

**CLASSIC BLAST MACHINE
WITH PNEUMATIC TLR REMOTE CONTROLS
O. M. 22501**

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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.

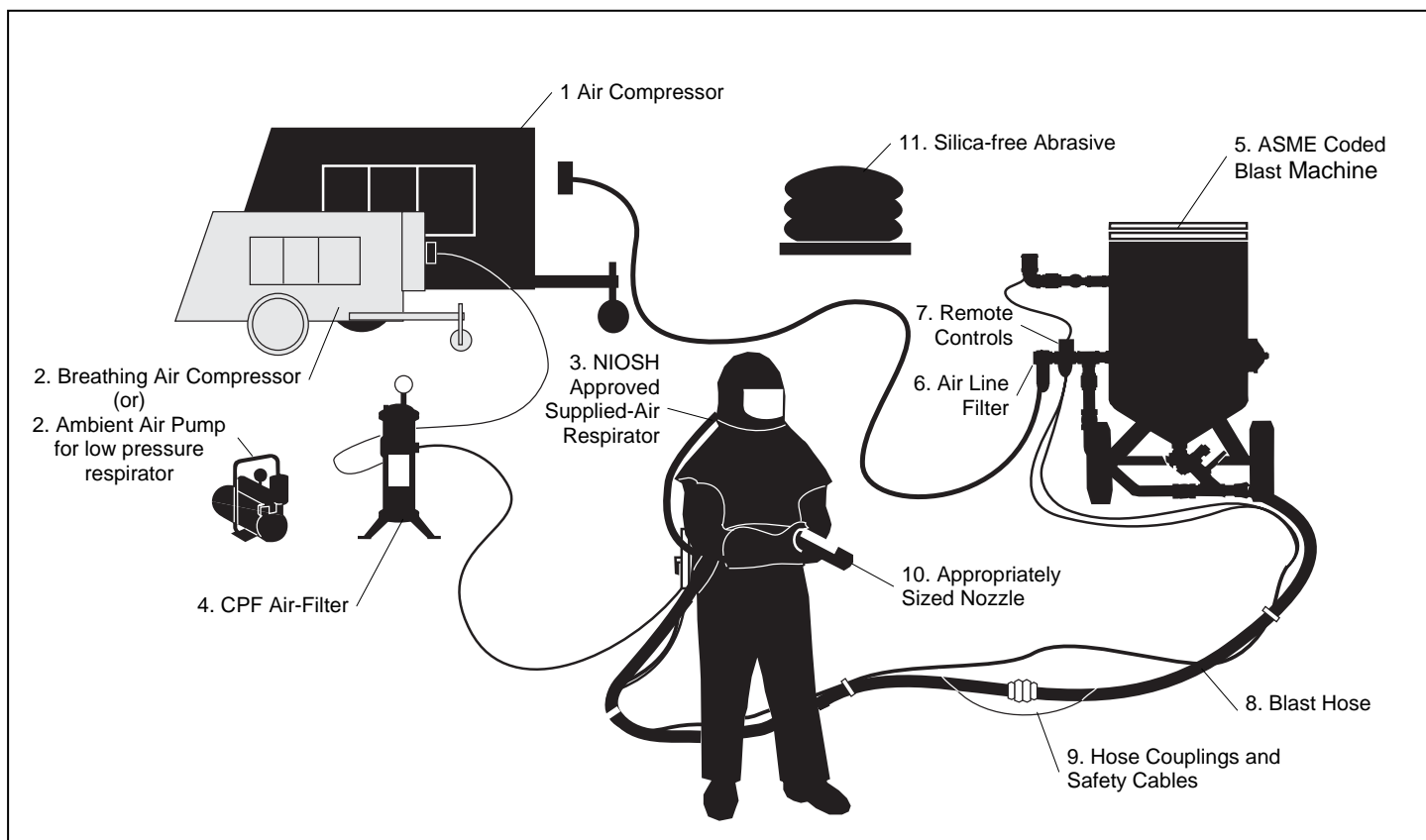
☐ **8. BLAST HOSE** with ID 3 to 4 times the nozzle orifice. Lines MUST be run AS STRAIGHT AS POSSIBLE from machine to work area with NO sharp bends. Check DAILY for internal wear and external damage.

☐ **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 set-up, operation, maintenance, troubleshooting, and replacement parts for Clemco Blast Machines with TLR-100/300, and TLR-100/300-D Pneumatic Remote Controls and standard FSV abrasive metering valve. These instructions also contain important safety information required for safe operation of the machine. The following separate instruction manual is provided for the remote control handle.

RLX Control Handle, Manual No. 10574

NOTE: Separate Operation instructions for optional metering valves are provided with the valves.

The optional Abrasive Cut-off (ACS) system uses a pneumatically operated abrasive metering valve. Operation instructions and a list of replacement parts for the metering valve are supplied with the valve.

1.1.2 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. The operators and all personnel involved with the abrasive blasting process must know about the hazards associated with abrasive blasting. 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.

1.2 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 blast machine and the remote control system are shown in Figure 1. Additional components of the remote controls are shown in Figure 2. Additional parts used with optional ACS cut-off systems are shown in Figure 3.

1.3.2 Blast Machine

1.3.2.1 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.

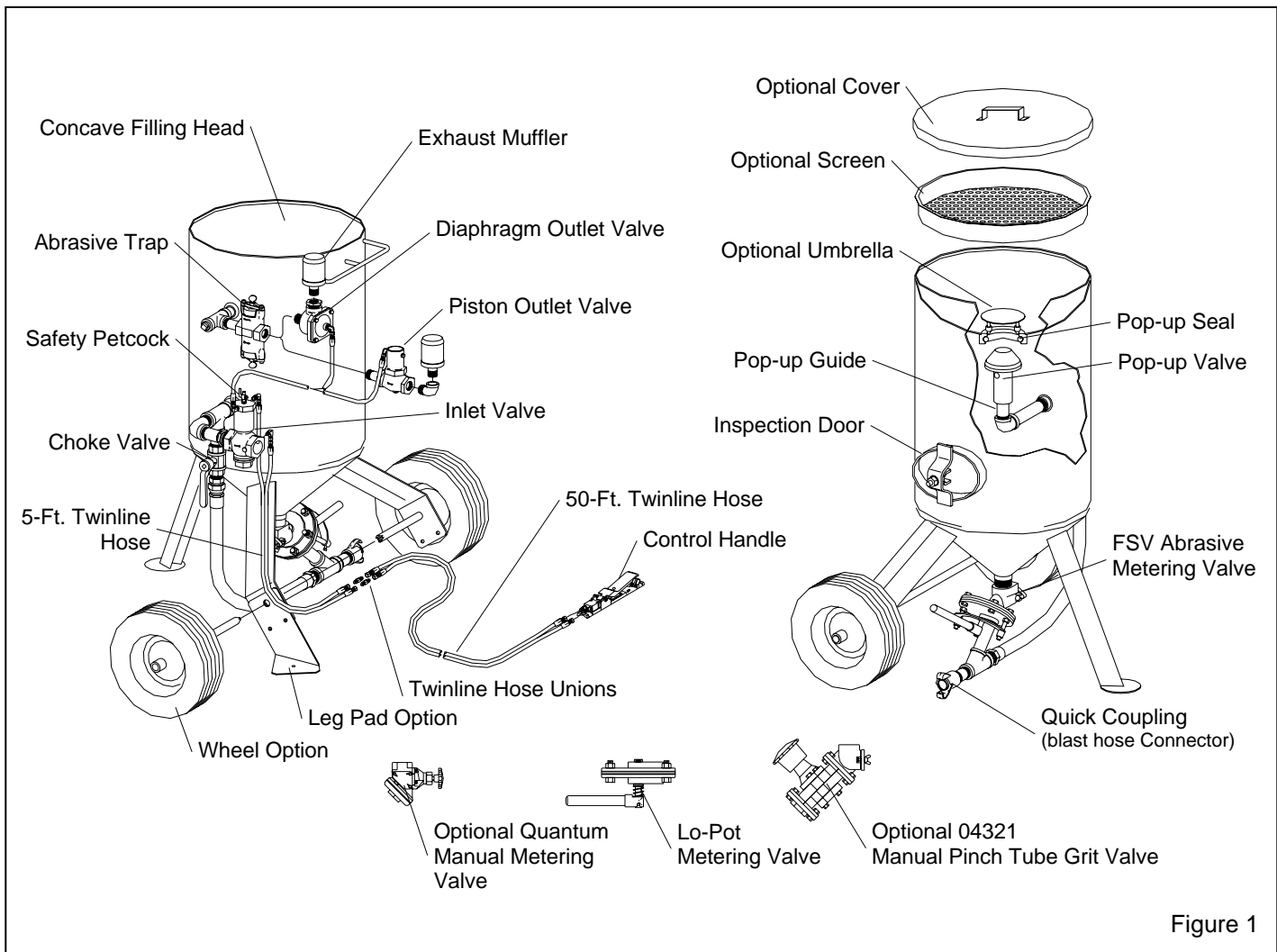


Figure 1

1.3.2.2 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.

1.3.2.3 The blast machine's pressure rating (psi) is stamped into the National Board Label which is welded onto the side of the vessel. Do not exceed the rated pressure.

⚠ WARNING

Excessive compressed 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.

1.3.2.4 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.

1.3.3 Remote Controls

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

1.3.3.2 A 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.

1.3.3.3 The components of the remote control system are shown in Figures 1 and 2. They include the inlet valve, piston or diaphragm outlet valve (the piston valve is used in most applications, the diaphragm valve is recommended for use with fine mesh or aggressive abrasive), RLX Control Handle, 50-foot and 5-foot twinline hoses, 2 control hose unions, and an 18-inch long interconnecting hose.

⚠ 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.

