

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

**DATE OF ISSUE: 04/98  
REVISION: G, 02/17**

** WARNING**

**Do not use this equipment until you have READ 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.**

**\*If you are using a Clemco Distributor Maintenance and Parts Guide, refer to the orange warnings insert preceding the Index before continuing with the enclosed instructions.**

**Electronic files include a Preface containing the same important information as the orange cover.**

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## **WARNING**

- Employers are responsible for identifying all job site hazards, educating and training all persons who will operate and maintain these products, and ensuring that all blast operators and their assistants understand the warnings and information contained in these instructions relating to safe and proper operation and maintenance of this equipment.
- Serious injury or death can result from failure to comply with all Occupational Safety and Health Administration (OSHA) regulations and all manufacturer's instructions.
- This equipment is not intended for use in any area considered hazardous per National Electric Code NFPA 70 2011, Article 500.
- Read this document and follow all instructions before using this equipment.

OSHA regulations relating to abrasive blasting are contained in the Code of Federal Regulations, Title 29 (29 CFR 1910 General Industry; 1915 Maritime; 1926 Construction). The most pertinent include: 1910.94 Ventilation, 1910.95 Occupational Noise Exposure, 1910.132 Personal Protective Equipment, 1910.133 Eye and Face Protection, 1910.134 Respiratory Protection, 1910.135 Head Protection, 1910.244 (b) Remote Controls. Consult [www.osha.gov](http://www.osha.gov) for complete information.

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

Clemco proudly provides products for the abrasive blast industry and is confident that industry professionals will use their knowledge and expertise for the safe and efficient use of these products.

The products described in this material, and the information relating to these products, are intended for knowledgeable, experienced users.

No representation is intended or made as to: the suitability of the products described here for any purpose or application, or to the efficiency, production rate, or useful life of these products. All estimates regarding production rates or finishes are the responsibility of the user and must be derived solely from the user's experience and expertise, not from information contained in this material.

It is possible that the products described in this material may be combined with other products by the user for purposes determined solely by the user. No representations are intended or made as to the suitability of or engineering balance of or compliance with regulations or standard practice of any such combination of products or components the user may employ.

Abrasive blast equipment is only one component of an abrasive blasting job. Other products, such as air compressors, air filters and receivers, abrasives, scaffolding, hydraulic work platforms or booms, equipment for lighting, painting, ventilating, dehumidifying, parts handling, or specialized respirators or other equipment, even if offered by Clemco, may have been manufactured or supplied by others. The information Clemco provides is intended to support the products Clemco manufactures. Users must contact each manufacturer and supplier of products used in the blast job for warnings, information, training, and instruction relating to the proper and safe use of their equipment.

### **GENERAL INSTRUCTIONS**

This material describes some, but not all, of the major requirements for safe and productive use of blast machines, remote controls, respirator systems, and related accessories. All equipment and accessories must be installed, tested, operated and maintained only by trained, knowledgeable, experienced users.

The blast operator and all workers in the vicinity must be properly protected from all job site hazards including those hazards generated by blasting.

Work environments involving abrasive blasting present numerous hazards. Hazards relate to the blast process from many sources that include, but are not limited to, dust generated by blasting or from material present on the surface being blasted. The hazards from toxic materials may include, but are not limited to, silica, cyanide, arsenic, or other toxins in the abrasives or in the coatings, such as lead or heavy metals. Other hazards from toxins include, but are not limited to, fumes from coating application, carbon monoxide from engine exhaust, contaminated water, chemicals or asbestos. In addition, physical hazards that may be present include, but are not limited to, uneven work surfaces, poor visibility, excessive noise, and electricity. Employers must identify all job site hazards and protect workers in accordance with OSHA regulations.

Never modify Clemco equipment or components or substitute parts from other manufacturers for any Clemco components or parts. Any unauthorized modification or substitution of supplied-air respirator parts violates OSHA regulations and voids the NIOSH approval.

### **IMPORTANT**

Contact Clemco for free booklets:

*Blast Off 2 – Guide to Safe, Productive, and Efficient Abrasive Blasting, and Abrasive Blasting Safety Practices – Guide to Safe Abrasive Blasting.*

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# OPERATIONAL INSTRUCTIONS

### *OPERATOR SAFETY EQUIPMENT*

## **WARNING**

- OSHA regulation 1910.134 requires appropriate respiratory protection for blast operators and workers in the vicinity of blasting. These workers must wear properly-fitted, properly-maintained, NIOSH-approved, respiratory protection that is suitable for the job site hazards. Blast respirators are to be worn only in atmospheres not immediately dangerous to life or health from which wearers can escape without use of the respirator.
- The employer must develop and implement a written respiratory protection program with required worksite- specific procedures and elements for required respirator use. The employer must provide effective training to employees who are required to use respirators. The training must be comprehensive, understandable, and recur annually, and more often if necessary.
- NEVER use abrasives containing more than one percent crystalline silica. Fatal diseases, such as silicosis, asbestosis, lead or other poisoning, can result from inhalation of toxic dusts, which include, but are not limited to, crystalline silica, asbestos, and lead paint. Refer to NIOSH Alert 92-102; and OSHA CPL 03-00-007: “National Emphasis Program – Crystalline Silica”, in which OSHA describes policies and procedures for implementing a national emphasis program to identify and reduce or eliminate health hazards from exposure to crystalline silica. Numerous topics associated with the hazards of crystalline silica in silica blasting sand can be found on [http:// osha.gov/](http://osha.gov/). Clemco urges users of silica blasting sand to visit this website, and read and heed the information it contains.
- Always make sure the breathing air supply (respirator hose) is not connected to plant lines that supply gases that include, but are not limited to, oxygen, nitrogen, acetylene, or other non-breathable gas. Never modify or change respirator air line connections without first testing the content of the line for safe breathing air. Failure to test the line may result in death to the respirator user.

- Breathing air quality must be at least Grade D, as defined by the Compressed Gas Association specification G-7.1, per OSHA Regulation 29 CFR 1910.134. When compressed air is the breathing air source, a Clemco CPF (suitable sorbent bed filter) should be used. Respirator hose connecting the respirator to the filter must be NIOSH approved. Non- approved hose can cause illness from chemicals employed to manufacture the hose.

- All workers must always wear NIOSH-approved respirators when any dust is present. Exposure to dust can occur when handling or loading abrasive, blasting, cleaning up abrasive, or working in the vicinity of blasting. Before removing the respirator, test the air with a monitoring device to ensure it is safe to breathe.

- Clemco respirators DO NOT remove or protect against carbon monoxide or any other toxic gas. Monitoring devices must be used in conjunction with the respirator to ensure safe breathing air. Always locate compressors and ambient air pumps where contaminated air will not enter the air intake.

- Always use Clemco lenses with Clemco respirators; installing non-approved lenses voids the NIOSH approval. Respirator lenses are designed to protect the wearer from rebounding abrasive; they do not protect against flying objects, heavy high-speed materials, glare, liquids, or radiation.

### *INDUSTRY ORGANIZATIONS*

For additional information, consult:

Occupational Safety and Health Administration (OSHA) - [www.osha.gov](http://www.osha.gov)

Compressed Gas Association (CGA) - [www.cganet.com](http://www.cganet.com)

The Society for Protective Coatings (SSPC) - [www.sspc.org](http://www.sspc.org)

National Association of Corrosion Engineers (NACE) - [www.nace.org](http://www.nace.org)

American Society for Testing and Materials (ASTM) - [www.astm.org](http://www.astm.org)

National Institute of Occupational Safety and Health (NIOSH) - [www.niosh.gov](http://www.niosh.gov)

American National Standards Institute (ANSI) - [www.ansi.org](http://www.ansi.org)

# PREFACE

## *BLAST MACHINES AND REMOTE CONTROLS*

### **WARNING**

OSHA regulation 1910.169 describes 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.

OSHA regulation 1910.244(b) requires the use of remote controls on blast machines.

Serious injury or death can result from many sources, among them:

- Involuntary activation of the remote controls. Never modify or substitute remote control parts; parts are not compatible among different manufacturers. Welding hose is not suitable for remote control hose. Its ID and material composition make it unsafe for remote control use.
- Exceeding the maximum working pressure. Clemco blast machines are built to ASME-code and carry a 'U' or 'UM' stamp, and National Board/serial number. Every machine is marked with its maximum working pressure. Never exceed the maximum working pressure limits of the blast machine.
- Uncontrolled blast stream. High-velocity abrasive particles will inflict serious injury. Always point the blast nozzle in the direction of the blast surface only. Keep unprotected workers out of the blast area.
- Welding on the blast machine. Never weld on the blast machine; welding voids the National Board approval and may affect the dimensional integrity of the vessel.
- Moving the blast machine. Never manually move a blast machine containing abrasive, any machine containing abrasive must be moved with appropriate mechanical lifting equipment.

## *HOSES, COUPLINGS, AND NOZZLE HOLDERS*

- The inside diameter (ID) of air hoses, fittings, and connections should be at least four times larger than the nozzle orifice size. Blast hose ID should be three to four times the size of the nozzle orifice. Example: a #6 nozzle (3/8" diameter orifice) calls for 1-1/2" ID blast hose and 1-1/2" ID or larger compressor hose. All hose runs should be kept as short as possible and run in as straight a line as possible to reduce pressure loss.
- To install, squarely cut the end of the hose so that it fits snugly against the coupling or hose end shoulder. Always use the screws recommended by the manufacturer ensuring that they do not penetrate the inner wall. Make sure the couplings tightly fit the hose. Install cotter pins at every connection or use couplings with built-in lock-springs to prevent disengagement. Install safety cables at all connections to prevent whipping if hoses disengage or blow out.

## *MAINTENANCE AND REPAIR*

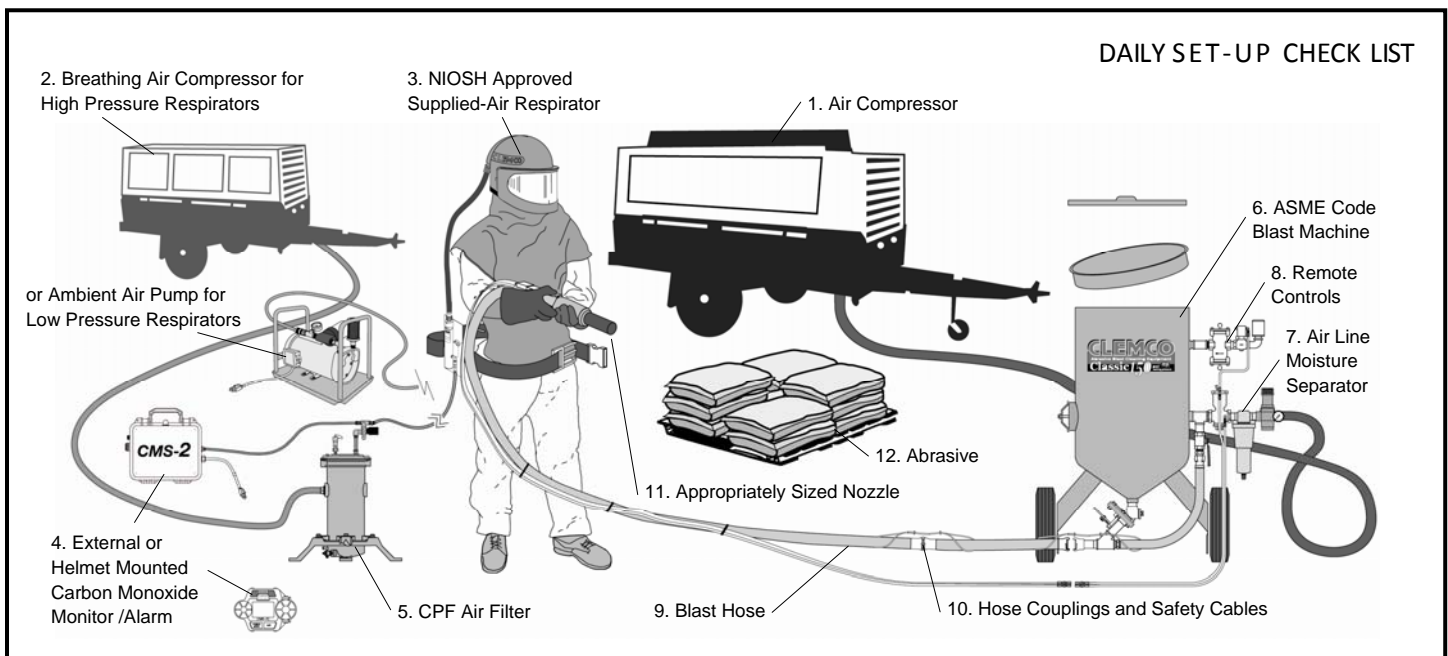
- Completely read and follow all service instructions and recommended maintenance intervals. Always shut off compressor and depressurize blast machine before performing any maintenance. At every service interval, clean all filters, screens, and alarm systems. If spring-loaded abrasive valves are used, always cage spring before disassembly.

## *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 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 the 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 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 the 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 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.

# PREFACE



DAILY SET-UP CHECK LIST

Make sure all blast operators are properly trained and suitably attired with a blast suit, safety boots, leather gloves, respiratory and hearing protection. Every day before start up, check all equipment components, including piping, fittings, and hoses, and valves, for leaks, tightness, and wear. Repair or replace as needed. Use the following checklist.

