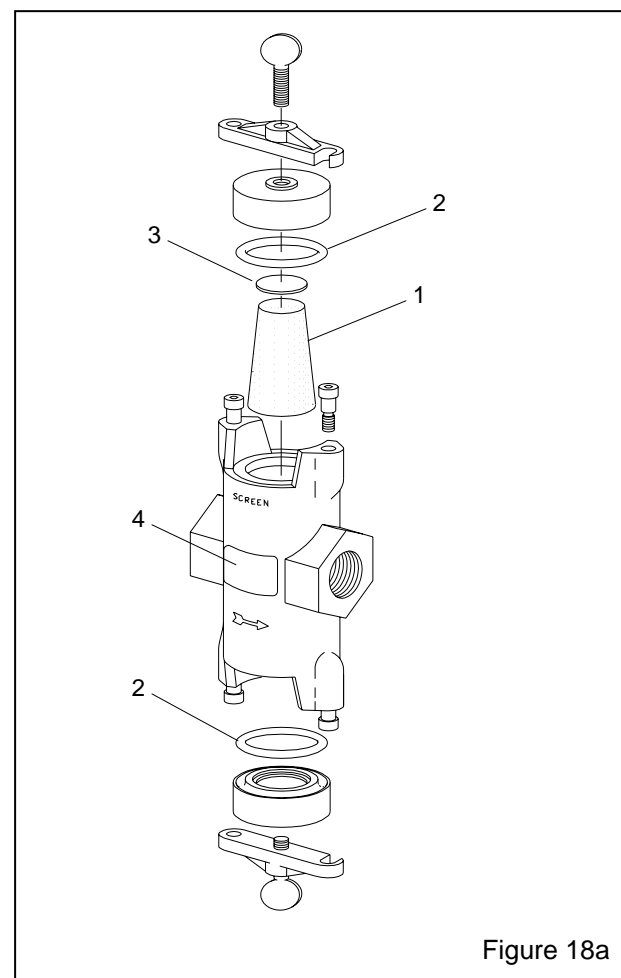
Item	Description	Stock No.
(-)	Abrasive trap	02011
*	Service kit, abrasive trap (Fig. 18a).....	01925
1.	Cap	02014
2.	Body	02015
3.	Lock bar	02016
4.	Screw, 3/8-NC x 1" thumb	03289
5.	Shoulder screw, 3/8" x 3/8"	03291



**01925 SERVICE KIT
ABRASIVE TRAP**

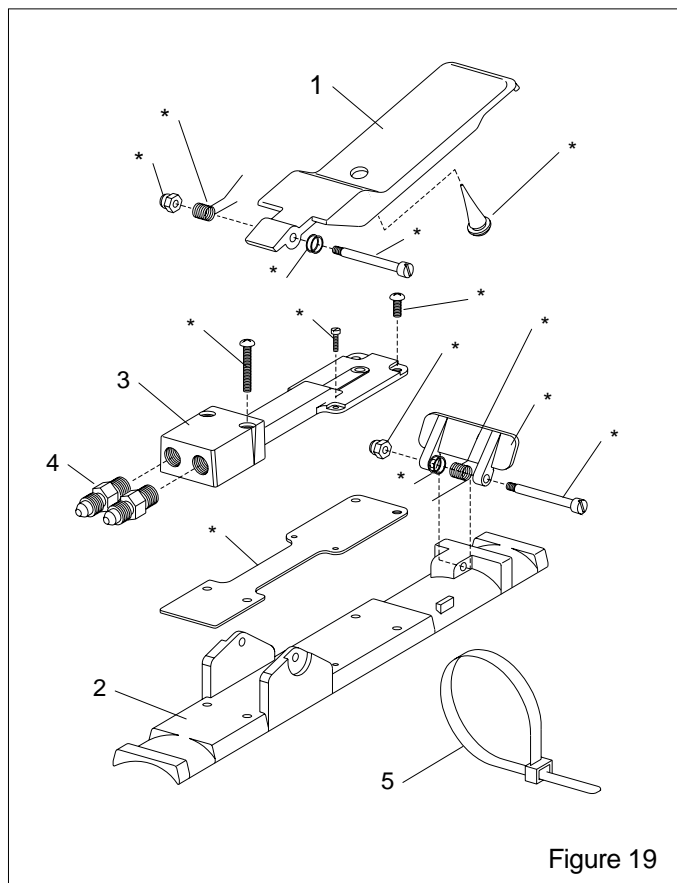
Refer to owner's manual for service instruction.

Item	Qty	Description
1.	3	Screen
2.	2	O-Ring
3.	1	Gasket, screen, 1/8" thick
4.	1	Decal, "clean screen"



8.9 RLX II Pneumatic, Figure 19

Item	Description	Stock No.
(-)	RLX II Pneumatic Control Handle Assembly	10565
*	Service kit, Pneumatic RLX (Fig. 19a)	22859
1.	Handle lever	10573
2.	Body	10568
3.	Pneumatic adaptor	10562
4.	Adaptor, 1/8" NPT (2 required)	01940
5.	Tie, nylon wire	02195



**22859 SERVICE KIT
RLX PNEUMATIC CONTROL HANDLE**

Refer to owner's manual for service instruction.

Item	Qty	Description
1.	1	Lever lock
2.	2	Spring
3.	2	Nut, 8-32 lock, ss
4.	4	Spacer washer, stainless steel
5.	2	Screw, 3/16" x 1-1/4" shoulder
6.	2	Screw, 8-32 x 1"
7.	2	Screw, 4-40 x 3/8"
8.	3	Rubber button
9.	1	Gasket, pneumatic adaptor
10.	2	Screw, 8-32 x 3/8"