1.3.3.4 TLR 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.

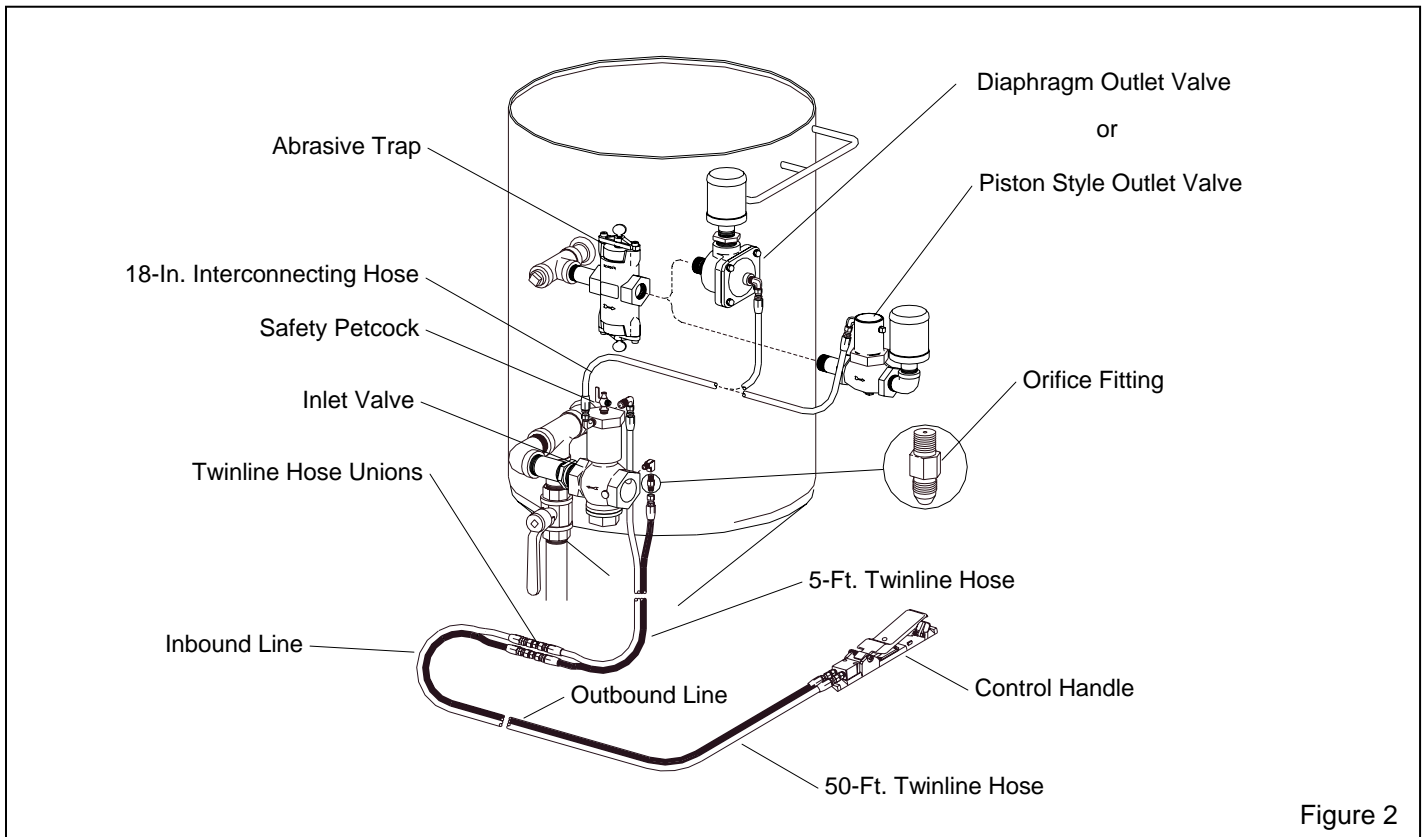


Figure 2

1.3.3.5 Clemco remote controls operate pneumatically on return air. If the control handle lever (the activator for the remote control system) is in the up (no blast) position, one stream of air travels down the outbound twinline (See Figure 2) and escapes through the opening located under the control handle lever. The normally-closed inlet valve remains closed, and the normally-open outlet valve remains open. As long as air escapes through the handle's 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 valve and close the outlet valve. This action pressurizes the blast machine and begins the blasting. Releasing the handle exhausts the control air, which closes the inlet valve, and opens the outlet valve to depressurize the blast machine and stop the blasting.

1.3.4 Abrasive Cut-off (ACS) Option

1.3.4.1 Parts used with optional ACS cut-off systems are shown in Figure 3. ACS systems include a 50-foot single line hose, and additional 18-inch long, inter connecting hose, an RLX control handle with ACS air switch assembly, and pneumatically operated metering valve. The metering valve supplied with the system may differ from the one shown. NOTE: Instructions and a list of replacement parts for the metering valve are in the manual supplied with the valve.

1.3.4.2 The abrasive cut-off switch, mounted on the control handle, closes the metering valve, so that air without abrasive exits the nozzle. The operator uses this feature for blow-down.

1.3.5 Electric 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.

1.4 Abrasive

1.4.1 Selection of blasting abrasive can play a significant part in the health risk, productivity, and maintenance of the blast machine. DO NOT USE abrasives containing more than one percent crystalline (free) silica. Obtain material safety data sheets (MSDS) for the blasting abrasive prior to blasting, paying particular attention the health risks and presence of any hazardous/toxic substances. Use only abrasives specifically manufactured for blast cleaning, and 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 abrasives may contain salts, corrosives, or other materials that could contaminate the blast surface.

1.4.2 Abrasive Size

1.4.2.1 The choice of abrasive size depends on the desired profile, cleaning rate, nozzle size and availability of clean dry air. Generally, larger and denser abrasive provide a deeper profile, while smaller abrasives clean faster. Most abrasive blasting is done with abrasive between 16 and 80 mesh. Larger size may be used if the nozzle orifice is large enough to prevent multiple particles to pass without jamming. Finer abrasive requires clean dry air to prevent bridging in the metering valve.

1.4.3 Sand: Sand should never be used because of the health hazards of using abrasive containing free silica.

1.4.4 Slags: Slag abrasives are compatible with the blast machine and accessories. Obtain a material safety data sheets (MSDS).

1.4.5 Steel: Steel shot and steel grit may be used with machines fitted with an optional Quantum or manual pinch-tube metering valve. See optional valves in Section 7.2. Shot applications may require the use of a pneumatically operated metering valve such as the Sentinel or Auto-Quantum, to prevent surging at startup.

1.4.6 Aggressive media: Aluminum Oxide, Silicon Carbide, and Garnet may be used but consideration must be given to accelerated, sometime rapid wear, on the metering valve, nozzle, hoses, and any item that is exposed to the media. Use a boron carbide nozzle with these abrasives.

1.4.7 Glass Bead: Most beads are treated to ensure free-flow operation even under moderately high humidity conditions. Glass beads subjected to excessive moisture may be reused after thorough drying and breaking up any lumps. Clean dry air is a necessary. Glass bead applications may require the use of a pneumatically operated metering valve such as the Sentinel or Auto-Quantum, to prevent surging at startup.

1.4.8 Lightweight Abrasive: Periodic use of plastic media, and most agricultural media okay. Exclusive use of plastic, or other lightweight media may require a blast machine with a 60° conical bottom.

2.0 INITIAL SET-UP

2.1 Storage Hopper

2.1.1 When a storage hopper is installed above the blast machine, an umbrella, mounted above the pop-up opening is required. See Section 7.2 for optional bolt-on umbrella.

2.2 Blast Machine Set-Up

⚠ WARNING

Clemco supplies an exhaust muffler with all blast machines of 2 cu. ft. capacity and larger. The muffler reduces exhaust noise and prevents abrasive from exhausting upward or sideways into the air. When the blast machine is depressurized, the muffler body pops up to diffuse the air and abrasive. When the machine is fully depressurized, the muffler body drops, permitting trapped abrasive to empty. For the muffler to work properly, it must be installed with the body facing up, as shown in Figure 1.

If an application requires the muffler be removed, the exhaust piping must be plumbed to direct exhausting air in a direction that ensures no persons will be exposed to possible injury from high velocity air and abrasive, which escapes when the blast machine is depressurized.

2.2.1 Attach the 5-foot twinline hose to the inlet valve as shown in Figure 2; one side connects to the unused upper elbow, the other to the orifice fitting. Either side can connect to either fitting.

2.2.2 Locate the two twinline hose unions, and screw them into the unattached fittings of the 5-foot twinline hose.

2.2.3 Install an optional filter to the inlet valve. The filter is recommended at this location to remove condensed moisture from air before it enters the machine.

2.2.4 Install an air supply hose fitting to the inlet valve (or air filter), that is compatible with the compressed-air supply hose. See Section 3.2.2.

2.3 Set up for optional ACS Ref. Figure 3. If the remote control does not have the ACS feature, skip to Section 2.4.

2.3.1 Attach the 18-inch long hose to the fitting on the metering valve.

2.3.2 Attach the 50-foot long single line hose to the ACS air switch assembly located on the RLX control handle.

2.3.3 Using one of the three unions, connect the 50-foot hose to the 18-inch long hose.

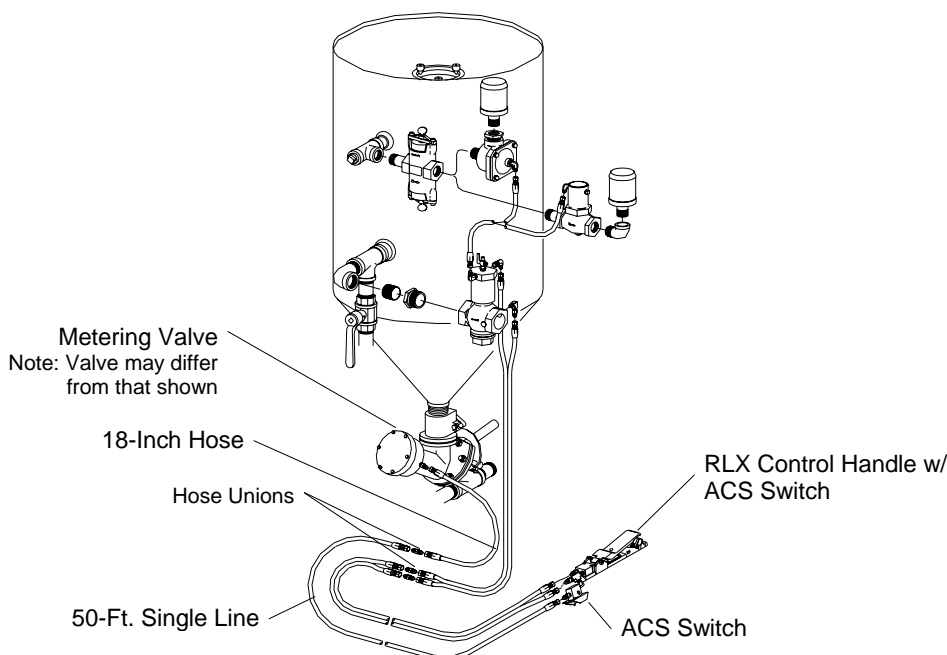


Figure 3

2.3.4 Proceed with the installation procedures beginning in Section 2.4.

2.4 Blast Hose and Control Hose Connections

WARNING

Where two or more blast machines are used, care must be taken when tracing and connecting control lines and blast hose. 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 connecting blast hose and control hose, the hoses should be of equal lengths and the hoses and blast machine couplings clearly marked, using 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 corresponding connection per the instructions supplied with the kit, and carefully trace and verify each connection before operating.