- 1. PROPERLY-MAINTAINED AIR COMPRESSOR** sized to provide sufficient volume (cfm) at given pressure for nozzle and other tools. ADD 50% volume (cfm) reserve to allow for nozzle wear. Use large compressor outlet and air hose (at least 4 times the nozzle orifice diameter). For oil-lubricated compressors, the employer shall use a high- temperature or carbon monoxide alarm, or both, to monitor carbon monoxide levels. If only high-temperature alarms are used, the air supply shall be monitored at intervals sufficient to prevent carbon monoxide in the breathing air from exceeding 10 ppm. Follow the manufacturer's checklist and maintenance instructions.
- 2. BREATHING-AIR COMPRESSOR** (or oil-less ambient air pump) capable of providing Grade D quality air, located in a dust free area. Read # 1 above.
- 3. CLEAN, PROPERLY-MAINTAINED NIOSH-APPROVED SUPPLIED-AIR RESPIRATOR** worn by blast operators, and other workers exposed to blast dust. Make sure all respirator components are in place — all lenses, inner collar, and cape. Thoroughly inspect all components for wear. The NIOSH approval (approval number is listed in the owner's manual) is for a complete assembly from point of attachment on the CPF (sorbet bed) filter to the complete respirator. Substitution of any part voids the NIOSH approval.
- 4. CARBON MONOXIDE MONITOR/ALARM** installed at the CPF filter or inside the supplied-air respirator for monitoring for the presence of deadly CO gas and warning the operator(s) when the CO level reaches an unacceptable level. When an ambient air pump is used for breathing air, a CO monitor provides a measure of safety. Read # 1 above.
- 5. BREATHING-AIR FILTER (OSHA-REQUIRED sorbet bed filter)** for removal of moisture and particulate matter in the compressed air breathing-air supply. Monitor the condition of the cartridge and replace when odor is detected or at 3 month intervals, whichever comes sooner. The breathing air filter does NOT detect or remove carbon monoxide (CO). Always install a CO monitor/alarm.
- 6. BLAST MACHINE** (bearing U or UM stamp, National Board Number, and Maximum Working Pressure) sized to hold a 30-minute abrasive supply. Examine pop-up valve for alignment. Check piping, fittings, screens, valves for tightness, leaks, and wear. Always ground the machine to eliminate hazard of static shock. Install a blast machine screen to keep out foreign objects. Use a blast machine cover if left outdoors overnight. Never exceed the maximum working pressure of the vessel.
- 7. AIR LINE FILTER** (moisture separator) installed as close as possible to the blast machine inlet and sized to match the size of the inlet piping or larger air supply line. Clean filter and drain often. Damp abrasive causes operational problems.
- 8. REMOTE CONTROLS** are required by OSHA and must be in perfect operating condition. Test and check all components to ensure all parts are present and fully functional. Use genuine replacement parts. NEVER mix parts from different manufacturers. Never use welding hose for remote control hose.
- 9. BLAST HOSE** should have an inside diameter sized to suit the blast nozzle. The ID should be three to four times the size of the nozzle orifice diameter. Blast hose should be arranged in as straight a line as possible from the blast machine to the work area, avoiding sharp bends.
- 10. COUPLINGS AND NOZZLE HOLDERS** should fit snugly on the hose and be installed with manufacturer recommended screws. Coupling lugs must snap firmly into locking position. Gasket must always be used to form a positive seal, and cotter pins must be installed. Replace gasket when wear, softness or distortion is detected. Check nozzle holder for thread wear; replace at any sign of wear. Install safety cables at all connections.
- 11. NOZZLE** orifice size should be checked and nozzle replaced when worn 1/16" from original size. (No. 5 nozzle has 5/16" orifice diameter; replace when it measures 3/8"). Threads should be inspected daily for wear and nozzle should be replaced when wear is detected. Always use a nozzle washer.
- 12. ABRASIVE** must be a material specifically manufactured for blasting. It should be properly sized for the job. Check material safety data sheet for free-silica, cyanide, arsenic, lead and other toxins and avoid use when these toxic, harmful substances are present.
- SURFACE TO BE BLASTED** should be examined for hazardous substances. Take appropriate protective measures as required by OSHA to ensure the blast operator, other workers in the vicinity, and any bystanders are properly protected.

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## 1.0 INTRODUCTION

### 1.1 Scope of manual

1.1.1 These instructions cover set-up, operation, maintenance, troubleshooting, and replacement parts for the 16" diameter, 2 cu. ft. capacity Clemco Contractor Blast Machine with Millennium pneumatic, pressure release remote controls.

1.1.2 These instructions contain important safety information. All operators and personnel involved with the abrasive blast process must read and understand the contents of these instructions, including the orange cover. It is equally important that the operator is trained and qualified to safely operate the blast machine and remote controls, and all other equipment used with the blast machine.

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; it contains important safety information about abrasive blasting that may not be included in equipment operation manuals. The booklet is available in both English and Spanish; to request copies, email [info@clemcoindustries.com](mailto:info@clemcoindustries.com).

### 1.2 Safety Alerts

1.2.1 Clemco uses safety alert signal words, based on ANSI Z535.4-2011, 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 you to potential physical injury hazards. Obey all safety messages that follow this symbol to avoid possible injury or death.

## NOTICE

Notice indicates information that is considered important, but not hazard-related, if not avoided, could result in property damage.

## CAUTION

Caution indicates a hazardous situation that, if not avoided, could result in minor or moderate injury.

## WARNING

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

## DANGER

Danger indicates a hazardous situation that, 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, and frame assembly. Blast machine systems also include optional compressed air filter, and optional CPF particulate air filter.

#### 1.3.2 Instruction Maintenance Manuals

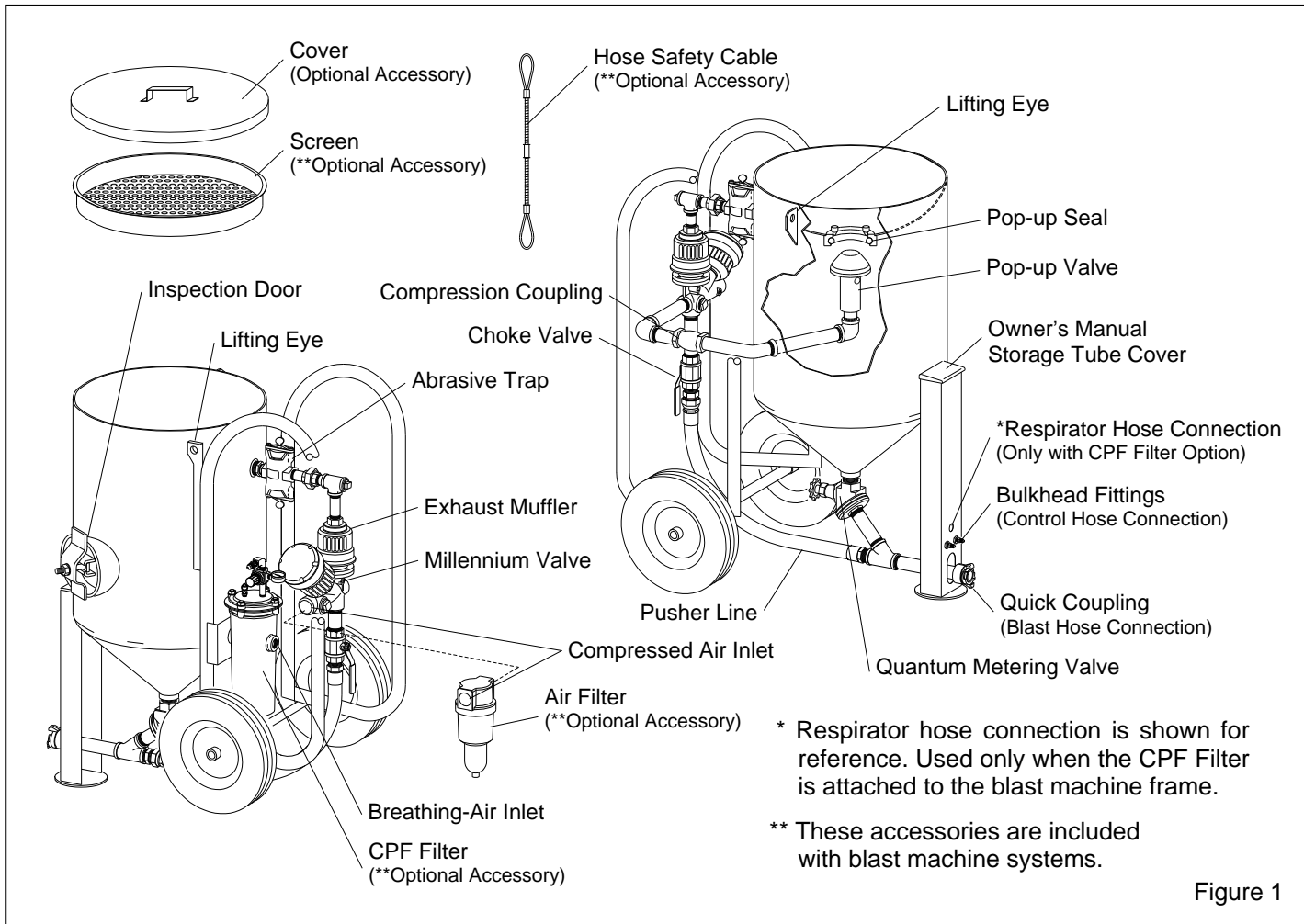
1.3.2.1 Individual manuals are included with optional accessories: Manuals provided with blast machine systems include:

- CPF Particulate Air Filter
- Apollo Respirator
- Clem-Cool Air Conditioner

1.3.2.2 The front leg contains a storage area for owner's manuals. After reviewing all the manuals, and startup 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 certified to conform to the ASME (American Society of Mechanical Engineers) Boiler and Pressure Vessel Code, Section VIII, Division 1. It is the owner's responsibility to maintain the integrity of the vessel in accordance with the requirements of state regulations. Regulations may include regular inspection and hydrostatic testing as described in National Board inspection code and jurisdictional regulations and/or laws.



\* Respirator hose connection is shown for reference. Used only when the CPF Filter is attached to the blast machine frame.

\*\* These accessories are included with blast machine systems.

**⚠ WARNING**

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

**1.3.3.2** All welding repairs to 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 the Clemco ASME certification.

**1.3.3.3** This blast machine is rated for a maximum of 150 psi (pounds per square inch); do not exceed the maximum working pressure. The maximum pressure rating is also stamped into ASME nameplate which is welded to the side of the vessel.

**⚠ WARNING**

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

**1.3.3.4** OSHA does not require pressure relief valves on blast machines when air compressors supplying air to the blast machines are built to ASME<sup>(1)</sup> code and comply with OSHA<sup>(2)</sup> regulations. OSHA regulation 1910.169 refers to the 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.

<sup>(1)</sup> American Society of Mechanical Engineers, Boiler and Pressure Vessel Code, Section VIII, Division 1,

<sup>(2)</sup> Occupational Safety and Health Administration, 29 CFR 1910, 169.

**1.3.4 Remote Controls**

**⚠ 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 can occur, causing serious injury.**

**1.3.4.1** A remote control system is an OSHA-required safety device; it is required when an operator mans the nozzle. The remote controls allow the blast operator to pressurize the machine to start blasting, and depressurize it to stop blasting.

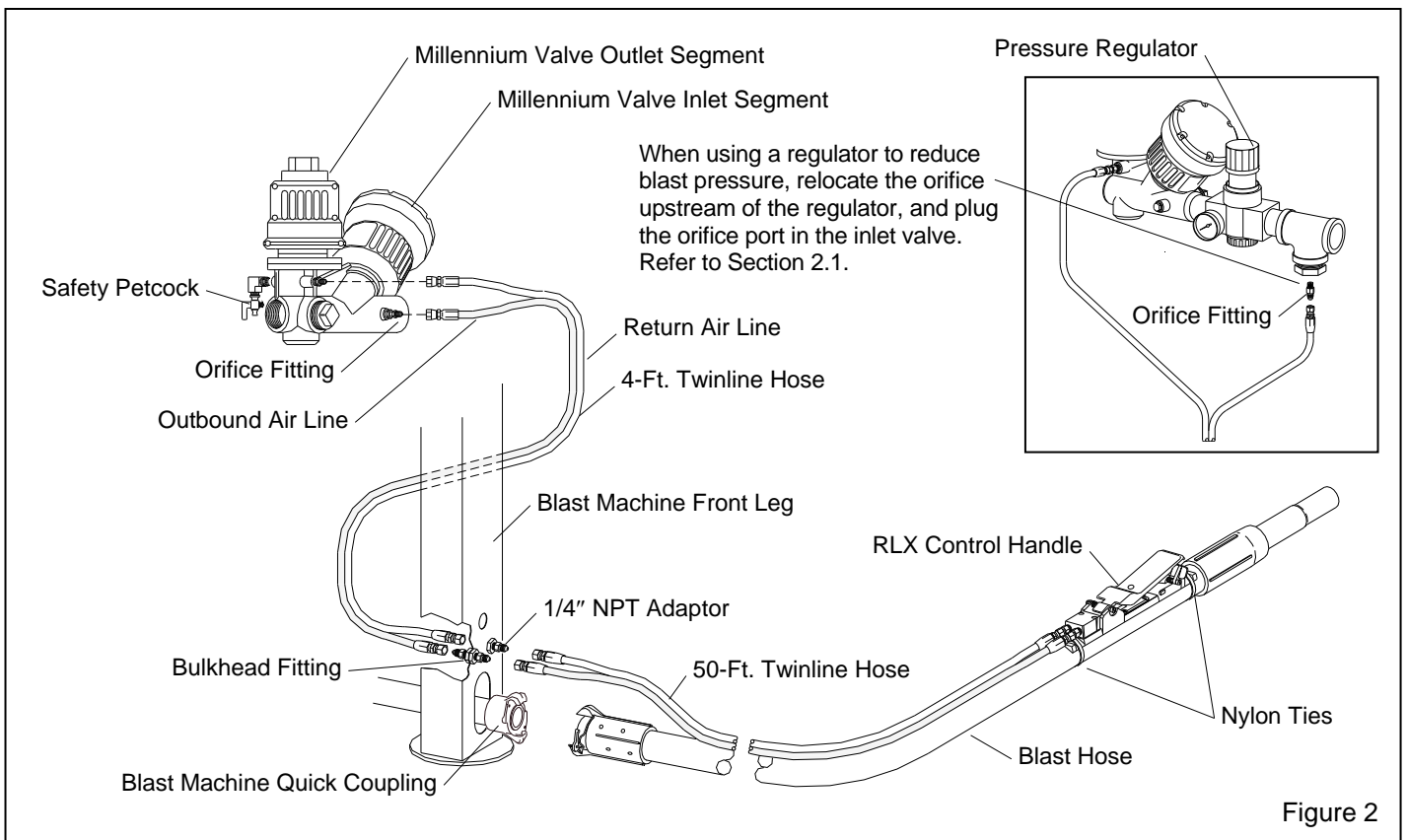
**1.3.4.2** The control handle, located near the blast nozzle, is the activator for the remote control system. When the operator intentionally or unintentionally removes hand-held pressure from the control handle, the machine depressurizes and blasting stops. The remote control system "fails to safe", which means when an interruption in the control-air circuit occurs for reasons such as a break in the line, the compressor stops running, or the operator drops the blast hose, the remote control deactivates the blast machine and blasting stops.