2.4.1 Uncoil the blast hose and lay the 50-foot twinline hose alongside it.

2.4.2 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.

2.4.3 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.

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

2.4.5 Temporarily connect the blast hose to the quick coupling on the blast machine.

2.4.6 Connect the 50-foot twinline hose to the unions attached to the 5-foot twinline that is already attached to the blast machine. Either side of the twinline can connect to either union.

2.4.7 Band the 5-foot twinline control hose on the blast machine side of the unions, to the quick coupling nipple.

3.0 OPERATION

3.1 Transporting and moving

WARNING

Failure to observe the following warnings before transporting or moving a blast machine could result in serious injury or death.

- Always empty the blast machine before lifting or hoisting.
- 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.

3.1.1 Transporting a blast machine

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

3.1.2 Moving a blast machine

WARNING

Never attempt to manually move a blast machine when it contains abrasive. Empty machines, up to 6 cu. ft. capacity, may be moved when the following criteria are met:

3.1.2.1 An empty machine may be moved manually, on level flat surfaces, by at least two people.

⚠ 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 in a forward direction. Do not back-up while moving the machine, as potential tripping hazards cannot be seen.

3.1.2.3 The Clemco Mule (Stock No. 20331) is designed to assist in moving empty 1.5 cu. ft. to 6 cu. ft. capacity

Clemco blast machines. Contact a Clemco Distributor for additional information.

3.2 Set-Up for Operation

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 a 3/8" nozzle, and 2" or larger when using up to a 1/2" nozzle. See the compressed air and abrasive consumption table in Figure 4 for approximate air consumption.

Compressed Air and Abrasive Consumption Consumption rates are based on abrasive that weigh 100 pounds per cubic foot									
Nozzle 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 67 2.5	13 77 3	15 88 3.5	17 101 4	19 112 4.5	20 123 5	25 152 5.5	28 169 6.5	Air (cfm) Abrasive (lbs/hr) Compressor (hp)
No. 3 3/16"	26 150 6	30 171 7	33 196 8	38 216 9	41 238 10	45 264 10	55 319 12	61 353 14	Air (cfm) Abrasive (lbs/hr) Compressor (hp)
No. 4 1/4"	47 268 11	54 312 12	61 354 14	68 408 16	74 448 17	81 494 18	98 608 22	108 676 24	Air (cfm) Abrasive (lbs/hr) Compressor (hp)
No. 5 5/16"	77 468 18	89 534 20	101 604 23	113 672 26	126 740 28	137 812 31	168 982 37	186 1085 42	Air (cfm) Abrasive (lbs/hr) Compressor (hp)
No. 6 3/8"	108 668 24	126 764 28	143 864 32	161 960 36	173 1052 39	196 1152 44	237 1393 52	263 1538 59	Air (cfm) Abrasive (lbs/hr) Compressor (hp)
No. 7 7/16"	147 896 33	170 1032 38	194 1176 44	217 1312 49	240 1448 54	254 1584 57	314 1931 69	347 2138 77	Air (cfm) Abrasive (lbs/hr) Compressor (hp)
No. 8 1/2"	195 1160 44	224 1336 50	252 1512 56	280 1680 63	309 1856 69	338 2024 75	409 2459 90	452 2718 101	Air (cfm) Abrasive (lbs/hr) 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 4

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. Use safety lock-pins or safety wire to lock the couplings together, to prevent accidental separation 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 disconnection. Lock pins and safety cables are listed in Section 7.1.

⚠ 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 unions on the 5-foot twinline hose. Either side of the hose can be attached to either fitting.

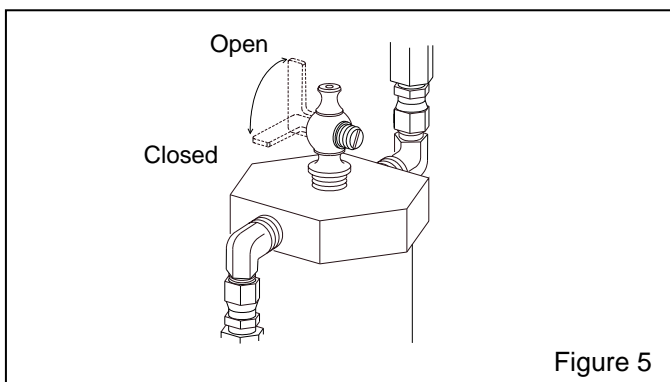
3.2.6 Check to make sure that all fittings are secure. Leaks will cause the system to malfunction.

3.2.7 Make sure that all blast hose and compressed-air supply hose connections are secured with safety lock pins and safety cables.

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

3.2.9 Close the abrasive metering valve. The closed position for the FSV and Lo-Pot metering valves is when the handle is all the way to either side of center. The closed position for the optional manual PVR grit valve is when the metering knob is turned fully clockwise.

3.2.10 Make sure that the safety petcock located on the inlet valve is open. Open position is when the lever is in-line with the petcock, as shown in Figure 5.



⚠ WARNING

To prevent severe injury 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 remote control handle lever is in the up (no blast) position, and that the handle lever and safety lock move freely.

⚠ WARNING

A separate manual is supplied with the remote control handle. Do not operate the machine before reading the remote control handle operating instructions.

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 could 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 50 psi, but must not exceed the blast machine's rated pressure.

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

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

3.2.16 No one is allowed within 10 feet of the blast machine except machine tenders, who are appropriately fitted with approved protective equipment. The blast operator could start and stop blasting 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.

3.2.17 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, preparing the machine for remote activation by the control handle. Air should be heard escaping from the orifice under the control handle lever but nowhere else. The noise from air escaping at the 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

WARNING

Before blasting, test the coating and substrate for toxic materials such as lead or heavy metals, and asbestos, which require special measures to protect the operators and environment.

Failure to wear approved respirators could result in serious lung disease or death.

Abrasive blasting produces harmful dust. Do not blast without the use of a properly fitted and maintained NIOSH-approved, type CE Supplied-Air Respirator that is approved for abrasive blasting.

During abrasive blasting, abrasive particles in the area around the blast machine and blast nozzle become airborne. Loud noise generated by the use of compressed air could cause hearing damage. Everyone in the blasting area must wear an approved respirator, approved eye and hearing protection.

3.3.1 Operators must wear appropriate protective gear, including abrasive-resistant clothing, leather gloves, eye and hearing protection, and a NIOSH-approved Type CE Supplied-Air Respirator.

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

3.3.3 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)

3.3.4 If the abrasive metering valve is closed as instructed, only air will exit the nozzle. Adjust abrasive flow per Section 3.4.

3.4 Adjust Abrasive Metering Valve

NOTE: The following instructions explain the adjustment using an FSV metering valve. Valves with knobs are adjusted by turning the knob clockwise for less abrasive, or counterclockwise for more abrasive. Separate manuals are provided with optional valves.

3.4.1 Abrasive flow is adjusted at the metering valve located at the bottom of the blast machine.

3.4.2 Begin adjustments with the metering valve closed. Closed, for the FSV and Lo-Pot metering valves, is when the handle is turned to either side of center until it hits the stops. The closed position for the optional Quantum or PVR grit valve is when the metering knob is turned fully clockwise.

3.4.3 While the operator is blasting, the machine tender increases abrasive flow by moving the handle toward center, no more than 1/4" at a time, allowing time for the flow to stabilize before readjusting.

3.4.4 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.

3.4.5 Once the correct flow is obtained, loosen the wing nut on the gauge unit and move the handle bolt spacer against the metering handle. This allows the handle to be moved (opened or closed) and returned to the same setting.

3.5 Stop Blasting

3.5.1 To stop blasting, release the control handle lever. 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 safety lever lock 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

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 into the concave head. Use an optional 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.

3.6.2 When the blast operator is ready, either the operator or the machine tender, while standing back and facing away from the blast machine's concave filling head and the 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 wets 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 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 located on the inlet valve, and open the choke valve.

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.

WARNING

The threads on the nozzle and nozzle holder must be inspected each time the nozzle is secured to the holder. Check that 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.

3.8 Shutdown

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

3.8.2 Drain receiver tank, 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 PREVENTIVE MAINTENANCE

NOTE: These preventive maintenance instructions pertain to the blast machine and remote controls only. Read the owners manuals for the control handle and all blast accessories, for their inspection and maintenance schedules.

4.1 Daily

4.1.1 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 5.7.
- 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. Check that 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 II 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 could result from unintentional blasting.

4.1.2 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 pipefittings 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.

4.2 Weekly**4.2.1** With the air off, before blasting, do the following:

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

4.2.2 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 5.10.

4.3 Monthly inspection**4.3.1** 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. 5.8.
- Inspect the rubber pop-up seal, and replace at the first sign of wear, drying, or cracking. See Section 5.9.
- Inspect the exhaust muffler for blockage and wear, per Section 5.10.

4.4 Periodic Inspection

4.4.1 The remote control system is a safety device. For safety and to avoid unscheduled down-time, periodically inspect the internal parts of the inlet valve, outlet valve, and abrasive trap. Inspect for wear and lubrication of O-rings, pistons, springs, seals, and castings. See Service Maintenance in Sections 5.3, 5.4 or 5.5, and 5.7.

4.4.2 The control handle is the actuator of the remote control system. Periodically clean around the springs, handle lever, and safety lever lock to ensure that the unit is free of abrasive and debris that may cause the handle lever or safety lever lock to bind. See the RLX II Owners Manual for service instructions.