**1.3.4.3** Components of the Millennium remote control system are shown in Figures 1 and 2. They include the Millennium inlet/outlet valve, RLX control handle, 50-ft. and 4-ft. long twinline control hoses, and abrasive trap, shown in Figure 1.

**⚠ WARNING**

**Moist air that freezes can cause blockage at the control handle or in the control lines. Blockage can cause involuntary activation of the remote controls, or prevent the controls from deactivating upon release of the control handle. This situation can 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.**

**1.3.4.4** 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, and depressurization, which stops blasting, occurs when the handle is released.





**1.3.4.5** Clemco remote controls operate pneumatically on a return-air principle. A stream of control air travels from the orifice on the inlet valve, down the outbound twinline (shown shaded in 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 operator presses the control lever, a rubber button seals the opening, and outbound air returns through the inbound 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 causes the inlet valve to close, and the outlet valve to open to depressurize the blast 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 additional 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 through 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.

**1.3.7.2** Use lifting eyes when raising, loading, and unloading the blast machine. Do not use a sling around the cart handles or piping.

## **1.4 Abrasive**

### **⚠ WARNING**

**Abrasives and dust from blasting may contain toxic materials (e.g., lead paint, silica) that are hazardous to workers. Obtain a safety data sheet (SDS) for the blast abrasive and identify all substances removed by the blasting process.**

- **Silica sand (crystalline) can cause silicosis, lung cancer, and breathing problems in exposed workers.**
- **Slags can contain trace amounts of toxic metals such as arsenic, beryllium, and cadmium and have the potential to cause lung disease.**

**NO DUST IS SAFE TO BREATHE. DUST PRODUCED FROM ANY ABRASIVE OR FROM THE BLASTING PROCESS CAN CAUSE SERIOUS LUNG DISEASE AND DEATH WHEN INHALED. It is the employer's responsibility to train employees to identify hazardous substances and to provide suitable policies, procedures, monitoring, recordkeeping and personal protective equipment.**

**NOTE:** Use only abrasives specifically manufactured for blasting that are compatible with the surface being blasted. Abrasives produced for other applications may be inconsistent in size and shape and produce an unsatisfactory finish, contain particles that could jam the abrasive metering valve, or cause irregular wear.

**1.4.1** Selection of blasting abrasive can play a significant part in worker health risk, job productivity, and maintenance of the blast machine. **DO NOT USE** abrasives containing more than one percent crystalline (free) silica. Obtain safety data sheets (SDS) for the blasting abrasive prior to blasting, paying particular attention to worker health risks and presence of any hazardous/toxic substances.

### **1.4.2 Abrasive Size**

**1.4.2.1** The choice of abrasive size depends on the desired profile, cleaning rate, nozzle orifice size and availability of clean dry air. Generally, larger, denser abrasives provide a deeper profile, while smaller abrasives clean faster. Most abrasive blasting is done with abrasive sizes between 16 and 80 mesh. Larger sizes may be used if the nozzle orifice is large enough to

prevent particles to pass without jamming. Finer abrasives are especially sensitive to moisture and requires very dry air to prevent bridging in the metering valve.

**1.4.3 Sand:** Sand should never be used because of the respiratory hazards associated with abrasives containing free silica.

**1.4.4 Slag:** Slag abrasives are compatible with the blast machine fitted with the MQV manual Quantum metering valve. Obtain safety data sheet (SDS) to identify hazardous substances.

**1.4.5 Steel:** Steel shot and steel grit may be used with machines fitted with the MQV manual Quantum metering valve. Shot applications may require the use of a pneumatically-operated metering valve such as AQP Auto-Quantum, to prevent surging at startup.

**1.4.6 Silicon Carbide, Aluminum Oxide, and Garnet:** These are the most aggressive, high-volume abrasives used in the blasting industry. These abrasives may be used, but the service life of any equipment components which come in contact with the abrasive will be reduced. Use a nozzle lined with boron carbide with these abrasives.

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

**1.4.8 Lightweight Media:** Plastic media and most agricultural media may be used occasionally in a standard blast machine. Exclusive use of plastic, and some other lightweight media, requires a blast machine with a 60° conical bottom for continuous, uninterrupted media flow.

## 2.0 INITIAL SET-UP

### 2.1 Installation of a Pressure Regulator to Reduce Blast Pressure.

**2.1.1** When installing a pressure regulator to reduce blast pressure below 60 psi, install a tee upstream of the regulator as shown in the insert in Figure 2, relocate the orifice to the tee, and plug the orifice port in the inlet valve. This allows the pneumatic control circuit to operate at line pressure.

### 2.2 Set Up for Multiple Blast Machines Operating From a Common Compressed Air Supply

## NOTICE

**If multiple machines are operating from a common compressed air supply, and a machine is under pressure, when another machine is pressurized, the sudden, increased demand for air can reverse air flow from the machine that is under pressure, and contaminate the compressed air supply with abrasive-laden air. Install check valves at the piping inlet to prevent the reversal of air.**

**2.2.1** Where multiple blast machines are operating from a single air source, install a ball-cone check valve at the air supply on each machine. Refer to the illustration in Figure 3 to install the check valve.

**2.2.2** If the machines are placed close together, use a receiver tank or manifold and run separate air lines from it to each machine. The check valves may be located on the receiver tank outlets if the air line goes directly to the blast machine and nowhere else.

**2.2.3** Use a Clemco 1-1/2-NPT cone check valve, stock no. 02296. A smaller size valve could restrict air movement and reduce nozzle pressure. When installing the valve, make sure the directional arrow is pointing in the direction of the air flow, toward the machine. NOTE: Do not use a swing check valve, as the swing gate may break in blast machine applications.

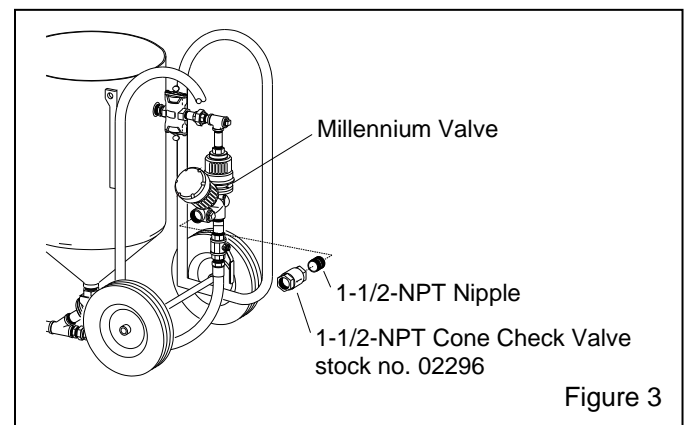


Figure 3

### 2.3 Install Optional Air Filter (Moisture Separator) Figure 4, NOTE: The filter is included with blast machine systems.

**2.3.1** Install a compressed-air filter to the inlet valve as shown in Figure 4. It is recommended that a filter be installed at this location to remove moisture from air before it enters the machine. If problems with moisture

persists after installing the filter, a dryer or aftercooler may be required in the air-supply line.

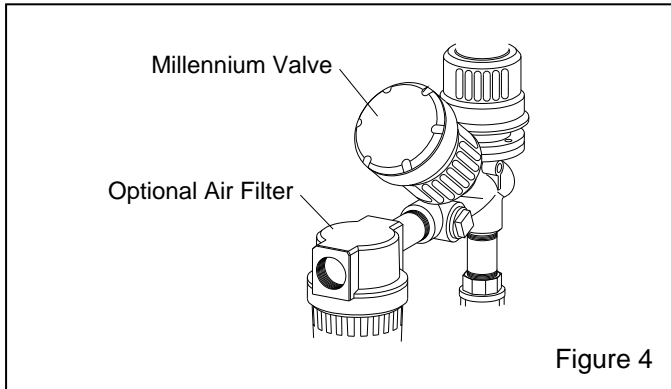


Figure 4

## 2.4 Compressed-Air Supply Hose Connection

**2.4.1** Apply thread sealant to the male pipe threads of an air fitting that is compatible with the air supply hose fitting, as noted in Section 2.4.2, and install it onto the 1-1/2 NPT optional air filter or the Millennium inlet valve, as shown in Figure 5. **Note that the style of connection shown in Figure 5 is for reference only.**

### **⚠ WARNING**

**Hose disconnection while under pressure can cause serious injury or death. Use safety lock pins or safety wire to lock twist-on (claw-type) couplings together and prevent accidental separation while under pressure, and safety cables to prevent hose from whipping should separation occur.**

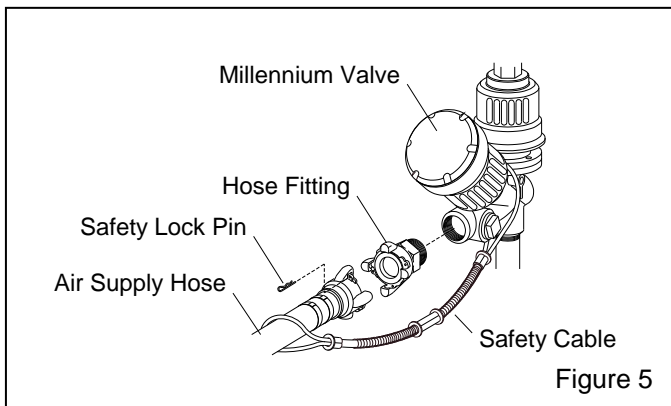


Figure 5

**2.4.2** Attach an air line from the compressor to the hose fitting installed on the blast machine inlet. For best blasting performance, refer to the table in Figure 6 for the minimum recommended hose size based on the nozzle orifice size. A smaller diameter hose could result in a reduction in nozzle pressure.

### AIR LINE RECOMMENDATIONS BASED ON NOZZLE SIZE

Nozzle  
Orifice Size      Recommended Air Supply Line

No. 3, 3/16"	3/4" ID or larger
No. 4, 1/4"	1" ID or larger
No. 5, 5/16"	1-1/4" ID or larger
No. 6, 3/8"	1-1/2" ID or larger
No. 7, 7/16"	2" ID or larger
No. 8, 1/4"	2" ID or larger

Refer to the compressed air and abrasive consumption table in Figure 9 for approximate air consumption.

Figure 6

## 2.5 Prepare Blast Hose and Remote Control Hose Connections, Figure 2.

### **⚠ 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 can 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, stock no. 15890 for use with two blast machines, or stock 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.**

### **⚠ WARNING**

**Moist air that freezes can cause blockage at the control handle or in the control lines. Blockage can cause involuntary activation of the remote controls, or prevent the controls from deactivating upon release of the control handle. This situation can 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.**

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

**2.5.2** Band the control handle to the blast hose close to the nozzle holder, as shown in Figure 7, using the two nylon ties provided. Once the control is firmly attached, clip the tie ends to avoid snags or interference with the operation of the control handle.

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

**2.5.4** 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.

NOTE: Control hoses come with reusable hose ends. Excess hose may be cut-to-fit and recoupled, refer to Section 6.11.

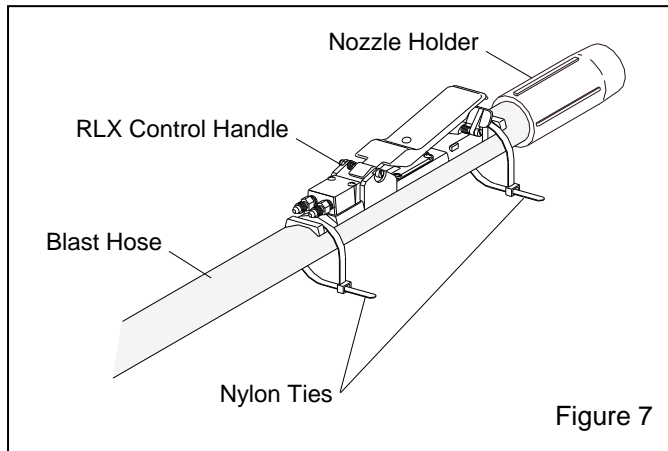


Figure 7

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

**2.6 Breathing Air Connection, Optional CPF Filter, Refer to the CPF Owner's Manual 04143 before operating the filter.**

**⚠ 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 150 psi. Failure to comply with this warning will cause low-pressure devices to explode under the high pressure of bottled air. Such an explosion can cause severe injury or death.**

**⚠ 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.**

**2.6.1** The employer is responsible for ensuring that breathing air shall 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., Chantilly, VA. Website: [www.cganet.com](http://www.cganet.com) (29 CFR 1910.134 (i)).

**2.6.2** Apply thread sealant to the male threads of an air fitting that is compatible with the air supply hose fitting, as noted in Section 2.6.3, and install it onto the 1-NPT port located at the side of the filter, as shown in Figure 8. Note that the style of connection shown is for reference only.

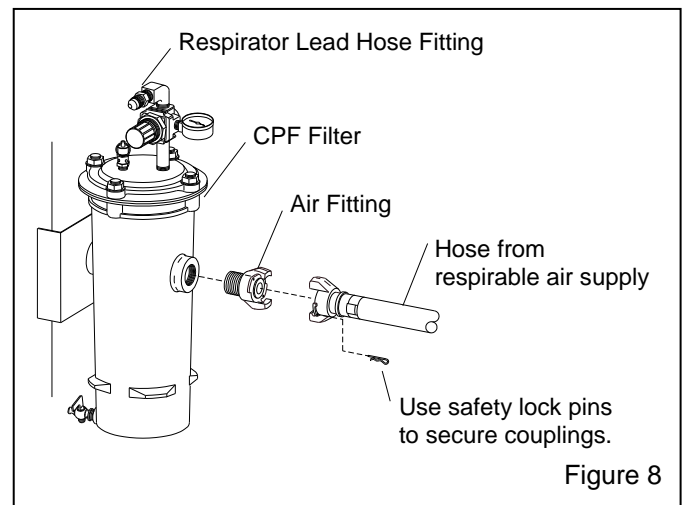


Figure 8

**2.6.3** Refer to the CPF air filter owner's manual and attach an air supply hose from an air source that meets OSHA requirements for respirable air, to the fitting installed on the CPF filter inlet, as shown in Figure 8 and noted in the CPF air filter owner's manual.