4.5 Lubrication

4.5.1 Once per week while the air is off, put one or two drops of light weight machine oil in the inlet valve through the safety petcock. This will lubricate the piston and O-rings in the inlet and outlet valves.

5.0 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.**
 - **Lockout and tagout the compressed air supply.**
 - **Bleed the air supply line to the blast machine.**
-

5.1 Removing damp abrasive from the blast machine.

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

5.1.2 For more difficult blockages, proceed as follows: See Section 5.2 to check for obstructions in the metering valve.

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

5.1.4 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.

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

5.1.6 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 so the nozzle and nozzle washer can be attached.

WARNING

The threads on the nozzle and nozzle holder must be inspected each time the nozzle is secured to the holder. Check that 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.

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

5.2 Clearing obstructions in the abrasive metering valve and blast machine.

5.2.1 If the nature of the obstruction permits emptying the machine of abrasive, follow the instructions per Section 3.7.

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

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

5.2.4 Check the metering valve for blockage, by inserting a finger into the opening, and feel for an obstruction or foreign object.

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

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

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

5.2.8 Check to make sure all inspection doors are secure before starting the compressed-air supply.

5.3 Inlet Valve, Ref. Figure 12 (1-1/2" valve) or Figure 13 (1" valve).

5.3.1 All service on the inlet valve must be done with the compressed air off and the air supply locked-out and tagged-out.

5.3.2 Bottom Section

5.3.2.1 Use a wrench to loosen the bottom cap until it can be removed by hand.

5.3.2.2 As the cap is removed, the spring(s) (two are used in the 1-1/2" inlet valve), and plug assembly will drop from the opening. Do not allow them to fall to the ground as that may damage the castings.

5.3.2.3 Clean all parts and inspect for wear:

- The small spring (only one used in 1" valve) is approximately 1-11/16" long. If it is rusted or compressed, replace it.
- The large spring (not used in 1" valve) is approximately 2-1/16" long. If it is rusted or compressed, replace it.
- Inspect the valve plug washer, valve plug, and plug retainer for damage. Replace all damaged parts. When reassembling the valve plug assembly, tighten the retainer enough to compress the washer, but not so tight to cause it to bulge.
- Look into the lower opening in the valve body. If the machined seat is worn, replace the body.
- Inspect the bottom cap seal, and replace if damaged.

5.3.2.4 If the top section of the valve requires service, go to Section 5.3.3, otherwise use the illustration in Figures 12 or 13 and reassemble the valve in reverse order.

5.3.3 Top Section

5.3.3.1 Remove the control hose and fittings from the cylinder cap, to prevent damage by a wrench.

5.3.3.2 Use a large wrench to remove the cylinder cap.

5.3.3.3 If the bottom cap has not been removed, remove it, and all other parts per Section 5.3.2.

5.3.3.4 Use a wooden hammer handle or similar object, inserted into the bottom of the valve body, pushed through the seat area, to drive the piston stem up. Doing so will push the piston out the top of the valve body.

5.3.3.5 Inspect all items for wear and damage.

- The piston cup should fit snugly against the cylinder wall. If it does not, replace the piston assembly.
- The piston stem should be free of deep abrasion and move freely in the stem bore. If it is badly abraded, drags in the bore, or is loose in the bore, replace the piston assembly.
- If the piston stem O-ring is flattened, replace the O-ring.
- Check the cylinder cap O-ring. Replace it if it is cut or does not fit snugly on the cap recess.

5.3.3.6 Lubricate the cylinder wall and piston cup with lightweight machine oil such as 3 in 1 or equivalent.

5.3.3.7 Install the piston into the cylinder. As the piston cup contacts the cylinder it may be difficult to press into place. Do not pound the piston, as it could damage the cup. Rotating the piston while applying thumb pressure eases assembly.

5.3.3.8 Use the illustration in Figure 12 or 13 and reassemble the valve in reverse order.

5.3.4 Remove the lower twinline hose connection, and remove the orifice fitting for inspection. Clean the 1/16" orifice and reassemble the connection.

WARNING

The orifice fitting must not be removed, modified, or substituted with another fitting. Altering the orifice fitting may cause involuntary activation of the blast machine or some other malfunction, which could result in serious injury or death.

5.4 Piston Outlet Valve, Ref. Figure 14 See Section 5.5 for the diaphragm outlet

5.4.1 All service on the outlet valve must be done with the compressed air off and the air supply locked-out and tagged-out.

5.4.2 Remove control hose from the valve bonnet.

5.4.3 Use a large wrench to loosen the bonnet from the valve body, until it can be removed by hand.

5.4.4 As the bonnet is removed, lift it straight up until the piston stem clears the spindle.

5.4.5 Remove the spindle, plug assembly, and spring from the valve body.

5.4.6 Remove the piston from the bonnet, by pulling the piston stem.

5.4.7 Inspect all parts for wear and damage:

- Inspect the valve plug washer, valve plug, and plug retainer for damage. Replace all damaged parts. When reassembling the valve plug assembly, tighten the retainer enough to compress the washer, but not so tight to cause it to bulge.
- Examine the body casting for wear. If the body or the machined seat is worn, replace the body.
- Examine the spring guide-bolt and nylon washer. If either is worn, replace both.
- The spring is approximately 1-5/8" long; if it is worn, rusted or compressed, replace it.
- The piston cup should fit snugly against the bonnet's cylinder wall. If it does not, replace the piston assembly.
- The piston stem should be free of deep abrasion and move freely in the spindle bore. If it is badly abraded, drags in the bore, or is loose in the bore, replace the piston assembly.

5.4.8 Lubricate the cylinder wall and piston cup with lightweight machine oil such as 3 in 1 or equivalent.

5.4.9 Install the piston into the bonnet cylinder. Cocking the piston so it enters the bonnet at a slight angle, and rotating it while applying pressure makes assembly easier. Do not push the piston fully into the bonnet; the stem should be even with the opening.

5.4.10 Place the spring over the guide-bolt, and place the plug assembly (retainer down) on the spring.

5.4.11 Place the spindle in the body. The large opening faces down, and fits over the plug fins. The spindle shoulder will not rest on the valve body due to the force of the spring.

5.4.12 To assemble the bonnet to the valve body, first insert the piston stem into the spindle guide hole. While keeping the bonnet, spindle, and body aligned, screw the bonnet onto the body. If all parts are correctly aligned, the body will screw-on hand tight until it is

seated. NOTE: If the bonnet does not screw on hand tight, do not force it. Recheck alignment and repeat.

5.4.13 After the bonnet is fully seated on the body, tighten the assembly with a wrench and attach the control hose.

5.5 Diaphragm Outlet Valve

See Section 5.4 for the piston outlet

5.5.1 All service on the outlet valve must be done with the compressed air off and the air supply locked-out and tagged-out.

5.5.2 Remove the cap by unscrewing the cap screws.

5.5.3 Remove the diaphragm and inspect it for damage. Replace as necessary.

5.5.4 Inspect the machined seat in the body. If worn, replace the body.

5.5.5 Reassemble in reverse order.

5.6 Control handle

5.6.1 A separate manual is provided for the control handle. Follow instructions in the manual.

5.7 Abrasive Trap

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

5.7.2 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.

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

5.7.4 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 reinstall the screen in the trap until the bottom section of the trap is cleaned per the following instructions.

5.7.5 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.

5.7.6 Empty abrasive from the bottom and top sections.

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

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

5.8. Replacing the Pop-Up Valve, Figure 6

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

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

5.8.3 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.

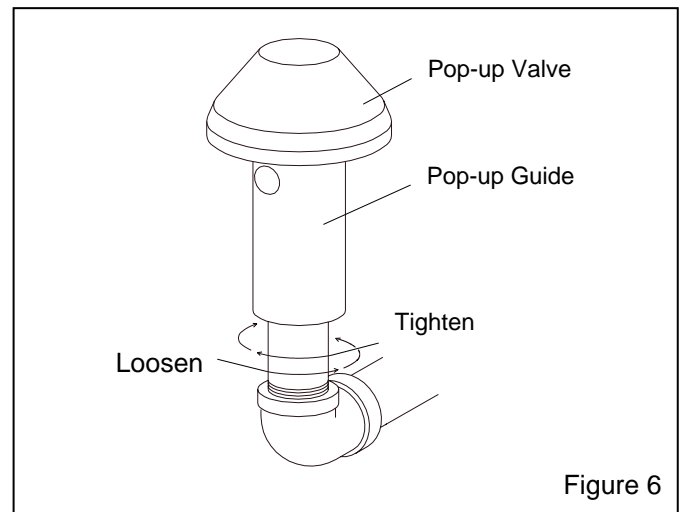
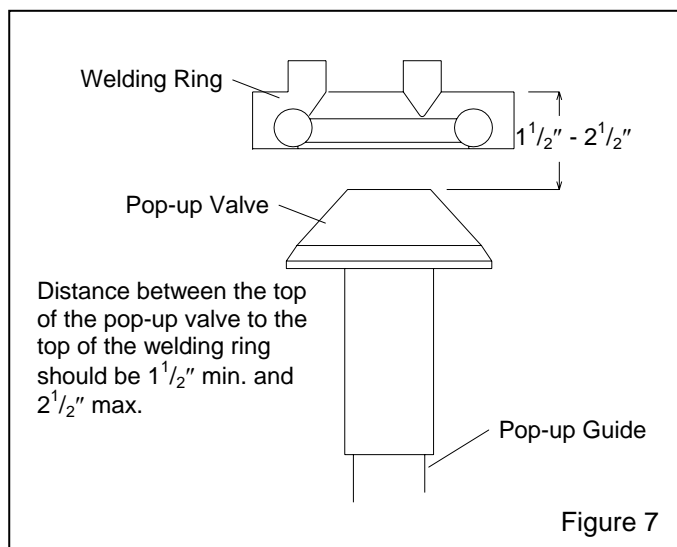


Figure 6

5.8.4 While the pop-up valve is out, check alignment as follows: Screw a 1-1/4" nipple that 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.

5.8.5 Slide the new pop-up valve over the guide, 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.



5.9 Replacing the Pop-Up Seal

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

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

5.9.3 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.