**2.6.4** For models with CPF filter attached, Refer to Page 27, Figure 35 and connect a hose union to one end of the 5-ft. respirator lead hose and connect the other end of the hose to the fitting at the top of the CPF filter

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

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### 3.0 OPERATION

#### 3.1 Transporting and Moving

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## WARNING

Failure to observe the following warnings before transporting or moving a blast machine can 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 the machine containing abrasive can increase the weight to an unsafe handling limit, and could cause abrasive to settle in the piping.

#### 3.1.2 Moving a blast machine

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## WARNING

Do not manually move the machine on an incline, or on a slippery or irregular surface that can 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.

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## WARNING

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Never attempt to manually move a blast machine when it contains abrasive. An empty machine may be moved manually in a forward direction, on level flat surfaces.

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

3.1.2.2 To avoid tripping hazards that may be out of view, always move the machine by pushing it in a forward direction. Do not back-up while moving the machine,

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, machine to malfunction, or damaged valves.

#### 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 Attach an air line from the compressor to the air supply hose connector installed on the blast machine inlet. For best blasting performance, use the minimum recommended hose size as noted in Section 2.4.2, Refer to the compressed air and abrasive consumption table in Figure 9 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. **NOTE: When connecting a nylon coupling to a nylon coupling, make sure the coupling spring lock pins are at 180 degrees** (Pins should enter the open hole of the adjoining coupling). The spring lock pins prevent accidental separation of hose couplings during blasting. One lock pin is used when connecting nylon to metal and two are used when connecting two metal couplings.

3.2.4 Make sure that all blast hose couplings and compressed-air supply hose connections are secured with safety lock pins to lock the couplings together and prevent accidental separation while under pressure, and safety cables to prevent hose from whipping should separation occur. Lock pins and safety cables are listed in Section 8.1 of this manual.

Compressed Air and Abrasive Consumption									
Consumption rates are based on abrasives 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)

\* 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 9

**⚠ WARNING**

**Hose disconnection while under pressure can cause serious injury or death. Use safety lock pins or safety wire to lock twist-on (claw-type) couplings together and prevent accidental separation while under pressure, and safety cables to prevent hose from whipping should separation occur.**

**3.2.5** Attach the ends of the 50-ft. twinline hose to the lower adaptors in the bulkhead fittings on the front leg as shown in Figure 10. Either side of the twinline hose can be attached to either fitting.

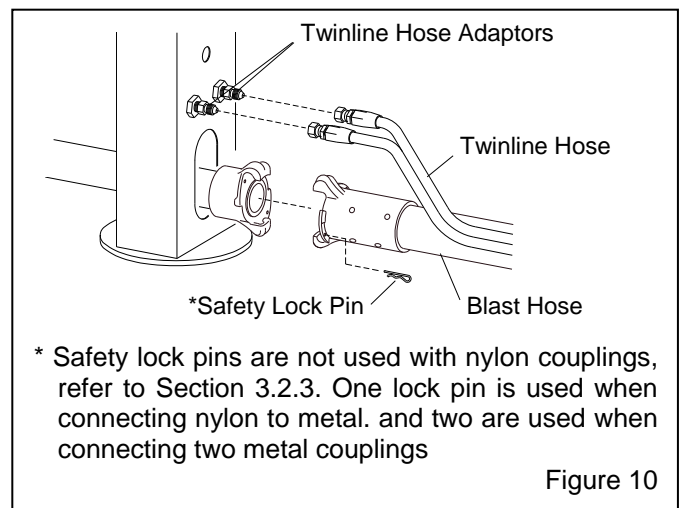


Figure 10

**3.2.6** Check all fittings to make sure they are wrench-tight. Leaks will cause the system to malfunction.

**3.2.7** Attach an air line between a source of respirable breathing and the CPF filter inlet. Breathing air must meet the requirements for Grade D or higher quality. Refer to Section 2.6. The maximum inlet pressure for the CPF Filter must not exceed 150 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 150 psi. Failure to comply with this warning will cause low pressure devices to burst from the excessive pressure of bottled air. A rupture of this nature can cause severe injury or death.**

## **⚠ WARNING**

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

**3.2.8** Make sure the choke valve is open; the valve is open when the handle position is aligned with the piping, as shown in Figure 14.

**3.2.9** Close the abrasive metering valve; The valve is closed when the metering knob is turned fully clockwise. Refer to Section 4.1. NOTE: it is not necessary to close the metering valve after the initial startup and adjustment per Section 4.1.

**3.2.10** Make sure the safety petcock on the Millennium valve. Open position is when the lever is aligned with the petcock, as shown in Figure 11.

## **⚠ 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 cannot activate the machine when the petcock is open.**

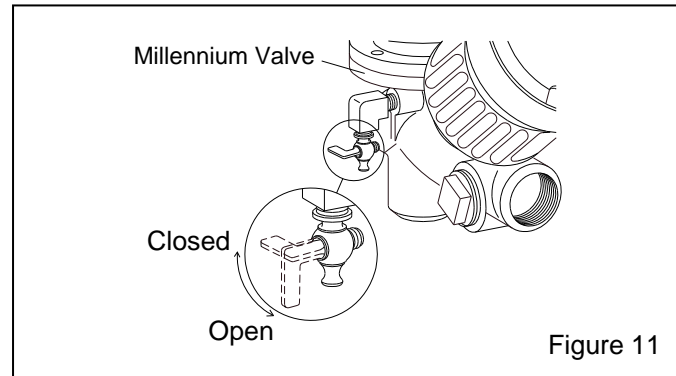


Figure 11

**3.2.11** Make sure the remote control handle lever is in the up (no blast) position, as shown in Figure 12 and that the handle lever and safety lock move freely.

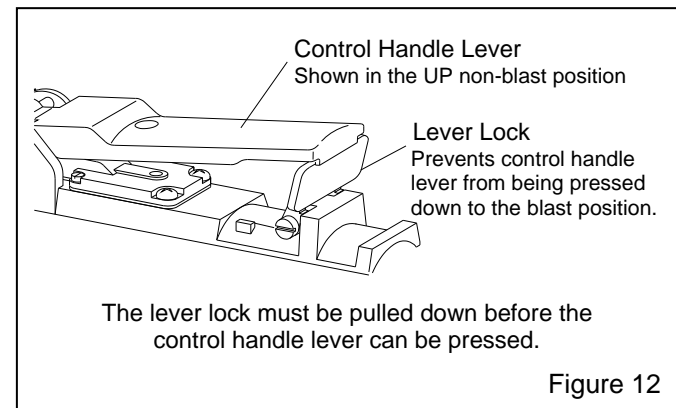


Figure 12

**3.2.12** Make sure the rubber seal under the handle lever does not seal the opening on the control handle, unless the safety lever lock is intentionally pulled down.

## **⚠ WARNING**

**Malfunctioning control handles can 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 be 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 50 psi, but not exceed 150 psi.

**3.2.14** Slowly open the compressor air valve to pressurize the air line. Listen for any open lines or air 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 according to the instructions in Section 3.7.

**3.2.17** Do not allow anyone near the blast machine except machine tenders, who are appropriately attired in approved protective equipment as noted in Section 3.3.

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** WARNING**

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**Everyone except for the blast operator or blast machine tender must stay clear of the blast machine. The machine tender or blast operator may pressurize or depressurize the machine at any time, which can cause abrasive to vent under pressure, causing dust and toxins to become airborne. Noise is produced by the sudden release of compressed air when the machine is pressurized or depressurized. These conditions can cause injury. Both the operator and machine tender must wear suitable personal protective equipment including an approved respirator, plus approved eye, face, and hearing protection.**

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**3.3 Blasting Attire**

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** WARNING**

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**Before blasting, test the coating and substrate for toxic materials (such as lead, other heavy metals, or asbestos). These hazards require special measures to protect the operators and the environment.**

**Obtain a safety data sheet (SDS) for the blast abrasive to identify hazardous substances. Silica sand (crystalline) can cause silicosis, lung cancer, and breathing problems in exposed workers. Slag abrasives may contain trace amounts of toxic metals such as arsenic, beryllium, and cadmium. Any abrasive dust has potential to cause lung disease.**

**Abrasive blasting operations can create high levels of dust and noise. No dust is safe to breathe. Abrasive blasting can produce harmful dust. Failure to wear NIOSH-approved**

**respirators can result in serious lung disease or death. The respirators must be 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 and eye protection appropriate for the job site hazards.**

**Loud noise generated by the use of compressed air can cause hearing damage. Everyone in the blasting area must wear approved hearing protection.**

**It is the employer's responsibility to train employees to identify hazardous substances and to provide suitable policies, procedures, monitoring, recordkeeping and personal protective equipment.**

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**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.

**3.3.2** Don protective blasting attire outside the blast area, in a clean non-hazardous environment, free of contaminants, where the air is safe to breathe.

**3.4 Pressurize Blast Machine to Start Blasting**

**3.4.1** Don all protective blasting attire per Section 3.3.

**3.4.2** 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 activation by the control handle. Air should be heard escaping from the opening under the control handle lever but from nowhere else. The air escaping at the handle is an audible signal meaning air is supplied to the blast machine, which will activate when the control handle is pressed.

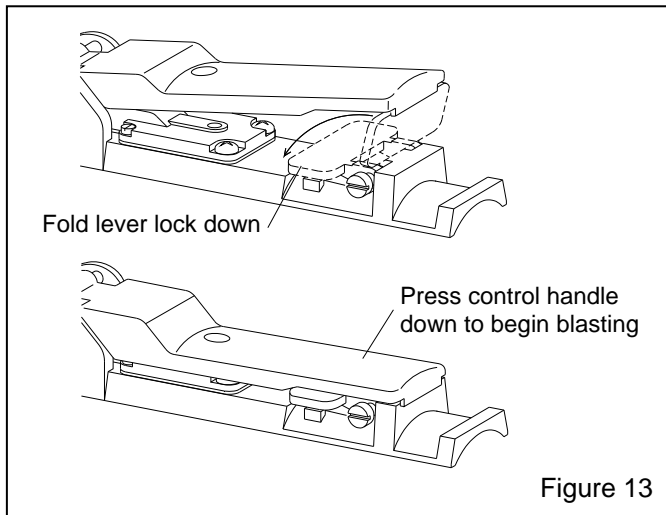
**3.4.3** Hold the blast hose securely and point the nozzle only toward objects intended to be blasted.



**3.4.4** Fold down the safety lever lock and press the remote control handle as shown in Figure 13. Within a few seconds, the pop-up valve will automatically close, and the blast machine will pressurize to start blasting.

## **⚠ WARNING**

**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 when an operator controls the nozzle. To comply with OSHA regulations, the remote control handle, which starts and stops the flow of air and abrasive, must be held down manually. Never 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 can result from uncontrolled blasting. Ref. 29 CFR 1910.244 (b).**

**3.4.5** If the abrasive metering valve is closed as instructed, only air will exit the nozzle. Adjust abrasive flow per Section 4.1.

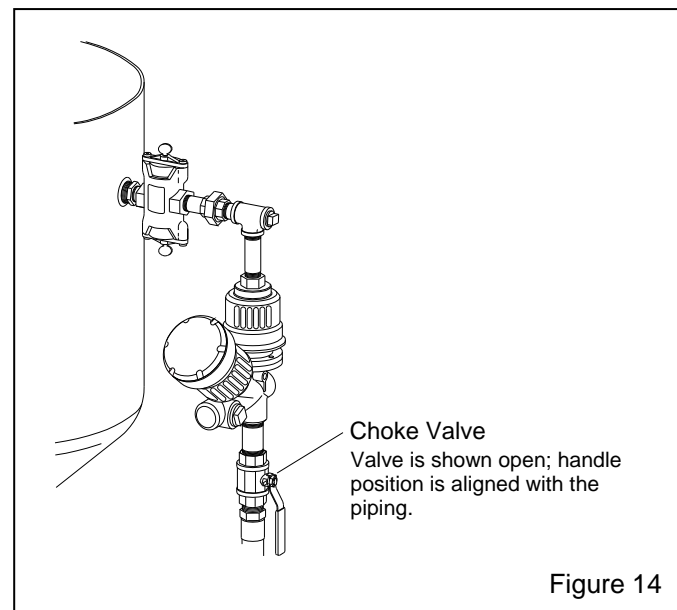
### **3.5 Operation and Function of the Choke Valve Refer to Figure 14**

**3.5.1** Always fully open the choke valve while blasting; open is when the handle is vertical and aligned with the piping as shown in Figure 14.

**3.5.2** Closing the choke valve while blasting, lowers pressure in the pusher line from the pressure in the vessel. Closing the valve forces abrasive through the metering valve to clear minor blockage such as damp abrasive, or is used to rapidly empty the machine at the end of the day.

## **NOTICE**

**Do not blast with choke valve closed or partially closed. Prolonged blasting with the choke valve partially closed will accelerate wear on the metering valve.**



### **3.6 Stop Blasting**

**3.6.1** To stop blasting, release the lever on the control handle. The inlet segment of the Millennium valve closes, the outlet segment opens, and the blast machine depressurizes. The pop-up valve automatically drops when air is expelled from the machine and pressure equalizes.

**3.6.2** 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. Make sure the safety lever-lock is up to prevent the handle lever from engaging.