5.10 Exhaust Muffler, Figure 8

⚠ WARNING

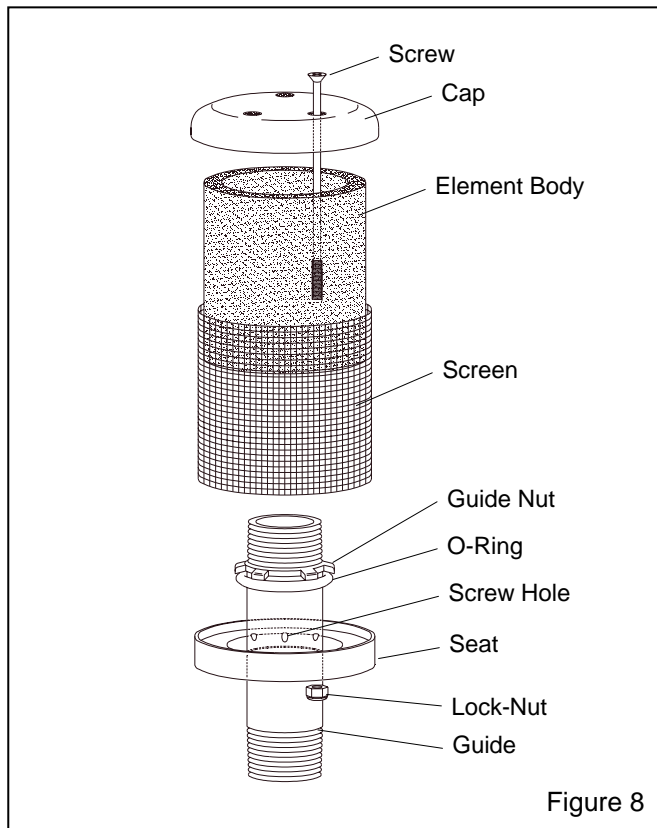
Service the muffler, and replace the element body as soon as blast machine depressurization time increases noticeably. Longer depressurization time indicates the porous element body is becoming clogged. If the element becomes plugged, excessive air pressure could build up inside the element, and cause it to burst, which could result in injury.

5.10.1 All service on the muffler must be done with the compressed air off and the air supply locked-out and tagged-out.

5.10.2 Using a pipe wrench, remove the muffler assembly from the exhaust elbow by unscrewing the 1" pipe guide.

5.10.3 Remove the three locknuts and screws, and separate all parts.

5.10.4 Inspect for wear. Replace parts that show signs of wear. Replace the cap if the urethane coating is worn. Always replace the element body.



5.10.5 Ensure that the guide nut is fastened tightly to the guide.

⚠ WARNING

Replace the guide and guide nut if the nut is not tightly fused to the guide. A loose fitting nut could work off the guide, permitting the muffler assembly to launch under pressure, and cause severe injury.

5.10.6 Clean parts to be reused, with a non-caustic solvent or detergent, and dry thoroughly.

5.10.7 Reassemble, taking care to correctly insert the screws in the seat plate. The screw holes are the three closest to the center. See the illustration in Figure 8.

5.10.8 Firmly tighten the lock nuts.

5.10.9 Use a pipe wrench to attach the muffler assembly to the exhaust elbow. In its final position, the muffler must face up.

WARNING

When installed on the machine, the muffler must face up. The muffler reduces exhaust noise, and prevents abrasive from exhausting upward or sideways when the blast machine is depressurized. To reduce risk of injury from abrasive carried by high velocity air, the muffler must be installed with the body facing up.

6.0 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. A separate manual is provided for the RLX II Control Handle.

WARNING

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

- Turn off the compressed air, and lockout and tagout 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.
-

6.1 Neither abrasive nor air comes out of the nozzle while the machine is under pressure

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

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

6.2 Air only (no abrasive) comes out the nozzle

6.2.1 Abrasive metering valve may be closed or needs adjustment. Adjust abrasive flow per Section 3.4.

6.2.2 Blast machine may be empty.

6.2.3 Abrasive may be damp. See Section 5.1 to clear damp abrasive.

6.2.4 Check the abrasive metering valve for obstructions per Section 5.2.

6.3 Heavy abrasive flow

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

6.3.2 Abrasive metering valve may be open too far. See Section 3.4.

6.4 Abrasive surging

6.4.1 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 3.4.

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

6.4.3 See Section 6.7.

6.5 Intermittent abrasive flow.

6.5.1 Moisture in the blast machine or in the air supply. Drain moisture from the compressor's receiver tank, and if so equipped, the blast machine's air filter. If moisture continues to be a problem, a dryer or aftercooler may be required in the air supply line.

6.5.2 Abrasive may be worn from recycling. Replace abrasive.

6.6 Blast machine will not pressurize.

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

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

6.6.3 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. (RLX II Control Handle is covered in Manual No. 10574)

6.6.4 Check for air escaping through the opening under the control handle lever. If no air is escaping, the orifice on the inlet valve Figure 12 item 4, or Figure 13 item 4 is blocked, or the line from the orifice to the control handle is blocked and must be cleared.

6.6.5 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.

6.6.6 Check control lines and fittings for leaks.

6.6.7 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 a diaphragm outlet valve is used, check the diaphragm for a rupture.

If air does come out, then the inlet valve is not functioning. Turn off the compressed air supply and service the valve per Section 5.3.

6.6.8 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 a worn piston in the inlet valve. See Section 5.3.

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

6.6.10 Dirty element in air filter. Check filter element.

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

6.7 Blast machine will not depressurize or depressurizes too slowly.

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

6.7.2 Exhaust muffler blocked. See Section 5.10.

6.7.3 Check the pneumatic adaptor gasket on the control handle for swelling, which restricts air flow through the handle. Refer to the control handle manual.

6.7.4 Check for blockage in the control hose.

6.7.5 Make sure the lower fitting on the inlet valve (Figure 12, item 4 or Figure 13, item 4) has not been switched for a fitting with a full flow orifice. The orifice on the 1/8" NPT end of the fitting must be 1/16" diameter.

6.7.6 Make sure the inlet valve closes. If it does not seal-off incoming air, service the valve per Section 5.3.

6.7.7 Disassemble the piston outlet valve, clean and lubricate it. Replace all worn or broken parts.

6.8 Outlet valve will not seal

6.8.1 Outlet valve requires service. For piston outlet valve, see Section 5.4, for diaphragm outlet valve see Section 5.5.

7.0 REPLACEMENT PARTS

7.1 Blast Machine Accessories

Description	Stock No.
Cover, for	
14" diameter machine	02334
16" diameter machine	02335
20" diameter machine	20358
24" diameter machine	02336
30" diameter machine	02337
Screen, recessed type, for	
14" diameter machine	03098
16" diameter machine	03099
20" diameter machine	20357
24" diameter machine	03100
30" diameter machine	03101
Safety cable, 3/4" to 1-1/2" ID blast hose	15013
Lock pin, coupling (package of 25)	11203

7.2 Blast Machine and Accessories, Figure 9

Item	Description	Stock No.
1.	Ball valve with handle, 1-inch NPT	02396
	1-1/4-inch NPT	02397
2.	Handle, 1" ball valve,	22531
	1-1/4" ball valve	22532
3.	Pop-up valve, 4" with external sleeve	03699
4.	Internal pop-up guide, toe nipple, for 2 and 3 cu. ft. 1-1/4" x 6-1/2"	01754
	6 cu. ft. 1-1/4" x 6"	01753
5.	Adaptor, male NPT x male JIC 1" NPT	11720
	1-1/4" NPT	22529
6.	Pusher line, coupled 1" ID x 21" (2 cu ft machine).....	22508
	1" ID x 28" long (3 cu ft & larger)	23673
	1-1/4" ID x 28" long (3 cu ft & larger).....	23674
	1" x 19" long (Lo-Pot machines).....	24167
	1-1/4" x 19" long (Lo-Pot machines).....	24168
7.	Coupling, 1-1/4" CF	00551
8.	Wye, 1-1/4" standard	01818
9.	Leg pad, right, for 1.5 cu ft, 3 cu ft, and 6 cu ft machine	03654
	2 cu ft machine	20735
10.	Leg pad, left, for 1.5 cu ft, 3 cu ft, and 6 cu ft machine	03655
	2 cu. ft. machine	20736
11.	Metering valve, FSV w/ wye	02427
12.	Gasket, CQG coupling, (package of 10)	00850
13.	Wheel and tire, 10 x 2.75, for 2 cu. ft.	20349
14.	Axle, 2 cu. ft. 10" Wheel	20734
15.	Wheel and tire, 16 x 400	02338
16.	Axle and 16" wheel set for 3 cu. ft. machine	02822
	6 cu. ft. machine	02350
17.	Washer, 1" thrust	03825
18.	Retaining ring, 1"	03824
19.	Inspection door assembly, 6" x 8"	02377
20.	Gasket, 6" x 8" inspection door	02369
21.	Seat, pop-up gum rubber, standard use	02325
	neoprene, for hot climates	02380
22.	Umbrella, optional, 4" bolt-on	02318
23.	Muffler, exhaust	05068
24.	Metering valve, optional manual pinch tube	04321
25.	Metering valve, for Lo-pot machines	05680
26.	Metering valve, optional manual Quantum	22845
27.	Lock pin, coupling (package of 25)	11203
28.*	Formed pipe pusher line, 1"	01865
29.*	Formed pipe pusher line, 1-1/4"	01866
30.*	Compression coupling, 1"	01856
31.*	Gasket, 1" compression coupling,	01885
32.*	Compression coupling, 1-1/4"	01857
33.*	Gasket, 1-1/4" compression coupling	01886