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

**3.6.4** When finished blasting, shutdown per Section 3.9.

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### 3.7 Loading Abrasive into the Blast Machine

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## 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 can pressurize the machine before the machine tender has moved away from the machine. During pressurization, abrasive can be forced out of the top of the machine, and cause injury.**

---

## WARNING

**Obtain safety data sheets (SDS) 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) of free silica.**

---

**3.7.1** Load abrasive by pouring it into the concave head. Use a screen (a screen comes with blast machine system) placed over the filling head to prevent foreign 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 top of the pop-up valve to prevent abrasive from being forced up and out of the machine when it pressurizes.

**3.7.2** When ready to blast, the operator or machine tender, while standing back and facing away from the concave filling head and exhaust muffler, closes the safety petcock.

**3.7.3** Begin blasting or resume blasting per Section 3.4.

### 3.8 Emptying the Machine of Abrasive

**3.8.1** Empty the machine of all abrasive when shutting down for the day. Condensation dampens abrasive and causes flow problems. When working in environments subject to extreme temperature changes, or very humid conditions, condensation may develop inside the machine.

Emptying the machine at the end of the work day eliminates trouble caused 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:

**3.8.2** With the blast machine OFF, turn the blast pressure to approximately 50-55 psi, close the choke valve and fully open the abrasive metering.

**3.8.3** To prevent wear to the nozzle holder threads, firmly attached the nozzle to the nozzle holder. Removing the nozzle is not recommended. If circumstances require the nozzle to be removed, also remove the nozzle washer. Purging the machine without a nozzle will eventually erode the thread area of the nozzle holder. Thread wear could cause a hazardous condition when the nozzle is reinstalled.

## WARNING

**The threads on the nozzle and nozzle holder must be inspected each time the nozzle is secured to the holder. A loose-fitting nozzle may eject under pressure and can cause severe injury. Check the threads for wear, and make sure the nozzle holder securely holds the nozzle. The nozzle washer must also be inspected for wear. When nozzle washers are worn, abrasive can erode nozzle threads.**

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**3.8.4** Point the nozzle into a drum or suitable container, or toward the direction where the abrasive is to be disposed.

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

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

**3.8.7** If the nozzle was removed, thoroughly inspect the nozzle holder threads for wear before installing the nozzle washer and reattaching the nozzle.

### 3.9 Shutdown

**3.9.1** Empty the blast machine per Section 3.8.

**3.9.2** When finished emptying the machine and after cleanup is completed, remove the respirator and

protective clothing outside the respirator-use area, in a clean environment where the air is safe to breathe.

**3.9.3** Close the compressed-air supply valve at the compressor.

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

**3.9.5** Shutdown the compressor.

**3.9.6** Cover the blast machine when not in use. Refer to Section 8.1 for optional cover.

## 4.0 ADJUSTMENTS

### 4.1 Abrasive Metering, Figure 15

**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 to return the setting to its original position, if temporary adjustments are required.

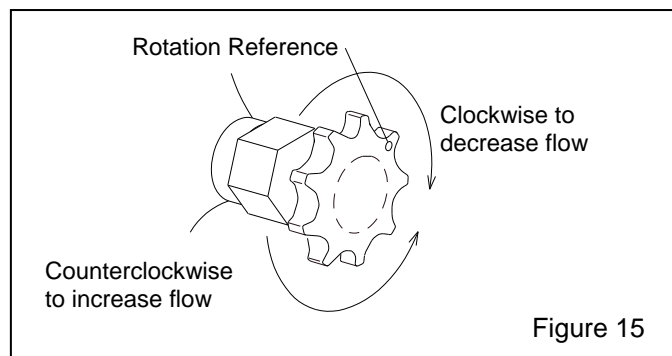


Figure 15

**4.1.3** The valve is closed when the knob is turned 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 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 or More Frequent 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. Refer to Section 6.7.
- Make sure couplings are secure and lock pins and safety cables are in place.
- Inspect the RLX Control Handle; look for the following:
  - The control handle lever must not seal the opening on the control, unless the safety lever lock is folded 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 can 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 be 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, pipefittings ports on the side of the machine or at the bottom of the cone, stop blasting immediately and repair or replace worn parts.

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## NOTICE

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If leaks are allowed to continue, abrasive erosion can cause extensive or irreparable damage to the blast machine.

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- 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.
- 

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## WARNING

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

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### 5.2 Weekly Inspection

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

- Inspect the blast hose for wear; squeeze the hose every two to three feet, looking for soft spots. Soft spots mean the hose is worn. Replace the blast hose before the tube wears as far as the fabric plies.
- 

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## WARNING

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Worn blast hose can suddenly burst. 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, can cause severe injury.

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- Remove the nozzle for inspection. Replace with a new nozzle if the orifice diameter is worn 1/16" or more, or if the liner is damaged.
  - Make sure the nozzle washer is in good condition and in place before reattaching the nozzle.
- 

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## WARNING

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The threads on the nozzle and nozzle holder must be inspected each time the nozzle is secured to the holder. A loose-fitting nozzle may eject under pressure and can cause severe injury. Check the threads for wear, and make sure the nozzle holder securely holds the nozzle. The nozzle washer must also be inspected for wear. When nozzle washers are worn or missing, abrasive can erode nozzle threads.

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5.2.2 After 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 abrasive trap per Section 6.7 and 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. Refer to Section 6.9.
- Inspect the rubber pop-up seal, and replace at the first sign of wear, drying, or cracking. Refer to Section 6.10.
- When an optional air filter is used, inspect the filter element, and clean the bowl.

### 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 lubricate O-rings, pistons, springs, seals, and castings. See Service Maintenance in Sections 6.3, 6.4, and 6.7.

5.4.2 Quantum Metering Valve: To avoid unscheduled downtime, periodically inspect the internal parts of the Quantum metering valve for wear. Refer to Service Maintenance in Sections 6.6.

5.4.3 RLX 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 6.8.

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## 6.0 SERVICE MAINTENANCE

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### **WARNING**

To avoid serious injury from the sudden release of compressed air, observe the following before performing any maintenance.

- Depressurize the blast machine.
  - Turn OFF the compressed air supply.
  - Bleed the air supply-line to the blast machine.
  - Lockout (be certain the air supply is OFF and that it cannot be started while work is in process) and tagout (be certain the air supply is clearly marked to prevent re-starting while work is in process) the compressed air supply.
- 

### 6.1 Removing Damp Abrasive From the Blast Machine

**6.1.1** To clear a minor blockage caused by damp abrasive, while blasting, rapidly open and close the choke valve several times.

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

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

**6.1.2.2** Close the choke valve and fully open the abrasive metering valve.

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

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### **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 can cause severe injury.

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**6.1.2.4** Pressurize the machine to force out any damp abrasive.

**6.1.2.5** 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.

**6.1.2.6** When the hose is cleared, depressurize the machine and attach the nozzle washer and nozzle.

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### **WARNING**

The threads on the nozzle and nozzle holder must be inspected each time the nozzle is secured to the holder. A loose-fitting nozzle may eject under pressure and can cause severe injury. Check the threads for wear, and make sure the nozzle holder securely holds the nozzle. The nozzle washer must also be inspected for wear. When nozzle washers are worn, abrasive can erode nozzle threads.

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**6.1.2.7** Once the hose is 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 3.8.

**6.2.2** Make sure the machine is depressurized. Turn OFF Turn OFF the compressed air supply. Lockout and tagout the air supply, and bleed the air supply line to the blast machine.

**6.2.3** Remove the metering valve cleanout cover by removing the wing nuts securing it.

**6.2.4** Check the metering valve for blockage, by inserting a finger 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 inside 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 cleanout cover O-ring is in good condition and in place before reassembling the cleanout cover.

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

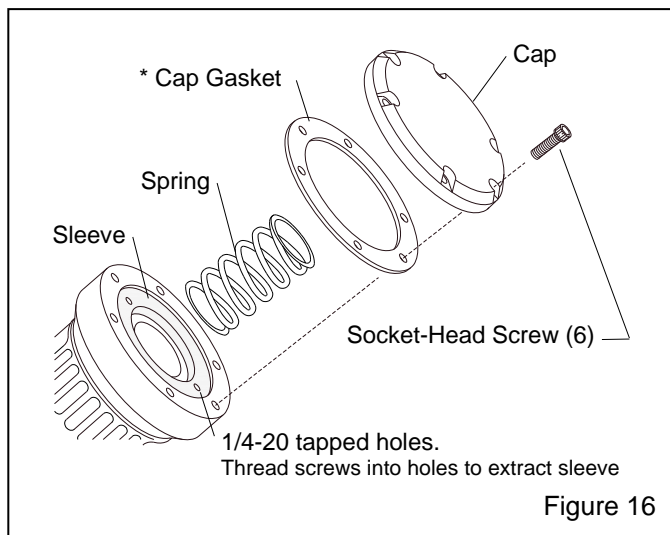
**6.3 Millennium Valve Inlet Segment**

**6.3.1 Inlet Valve Disassembly**

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. Items shown with a single asterisk (\*) are included with the seal kit, refer to Page 29, Figure 38. Use the plunger tip kit when replacing the plunger tip.

**6.3.1.1** Make sure the machine is depressurized. Turn OFF the compressed air supply. Lockout and tagout the air supply, and bleed the air supply line to the blast machine.

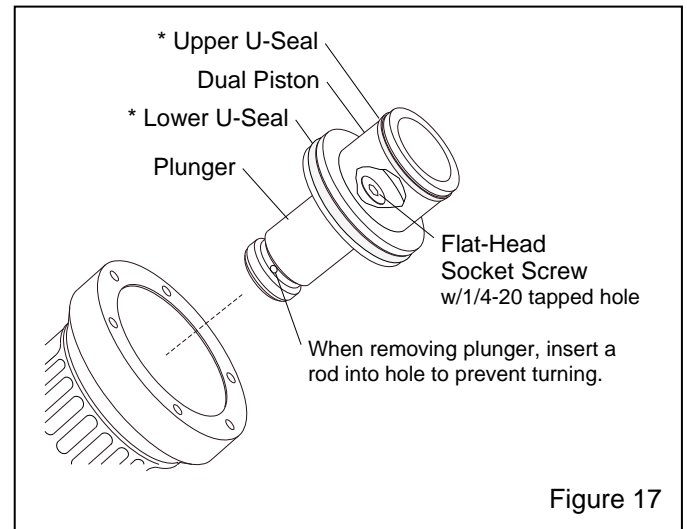
**6.3.1.2** Unscrew the six socket-head screws to remove the cylinder cap, cylinder cap gasket, and spring, as shown in Figure 16.



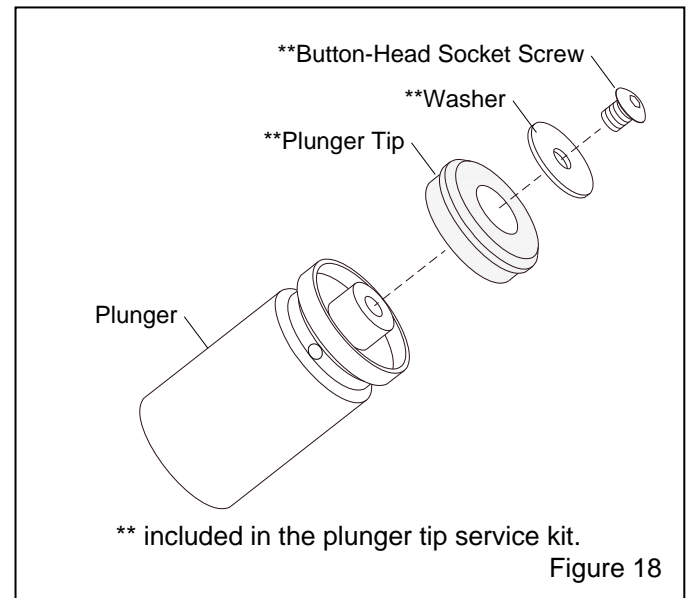
**6.3.1.3** If the cylinder sleeve cannot be removed by hand, screw two 1/4-NC screws into the holes in the end of the sleeve and pull the screws to remove the sleeve from the body. If the sleeve is too tight to remove by hand, use a puller attached to the screws. Remove the screws after the sleeve is removed.

**6.3.1.4** Refer to Figure 17 and grip the edge of the dual piston, and pull the piston/plunger assembly from the body. If unable to remove the piston by hand, screw a long 1/4-NC screw into the threaded 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 attached to the screw. Remove the screw after the piston is removed.

**6.3.1.5** It is not necessary to separate the plunger from the piston unless the metal of either part is scored or otherwise needs to be replaced. 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 flat-head socket screw from inside the piston.



**6.3.1.6** If the plunger tip is worn, use a 3/16" hex key to remove the button screw, washer, and tip as shown in Figure 18.



**6.3.1.7** Refer to Figure 19 and remove both O-rings from the inside the valve body.

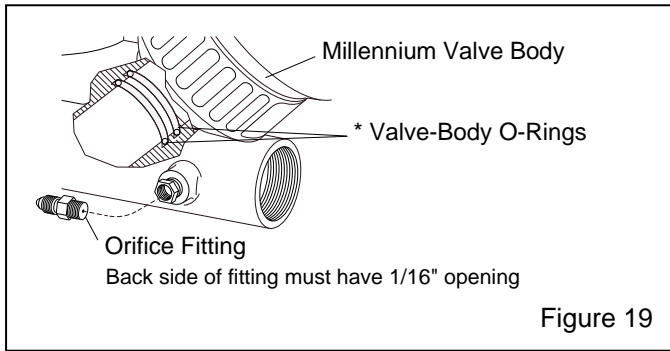


Figure 19

### 6.3.2 Inlet Valve Reassembly

Reassembly is done in reverse order. Refer to the illustration used for disassembly to reassemble. Clean and inspect for wear all parts to be reused; replace worn parts. Lubricate all O-rings and U-seals with O-ring lubricant or light-weight tool oil at assembly.

**6.3.2.1** Clean all items and inspect for wear. Replace all seals and O-rings (included in the service kit).

- 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.

**6.3.2.2** Refer to Figure 19 and install new valve-body O-rings.

**6.3.2.3** Refer to Figure 18 and install new plunger tip.

**6.3.2.4** If the plunger and piston were separated as noted in paragraph 6.3.1.5, refer to Figure 20 and apply removable thread sealant to the threads on the flat-head socket screw, and reassemble the parts using the new O-ring supplied with the service kit.