* Used on 30" & larger machines, & all machines shipped prior to Jan 2003

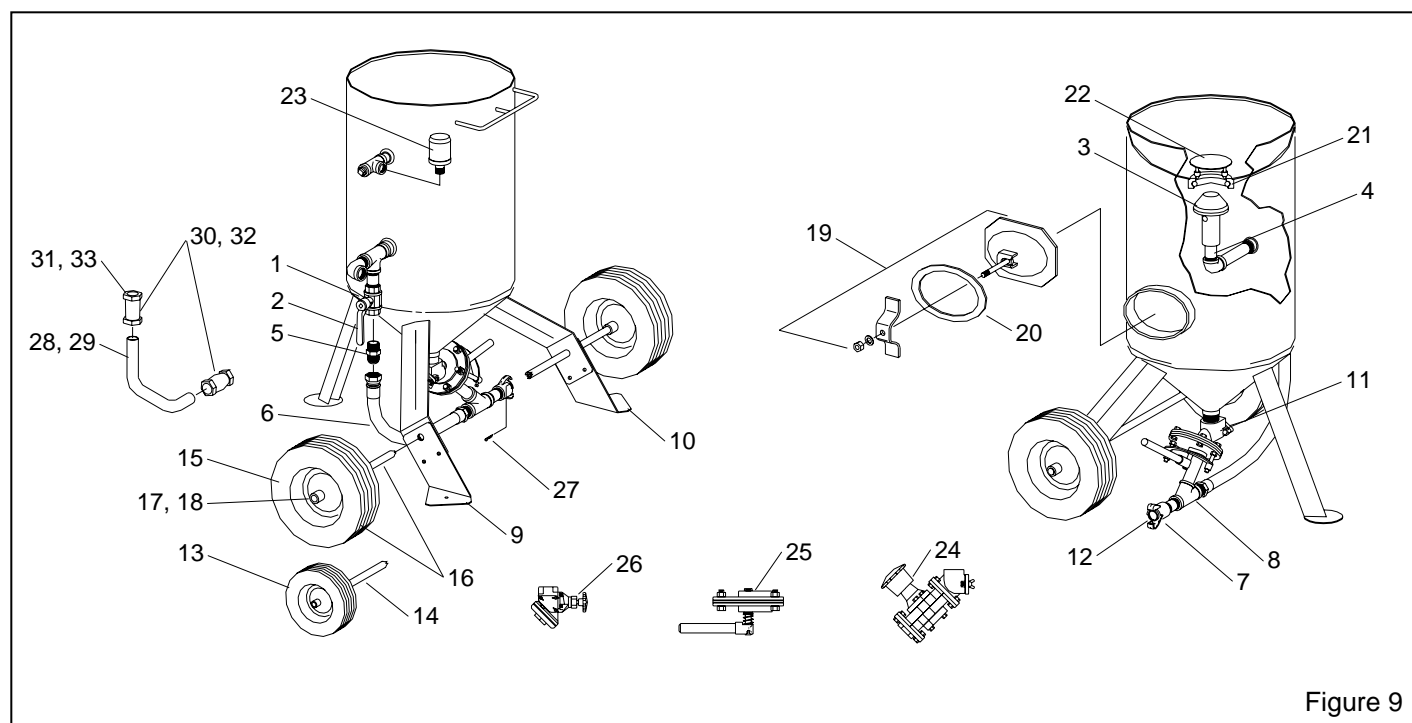


Figure 9

7.3 TLR-100/300 Systems, Complete

Description	Stock No.
TLR-100, 1" w/ Piston outlet valve	01935
TLR-300, 1-1/4" w/ Piston outlet valve	01936
TLR-100D, 1" w/ Diaphragm outlet valve	03449
TLR-300D, 1-1/4" w/ Diaphragm outlet valve	03448

7.4 Remote System, Figure 10

Item	Description	Stock No.
1.	Outlet valve, 1" piston	01967
2.	Outlet valve, 1" diaphragm	03371
3.	Inlet valve	
	1" NPT	01980
	1-1/2" NPT	01995
4.	Abrasive trap	02011
5.	RLX Control handle	10565
6.	Hose, 3/16" x 18 inch, coupled	02454
7.	Hose, 5 foot twinline, coupled	01952
8.	Hose end, reusable	01943
9.	Hose, 50 foot twinline, coupled	01951
10.	Union, hose	01944
11.	Elbow, 1/4" NPT adaptor	02513

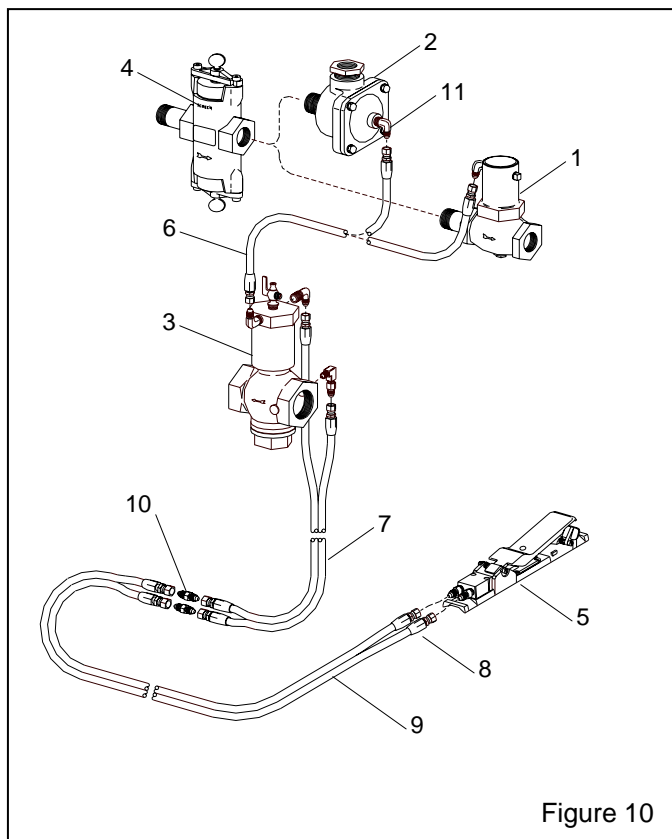


Figure 10

7.5 ACS Systems Replacement parts, Figure 11

NOTE: All other parts are the same as shown in Section 7.3, and Figure 10. Refer to the RLX manual for replacement parts for the ACS Control. Refer to the Metering valve manual for metering valve replacement parts.

Item	Description	Stock No.
1.	RLX Control handle w/ ACS switch	07625
2.	Hose, 50-foot single line, coupled	03087
3.	Hose, 3/16" x 18", coupled	02454
4.	Union, Twinline hose	01944
5.	Elbow, 1/4" NPT adaptor	02513

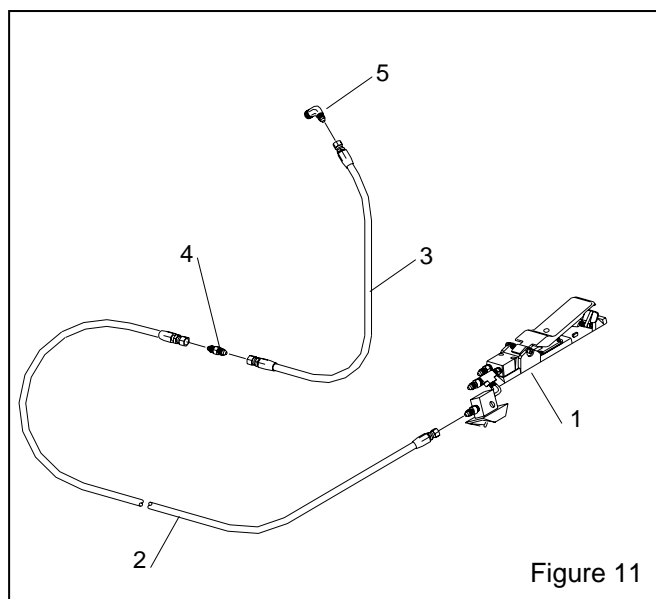
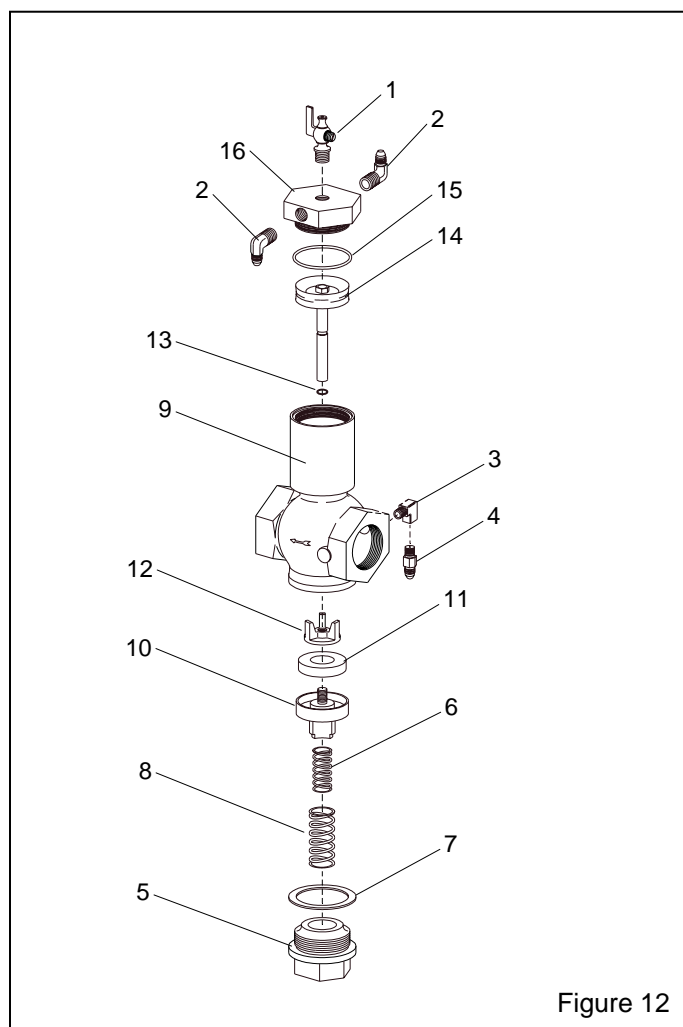


Figure 11

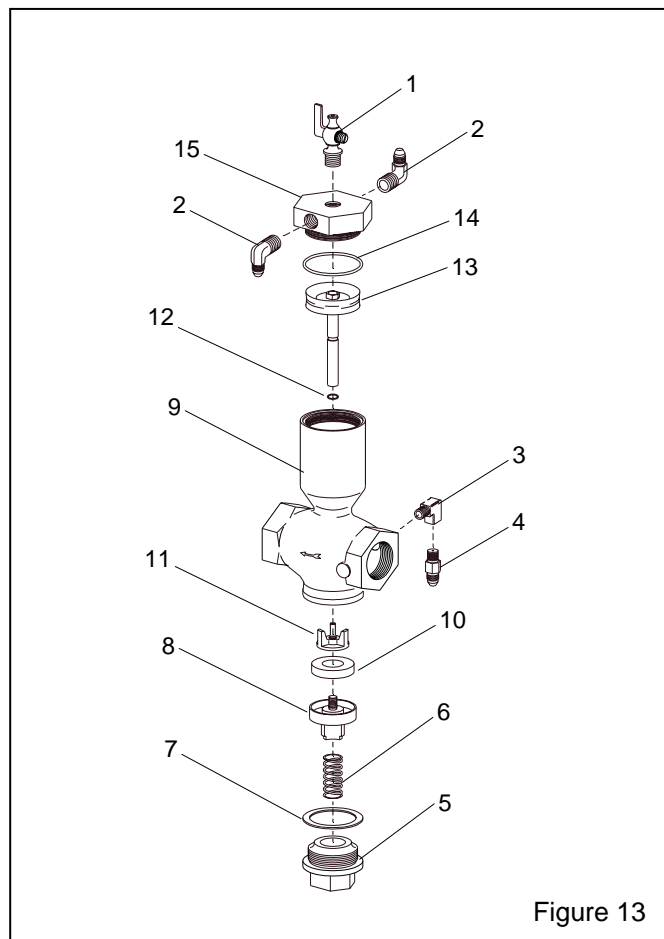
7.6 1-1/2" Inlet Valve, Figure 12

Item	Description	Stock No.
(-)	1-1/2" Inlet Valve, complete	01995
1.	Petcock 1/4" NPT	01993
2.	Elbow, 1/4" NPT adaptor	02513
3.	Elbow, 1/8" NPT brass street	03993
4.	Adaptor 1/8" NPT with 1/16" orifice	01945
5.	Bottom cap	02001
6.*	Spring, inner, 5/8" x 1-11/16" long, (1)	01982
7.*	Gasket, bottom cap, (1)	02006
8.*	Spring, outer, (1)	02000
9.	Valve body	01996
10.	Valve plug	01999
11.*	Washer, valve plug, (2)	01998
12.*	Retainer, valve plug washer, (1)	02002
13.*	O-Ring, 7/16" OD, (1)	02008
14.	Piston and rod assembly	02003
15.*	O-Ring 2-1/4" OD, (1)	02007
16.	Cylinder cap	01997
(-)	Service kit, includes items marked *	
	quantities are shown in ()	01927



7.7 1" Inlet Valve, Figure 13

Item	Description	Stock No.
(-)	1" Inlet Valve, complete	01980
1.	Petcock 1/4" NPT	01993
2.	Elbow, 1/8" NPT adaptor	02827
3.	Elbow, 1/8" NPT brass street	03993
4.	Adaptor 1/8" NPT with 1/16" orifice	01945
5.	Bottom cap	01985
6.*	Spring, 5/8" x 1-11/16" long, (1)	01982
7.*	Seal, bottom cap, (1)	01989
8.	Valve plug	01984
9.	Valve body	01981
10.*	Washer, valve plug, (2)	01969
11.*	Retainer, valve plug washer, (1)	01986
12.*	O-Ring 3/16" ID x 1/16", (1)	01992
13.	Piston and rod assembly	01987
14.*	O-Ring 1-3/4" OD, (1)	01990
15.	Cylinder cap	01983
(-)	Service kit, includes items marked *	
	quantities are shown in ()	01929



7.8 1" Piston Outlet Valve, Figure 14

Item	Description	Stock No.
(-)	1" Piston outlet valve, complete	01967
1.	Elbow, 1/4" NPT adaptor	02513
2.	Plug, 1/4" NPT	01950
3.	Bonnet	01970
4.	Piston and rod assembly	01976
5.	Plug and spindle guide	01971
6.*	Valve plug, (1)	01972
7.*	Washer, valve plug, (2)	01969
8.*	Retainer, valve plug washer, (1)	01986
9.	Valve body	01968
10.*	Spring, 7/16" x 1-5/8" long (1)	01974
11.	Nylon washer	01979
12.	Cap screw, 3/8-NC x 3/4"	03331
(-)	Service kit, includes items marked * quantities are shown in ()	01928

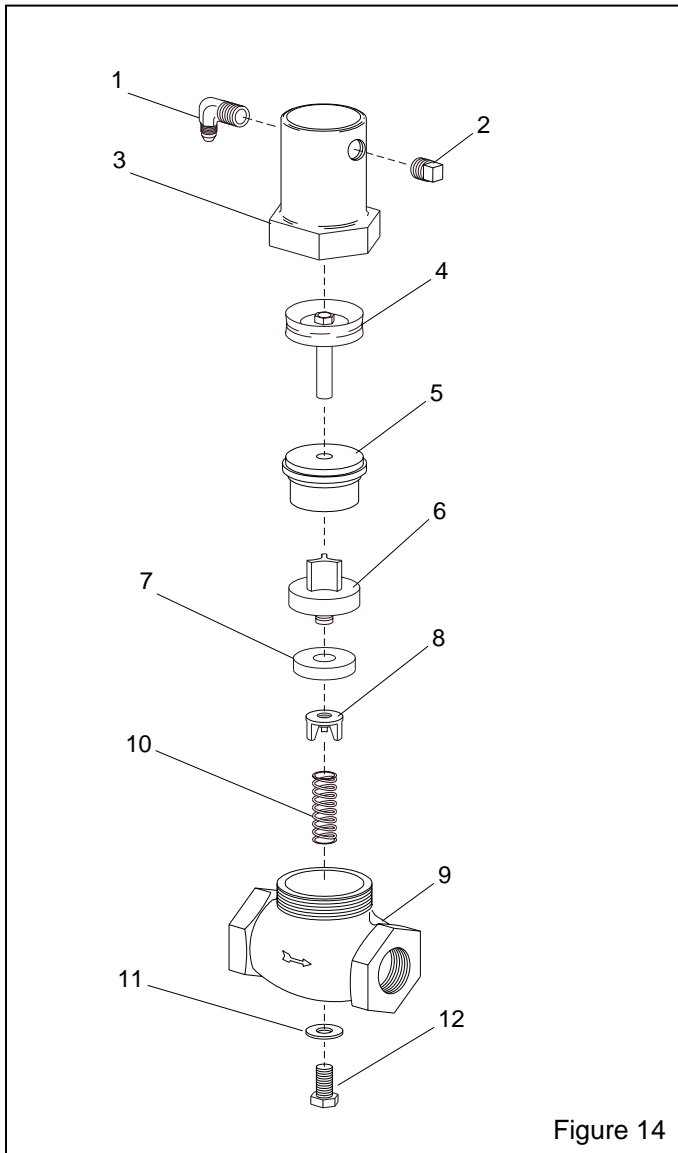


Figure 14

7.9 1" Diaphragm Outlet Valve, Figure 15

Item	Description	Stock No.
(-)	1" Diaphragm outlet valve, complete	03371
1.	Nipple, 1" x close	01701
2.	Diaphragm	06149
3.	Lockwasher, 1/4"	03117
4.	Cap screw, 1/4-NC x 1" hh	03053
5.	Cap, diaphragm outlet	03393
6.	Body, diaphragm outlet	06135
7.	Bushing, 1-1/4" x 1" NPT	01804

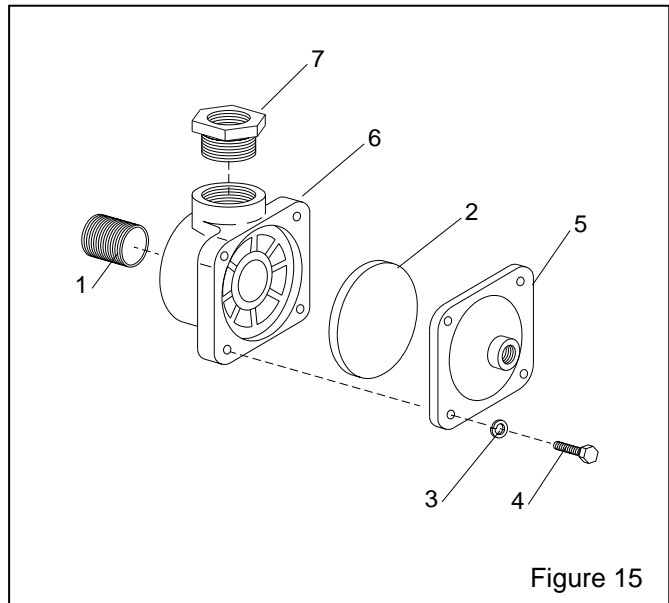


Figure 15

7.10 RLX II Pneumatic Control Handle

Refer to RLX Control Handle Manual No. 10574
for RLX replacement parts.

7.11 Abrasive Trap, Figure 16

Item	Description	Stock No.
(-)	Abrasive trap, complete	02011
1.*	Screen, (3)	02012
2.*	O-Ring, (2)	02013
3.	Cap	02014
4.	Body	02015
5.	Lock bar	02016
6.	Screw, 3/8-NC x 1" thumb	03289
7.	Shoulder screw, 3/8" x 3/8"	03291
8.*	Gasket, screen, 1/8" Thick, (1)	02434
9.	Decal, clean screen	02129
(-)	Service kit, includes items marked * quantities are shown in ()	01925