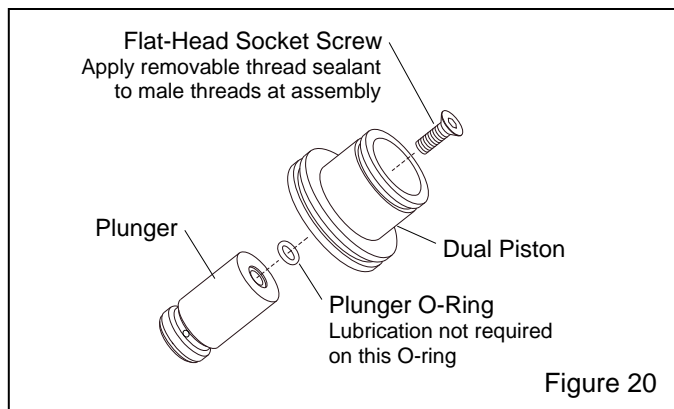


Figure 20

**6.3.2.5** 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 21.

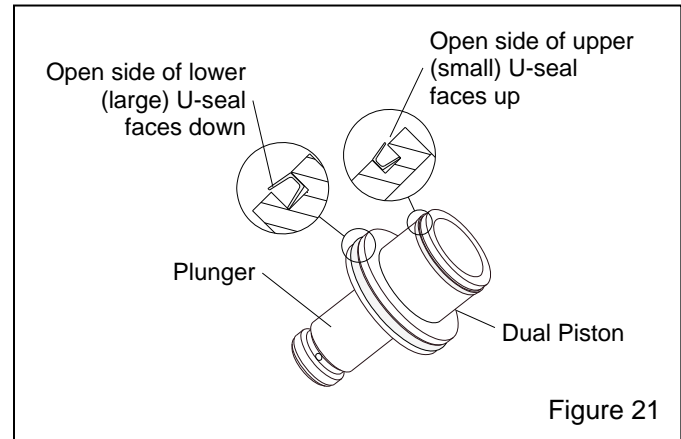


Figure 21

**6.3.2.6** Install the plunger and dual piston assembly into the body. Make sure the open side of the large (lower) U-seal does not fold back during assembly. The cylinder is chamfered to help slip the lip in. Tucking the lip of the seal in, while applying pressure to the piston, eases assembly.

**6.3.2.7** Refer to Figure 22 and place the O-ring on the cylinder sleeve, and insert the sleeve (O-ring end up) into the body. Make sure the open side of the upper (small) U-seal does not fold back during assembly, the sleeve is chamfered to make assembly easier.

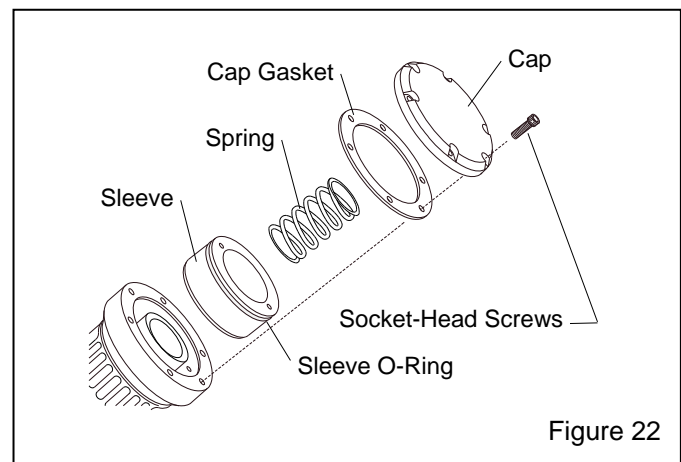


Figure 22

**6.3.2.8** Install the spring, cylinder cap gasket, and cylinder cap.

**6.3.2.9** Tighten the six socket-head screws in sequence to secure the cap.

**6.3.2.10** If fittings on the body were removed, make sure the 1/16" orifice fitting is threaded into the port as shown in Figure 19.

**⚠ WARNING**

**For proper operation, the orifice fitting must always be in place. Do not modify it, or substitute another fitting. Altering the orifice fitting may cause involuntary activation of the blast machine or some other malfunction, which can result in serious injury or death.**

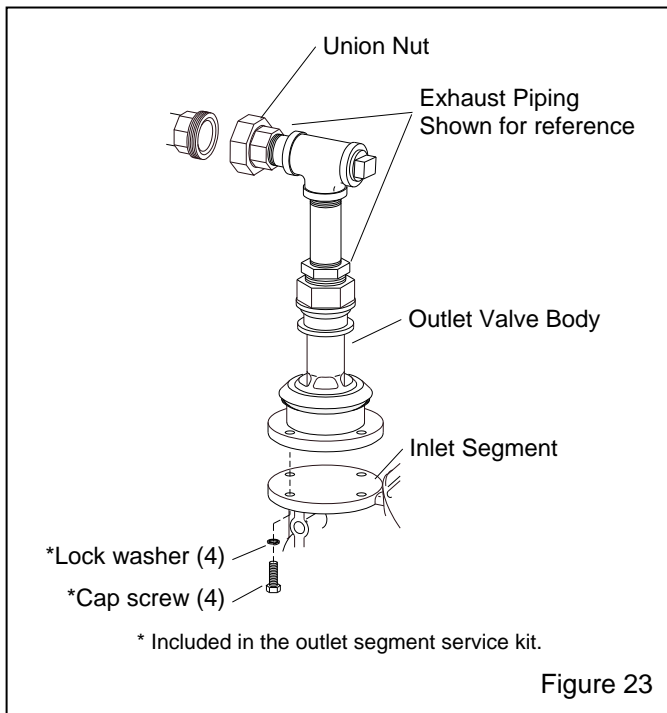
**6.4 Millennium Valve Outlet Segment**

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** Remove the muffler assembly per Section 6.5.

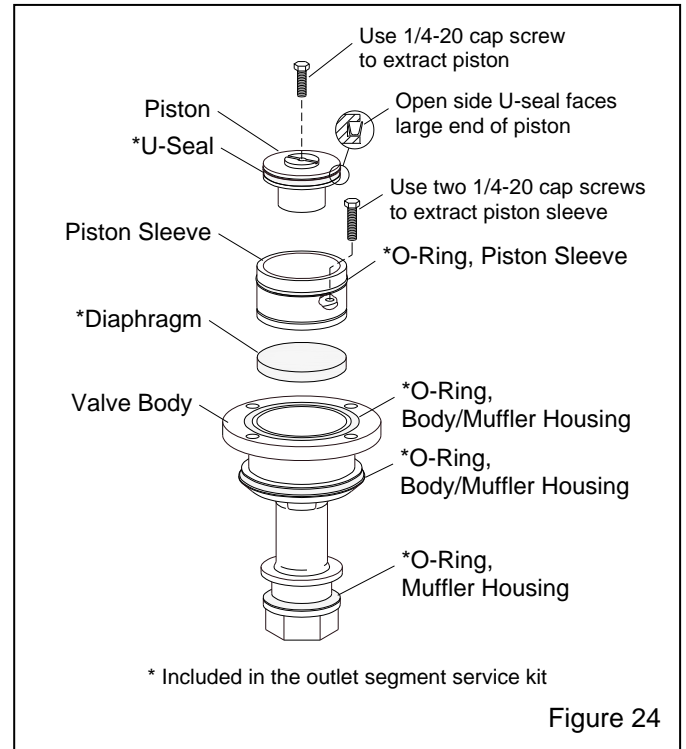
**6.4.2** Loosen the exhaust piping union nut as shown in Figure 23.

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



**6.4.4** Refer to Figure 24 and thread 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.

**6.4.5** Thread two 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.



**6.4.6** Remove the diaphragm from the bottom of the outlet valve body.

**6.4.7** Clean all items and inspect for wear. Replace the diaphragm, seals and O-rings (included in the outlet segment 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 outlet valve body for wear. The body must be replaced if the seat is worn.

**6.4.8** Inspect the exhaust muffler per Section 6.5.

**6.4.9** Lubricate the U-seal with an O-ring lubricant or light-weight tool oil, 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 24.

**6.4.10** Make sure the inner sleeve O-ring is in the lower groove, not in the upper groove, which has the vent hole.

**6.4.11** Insert the piston into the sleeve.



**6.4.12** Place the diaphragm in the valve body.

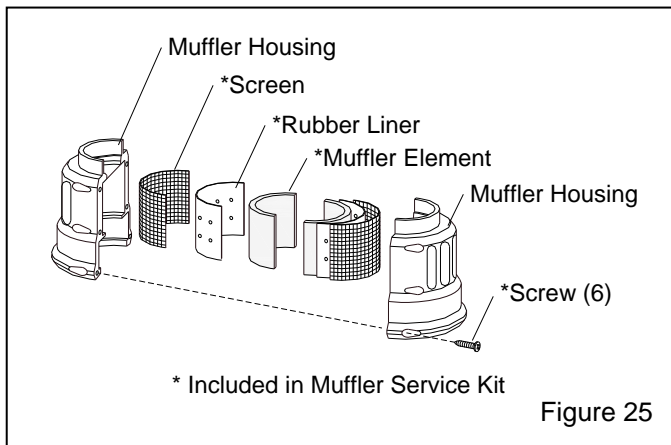
**6.4.13** Slide the piston and sleeve assembly into the valve body. The piston faces away from the bottom of the body, as shown in Figure 24.

**6.4.14** 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 lock washers, and union nut.

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

**6.5 Exhaust Muffler, Figure 25**

**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 sediment or blockage that prevents air from passing through the porous element. Replace the elements as needed.

**6.5.4** Inspect the two sealing O-rings (body/muffler housing O-rings) on the exhaust body (ref Figure 24), 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 Manual Quantum Metering Valve, Figure 26**

NOTE: A service kit is 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.

If immediate service is required and a service kit is not readily available, take extreme care not to misplace or damage O-rings, gaskets, or other seals. Thoroughly clean all reusable parts.

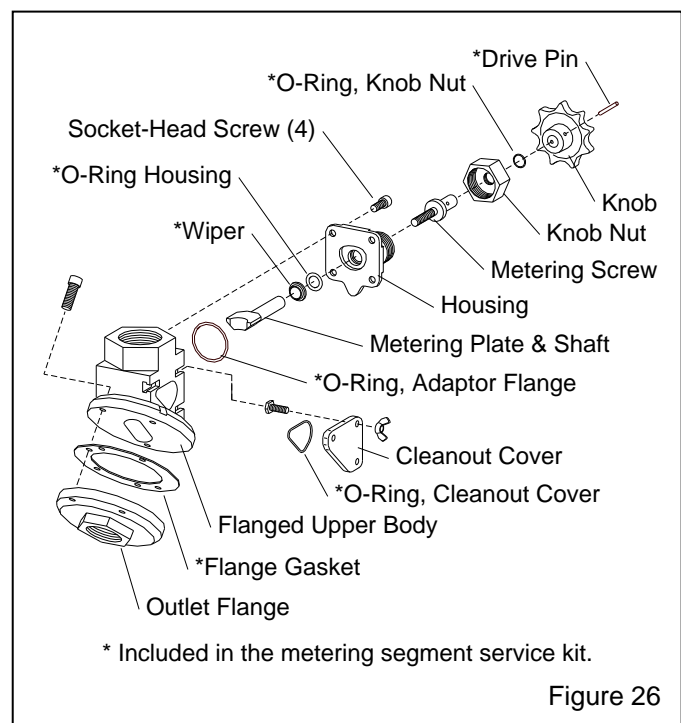
**6.6.1** Empty the machine of abrasive. Turn OFF the compressed air supply. Lockout and tagout the air supply, and bleed the air supply line to the blast machine.

**6.6.2** Remove the cleanout cover wing nuts and cleanout cover.

**6.6.3** Remove the four socket-head screws securing the metering housing, and remove the housing assembly.

**6.6.4** The flanged 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 if worn.

**6.6.5** Turn the metering shaft clockwise to remove the shaft from the metering screw.



**6.6.6** Loosen the knob nut, and pull the knob assembly from the housing.

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

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

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

**6.6.10** Clean the threads on the metering screw, and test the condition of the threads by screwing it into the metering plate shaft. Replace the metering screw if there is any resistance or binding.

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

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

**6.6.13** Place a new O-ring in the knob nut.

**6.6.14** Place a new O-ring and wiper seal in the housing, as shown in Figure 26. The small side of the wiper seal faces away from the O-ring. A generous amount of silicone-based lubricant eases installation.

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

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

**6.6.17** 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.

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

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

**6.6.20** Secure the metering housing finger-tight before tightening all screws.

**6.6.21** Place a new O-ring on the cleanout cover, and securely attach the cover.

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

**6.7 Abrasive Trap, Refer to Figure 27**

**⚠ WARNING**

**To avoid serious injury from the sudden release of compressed air, all service on the abrasive trap must be done with the air OFF and the air supply locked-out and tagged-out.**

**6.7.1** Clean abrasive trap screen and empty the trap twice daily. NOTE: Failure to clean the abrasive trap on a regular basis is a major cause of system malfunction.

**6.7.2** To check the abrasive trap screen, loosen the thumb screw on the upper lock bar, swing the lock bar off the cap, and remove the cap.