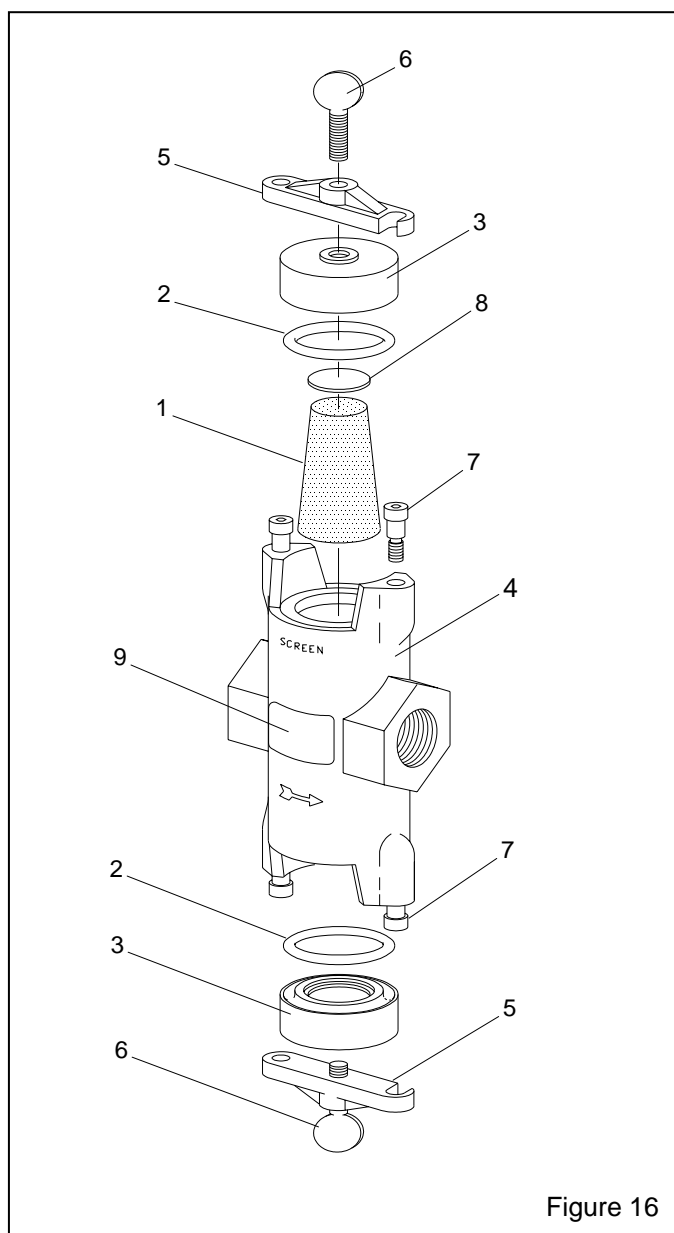


Figure 16

7.12 Exhaust Muffler, Figure 17

Item	Description	Stock No.
(-)	Muffler, complete	05068
1.	Screw, 8-32" x 4"	05061
2.	Cap, coated	05067
3.	Body, element	05065
4.	Screen	05060
5.	Guide w/ guide nut.....	22344
6.	O-ring, 1-1/4" ID	05069
7.	Seat	05062
8.	Lock-nut, 8-32 ss	05815

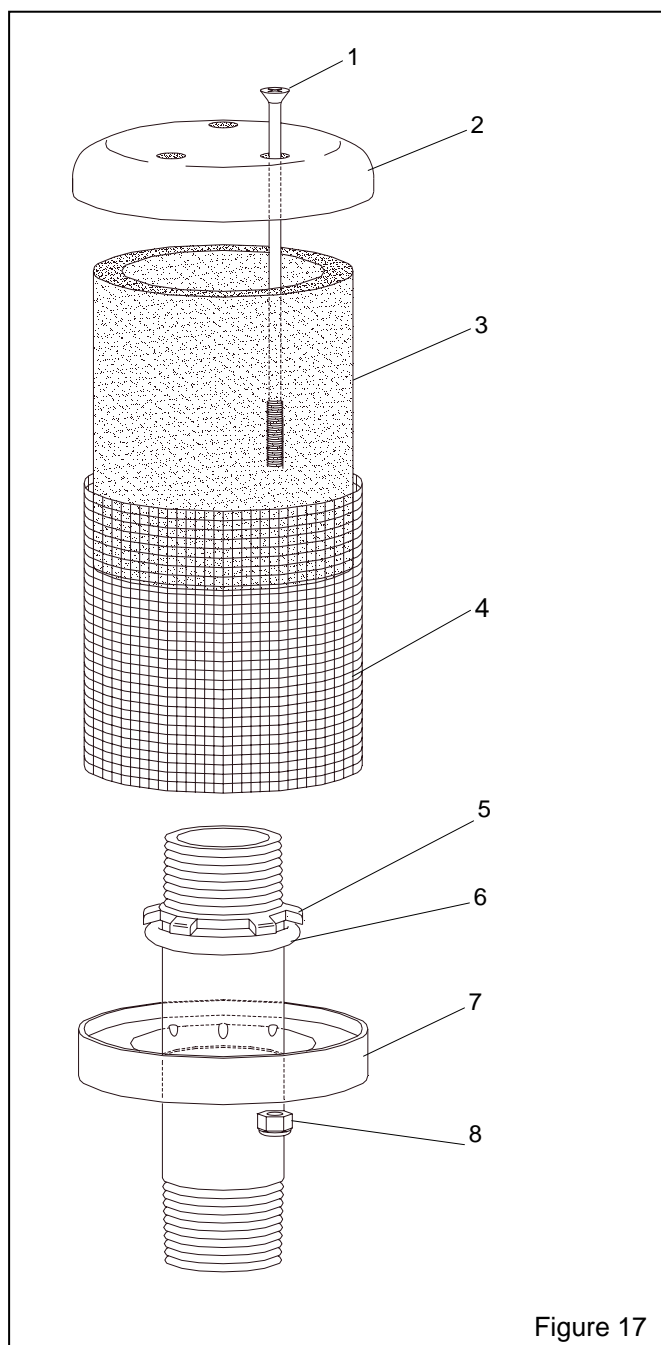


Figure 17

7.13 FSV Abrasive Metering Valve, Figure 18

Item	Description	Stock No.
(-)	Metering valve, complete	02427
1.	Upper body	02422
2.	Valve disc w/ stem	02423
3.	Gasket, rubber, 2 required	02424
4.	Disc-stainless	02425
5.	Lower body	02426
6.	Metering handle, heavy duty	20498
7.	Cap screw, 1/4-NC x 1" hex head	03053
8.	Wing nut, 1/4-NC	03113
9.	Handle bolt spacer	02431
10.	Valve handle pin	20246
11.	Gauge unit	02433

12.	Set screw, 1/4-NC x 1/2" square head	03080
13.	Spring, compression	01982
14.	Stud	02436
15.	Packing gland	02437
16.	O-ring, 7/8" OD	21165
17.	Gasket, shaft	02439
18.	Inspection plate	02440
19.	Cap screw 5/16-NC x 1" hex head	03152
20.	Wing nut, 5/16-NC	03213
21.	O-Ring	01990
22.	Nipple, heavy wall 1-1/2" x close	01791
23.	Wye, standard 1-1/4"	01818
24.	Nipple, heavy wall 1-1/4" x 5"	01860
25.	Nut, 1/2-NC hex	03511
26.	Cap screw, 1/2-NC x 1-3/4" hex head	03455
27.	Washer, 1/4" flat	03116
28.	Hitch pin	20245

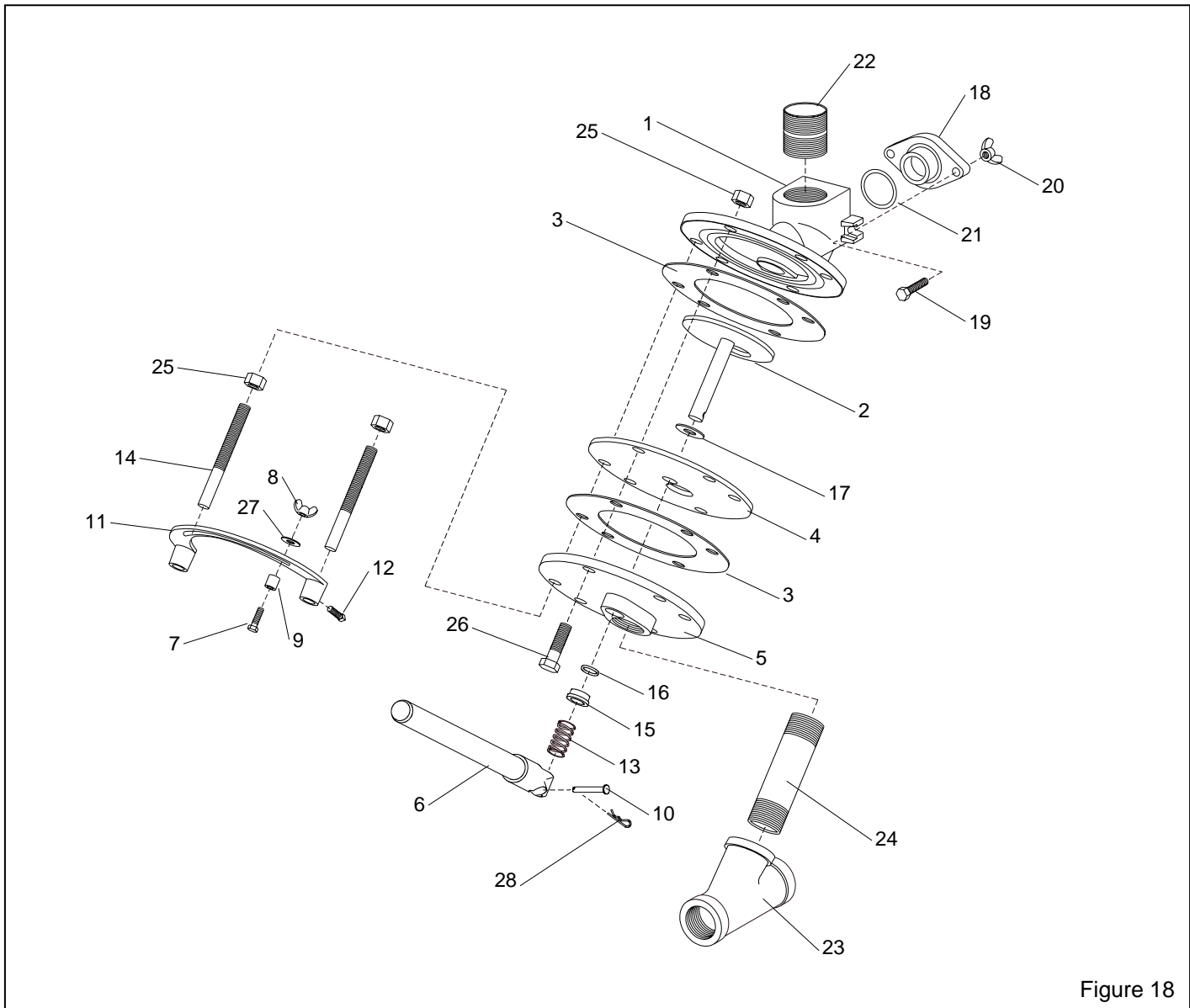


Figure 18