**6.7.3** 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.

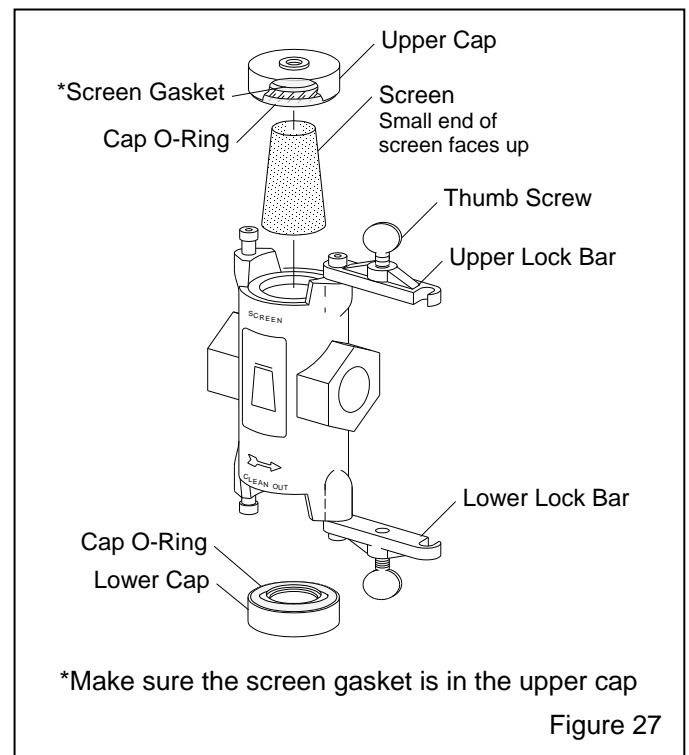


Figure 27

**6.7.4** To clean the bottom section of the trap, loosen the thumb screw on the lower lock bar, swing the lock bar off the lower cap, and then remove the cap.

**6.7.5** Empty all abrasive from the bottom and top sections.

**6.7.6** Install the screen in the top section. The smaller diameter end of the screen must face up as shown in Figure 27.

**6.7.7** Reassemble the upper and lower caps. NOTE: The upper and lower caps are identical except the screen gasket is glued into the upper cap. Make sure the screen gasket is in place in the upper cap, and the O-rings are in place on both caps before assembly.

## 6.8 RLX Control Handle

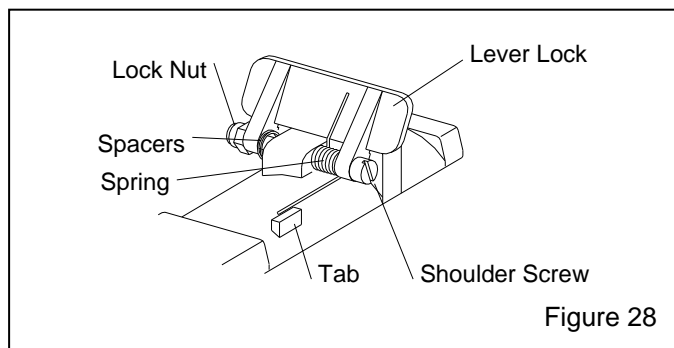
NOTE: A service kit is available for the RLX Control Handle. To avoid unscheduled down-time, a kit should be kept on hand.

### 6.8.1 Spring replacement

**6.8.1.1** To replace the lever lock spring, follow the instructions in Section 6.8.2. To replace the handle lever spring, follow the instructions in Section 6.8.3.

### 6.8.2 Lever Lock replacement, Figure 28

**6.8.2.1** Remove the lock nut from the shoulder screw. Before removing the screw, note the positions of the spacers and spring, as shown in Figure 28. The bent end of the spring is toward the inside, forcing the lever lock up. The straight end is toward the outside facing down, and against the tab.



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

**6.8.2.3** 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.

### 6.8.3 Handle lever replacement, Figure 29

**6.8.3.1** Remove the lock nut from the shoulder screw. Before removing the screw, note the positions of the spacers and spring as shown in Figure 29. The bent end of the spring is against the handle lever, facing up. The straight end is against the body, facing down.

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

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

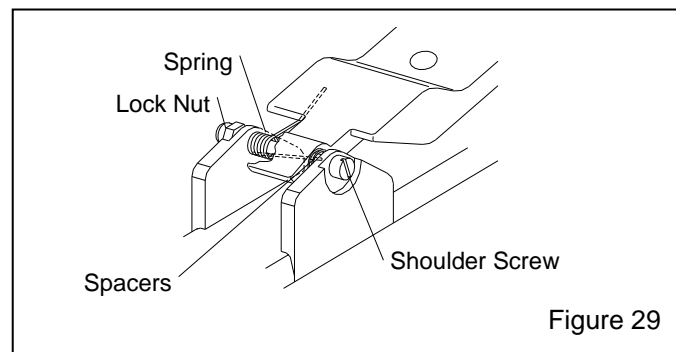


Figure 29

### 6.8.4 Rubber button replacement

**6.8.4.1** Remove the old rubber button.

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

**6.8.4.3** Trim the button stem flush with the top of the handle lever.

### 6.8.5 Gasket replacement

**6.8.5.1** Remove the handle lever per Section 6.8.3.

**6.8.5.2** Remove the six screws holding the pneumatic adaptor to the body.

**6.8.5.3** Install a new gasket.

**6.8.5.4** Place the pneumatic adaptor on the gasket and hand-tighten all screws before tightening them in sequence to uniformly compress the gasket.

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

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

**6.9 Replacing the Pop-Up Valve, Figure 30**

**6.9.1** All service on the pop-up valve must be done with the machine is depressurized, the compressed air supply OFF and the air supply locked-out and tagged-out.

**6.9.2** To gain access to the pop-up valve, loosen the nut on the inspection door clamp and remove the door.

**6.9.3** 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.

**6.9.4** 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.

**6.9.5** 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, it should be wrench-snug, but not wrench-tight. Over-tightening the guide will make it difficult to remove the next time the pop-up valve needs replacement.

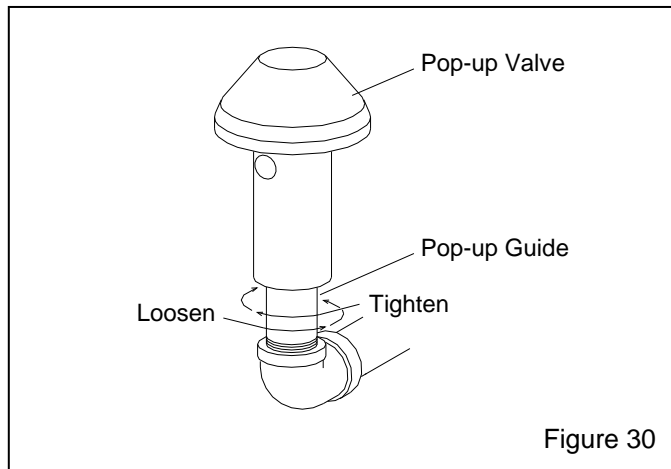


Figure 30

**6.9.6** Refer to Figure 31 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 when filling. Adjust the height by replacing the guide with one that is longer or shorter.

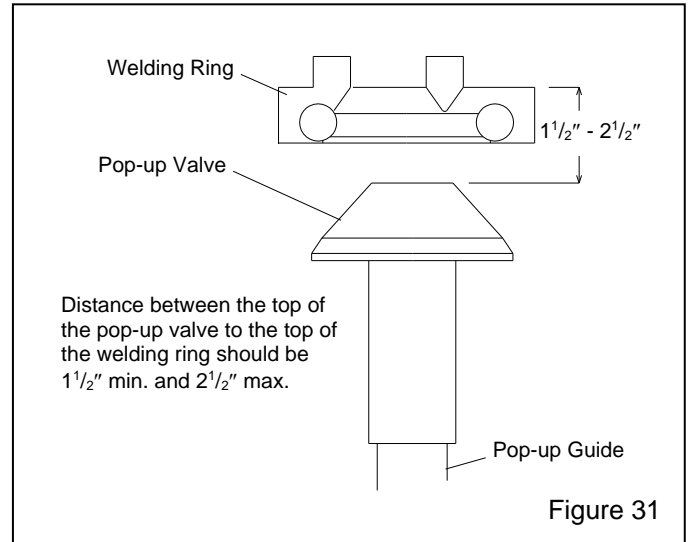


Figure 31

**6.9.7** Put a new gasket on the inspection door before bolting the door onto the machine.

**6.10 Replacing the Pop-Up Seal**

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

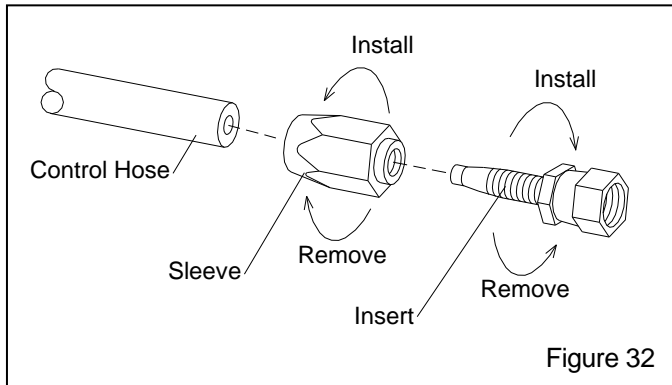
**6.10.2** Remove the old seal using fingers, screwdriver, or similar object, to work the seal out of the retaining groove.

**6.10.3** 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.

**6.11 Remove and Install Reusable Control Hose Ends, Refer to Figure 32**

**6.11.1** Control hoses may be shortened and cut to length as follows:

1. Remove the hose end by placing the sleeve in a vise or use a backup wrench on the sleeve to prevent it from turning. Unscrew the insert by turning it counterclockwise.
2. Turn sleeve clockwise to remove from the hose.
3. Cut hose to length.
4. Turn sleeve counterclockwise to install on hose. Do not over-tighten the sleeve, stop tightening as soon as the hose bottoms-out against the sleeve's internal shoulder. Over tightening will cause the hose to curl inward and could cause blockage.
5. Push end of insert into sleeve, and turn clockwise to tighten until the insert hex is against the sleeve.



## 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 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.

### 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 both the abrasive metering valve and choke valve are open.

### 7.2 Air only (no abrasive) comes out of the nozzle

7.2.1 Abrasive metering valve may be closed or needs adjustment. Adjust abrasive flow per Section 4.1.

7.2.2 Blast machine may be empty.

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

7.2.4 Check the abrasive metering valve for obstructions. Refer to Section 6.2.

### 7.3 Heavy abrasive flow

7.3.1 Make sure the choke valve is fully open. The valve is open when the handle position is aligned with the piping.

7.3.2 Abrasive metering valve may be open too far. Adjust abrasive flow per Section 4.1.

7.3.3 Check the abrasive metering valve for wear. Look for wear on the abrasive valve metering plate.

### 7.4 Abrasive surging

7.4.1 A moderate amount of abrasive surge is normal at startup. Should the flow of abrasive continue to surge, reduce the amount of abrasive in the air stream by adjusting the metering valve per 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 startup. Refer to Section 7.7.

7.4.3 Make sure the choke valve is fully open. The valve is open when the handle position is aligned with the piping.

### 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 problem with moisture persists, a dryer or after-cooler may be required in the air supply line.

7.5.2 Abrasive may be too fine or 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.

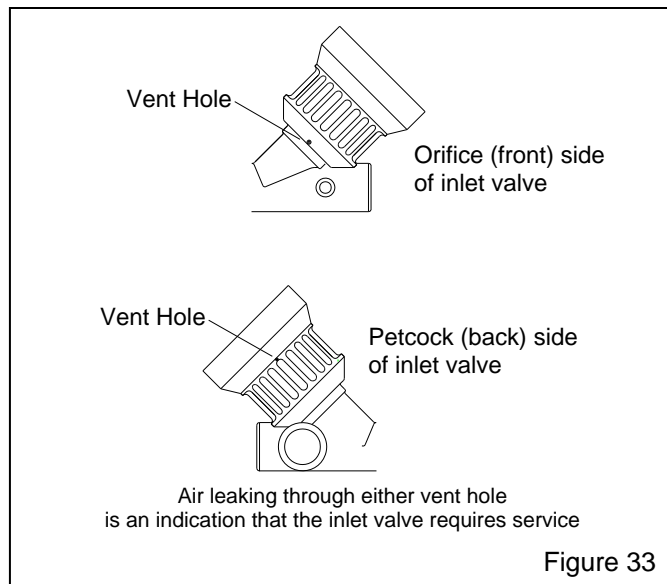
**7.6.3** Inspect the rubber button on the control handle for wear or damage, make sure it seals the opening in the handle when the lever is pressed.

**7.6.4** While the control handle lever is up, check for air escaping (from under the lever) through the opening in the handle. If no air escapes, the orifice on the inlet valve (shown in Figures 2 and 36) 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 for and listen for air leaks anywhere on the handle. If there is a leak, it must be located and repaired. The RLX control handle is covered in Manual No. 10574.

**7.6.6** Press the control handle lever and check control lines and fittings for leaks or breaks. Once the control handle is pressed, there should be no air leaking from anywhere in the controls or blast machine. Any air leak must be located and serviced.

**7.6.7** Close the safety petcock, and press the control handle lever. Make sure that no air escapes through either of the two vent holes in the inlet valve body, shown in Figure 33. Air escaping from either of the vents indicates worn seals in the inlet valve. Service the valve per Section 6.3.



**7.6.8** Open the safety petcock, and press the control handle lever; the same volume of air should exhaust from the petcock as from the control handle before the handle lever is pressed. If it does not, check the following:

- The opening on the control handle is not being sealed off.
- Air leaks in the control handle.
- The line from the control handle to the upper fitting on the inlet valve is blocked.

If the same volume of air does come out the petcock, the inlet segment of the Millennium valve is not functioning. Turn OFF the compressed air supply and service the inlet segment per Section 6.3.

**7.6.9** Inlet valve malfunctioning. Inspect internal parts for wear, and lubrication. Refer to Section 6.3.

**7.6.10** Compressor too small for the nozzle. Refer to the compressed air and abrasive consumption table in Figure 9 for nozzle air consumption.

**7.6.11** Reduced air supply hose or fittings between the compressor and blast machine. Refer to Section 2.4.

**7.6.12** Dirty filter element in optional air filter. Inspect filter element.

**7.6.13** 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 to be emptied. Inspect the screen and empty the trap at least twice daily.

**7.7.2** Exhaust muffler blocked. Inspect the muffler per Section 6.5.

**7.7.3** After releasing the control handle, open the safety petcock on the inlet valve.

- If the machine does depressurizes, control air remains in the control lines, refer to Paragraphs 7.7.4, 7.7.5, 7.7.6, and 7.7.7.
- If the machine does not depressurize, the inlet valve is not fully closing or the outlet valve is not fully opening, refer to Paragraph 7.7.8.

**7.7.4** Check the pneumatic adaptor gasket on the control handle for swelling, which restricts air flow through the handle exhaust opening.

**7.7.5** Inspect the exhaust opening in the control handle pneumatic adaptor; make sure it is clear of obstruction that restricts air from escaping through the opening.

**7.7.6** Check for blockage in the control hose.

**7.7.7** Make sure the orifice (lower) fitting on the inlet valve (shown on Page 29, Figure 38, Item 13) has not been switched for a fitting with a full-flow orifice. The orifice on the 1/8" NPT end of the fitting (the end that threads into the bushing on the valve) must be 1/16" diameter.

**7.7.8** Millennium valve malfunctioning. Make sure the inlet segment fully closes, refer to Section 6.3, and the outlet segment fully opens, refer to Section 6.4.

**7.8 Outlet valve leaks air during blasting**

**7.8.1** Outlet valve diaphragm worn or outlet valve requires service. Refer to Section 6.4.

**7.9 RLX control handle lever fails to return to the non-blast position (up) when released**

**7.9.1** Inspect the handle lever for damage that may cause binding against the body. Replace as necessary.

**7.9.2** Inspect 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**

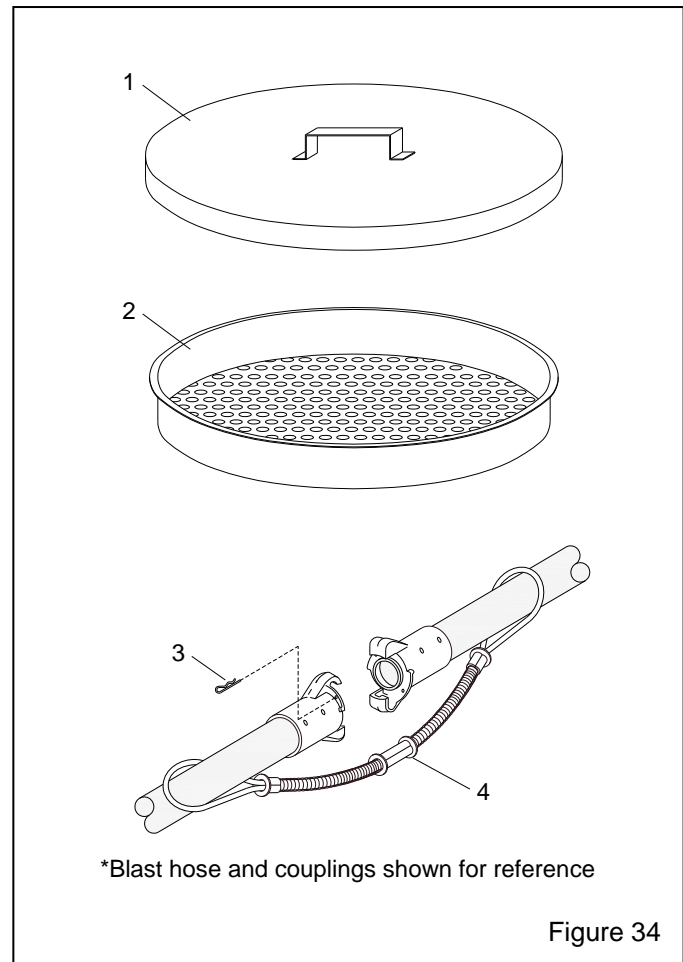
**7.10.1** Inspect the lever lock for damage, or buildup of debris or abrasive that could cause binding.

**7.10.2** Check the lever lock return spring for damage or fatigue. Replace as necessary.

**8.0 ACCESSORIES AND REPLACEMENT PARTS**

**8.1 Accessories, Figure 34**

- (-) Cover, poly bag with Clemco logo for  
2 cu. ft. machines ..... 15143
- 1. Cover, steel, for 16" blast machine ..... 02335
- 2. Screen, for 16" blast machine ..... 03099
- 3. Safety lock pin, package of 25 ..... 11203
- 4. Safety cable,  
for 1-1/2" to 3" OD hose ..... 15013  
for 1-1/2" to 4" OD hose ..... 27405



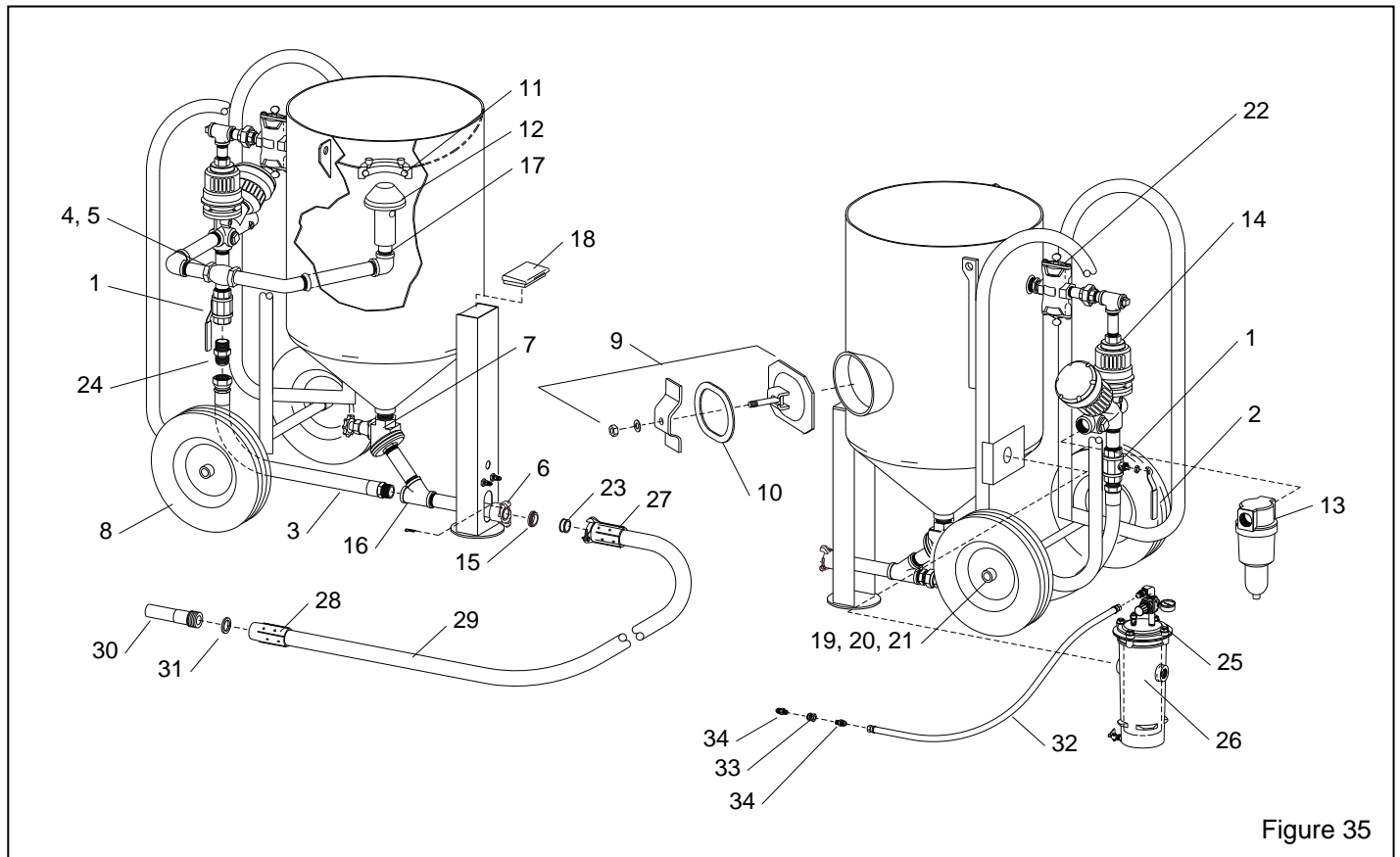
**8.2 Blast Machine, Figure 35**

Item	Description	Stock No.
1.	Ball valve, 1-1/4" with handle	02397
2.	Handle, 1-1/4" ball valve	22532
3.	Pusher line assembly, 1-1/4" x 28"	23674
4.	Compression coupling, 1-1/4"	01857
5.	Gasket, compression coupling, 1-1/4"	01886
6.	Coupling, 1-1/4" CF 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, CQG, pack of 10	00850
16.	Wye, 1-1/4"	01818
17.	Internal pop-up guide, 1-1/4" x 6" toe	01753
18.	Leg 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.	Adaptor, 1-1/4" NPT x JIC	22529
25.	CPF-20 Air filter, optional	03578
26.	Cartridge replacement, CPF filter	03547
27.*	Coupling, nylon, CQPS-1	21088
28.*	Nozzle holder, nylon, NHP-1	04106
29.*	Hose, 1" ID x 50 ft. Supa	23104
30.*	Nozzle, TMP-4	23520
31.*	Washer, nozzle, NW-25, pack of 10	91024
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 35**



**8.3 Remote Control System Parts, Figure 36**

Item	Description	Stock No.
1.	Millennium inlet/outlet valve .....	21336
2.	RLX Control handle .....	10565
3.	Hose, 4 ft. twinline coupled w/item 8 .....	21619
4.	Hose, 50 ft. twinline coupled w/item 8 .....	01951
5.	Fitting, 1/4" NPT bulkhead .....	05605
6.	Adaptor, 1/4" NPT .....	02494
7.	Tie, nylon .....	02195
8.	Hose end, reusable .....	01943

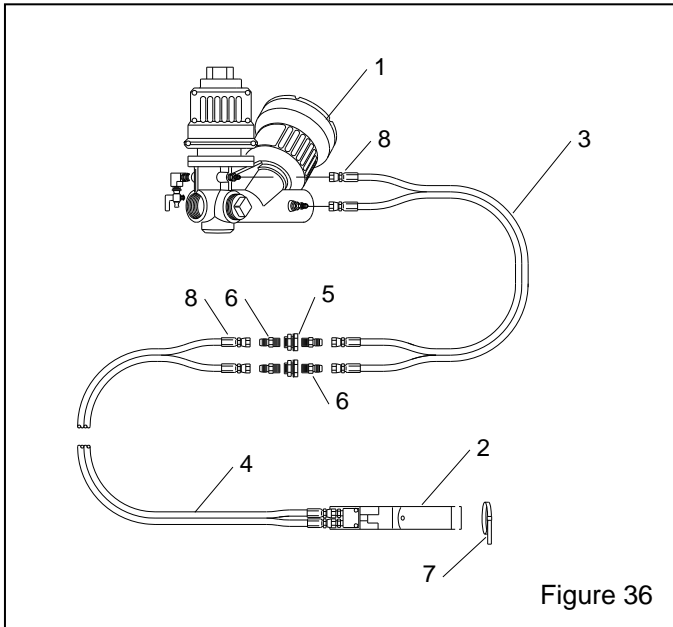


Figure 36

**8.4 MQV Manual Quantum Abrasive Metering Valve, Figure 37**

Item	Description	Stock No.
(-)	Quantum MQV manual metering valve .....	22845
*	Service kit, metering segment (Fig. 37a) .....	22854
1.	Upper body, flanged .....	21314
2.	Screw, 3/8-NC x 1" socket-head .....	22655
3.	Lower body flange .....	22621
4.	Cover, cleanout .....	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" Sch. 80 .....	01840
15.	Nipple, 1-1/4" x 5-1/2" .....	01874

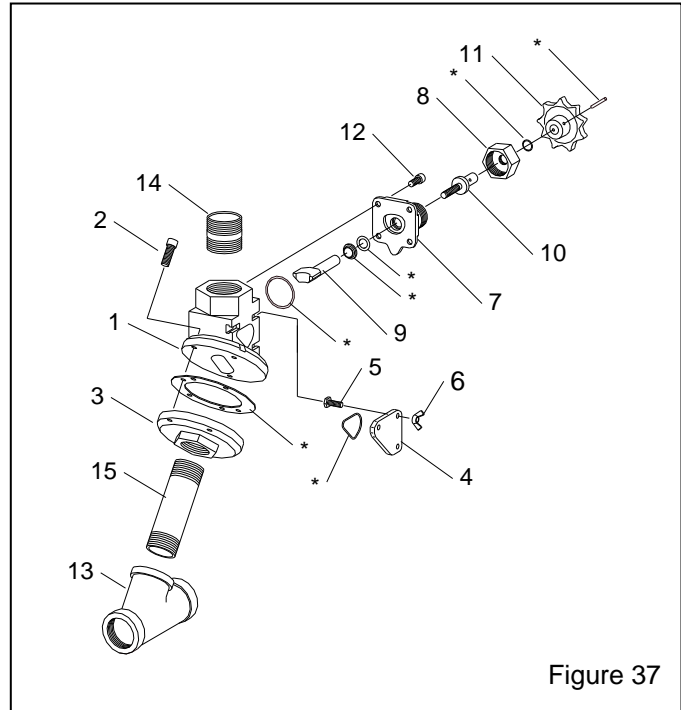


Figure 37

**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

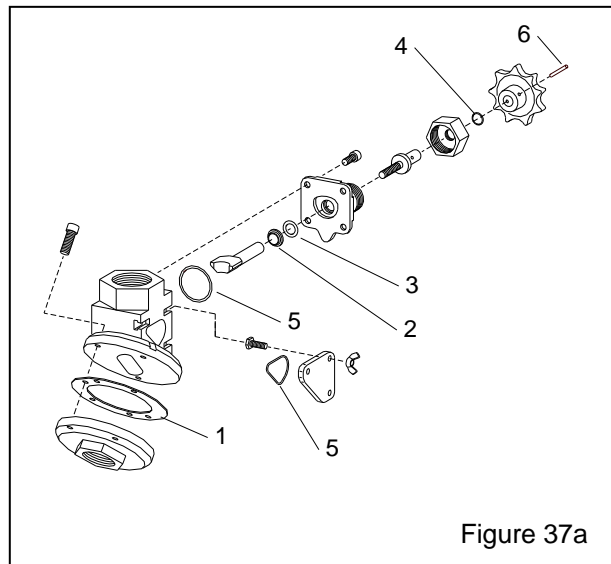


Figure 37a

**8.5 Millennium Valve Service Kit** .....22899  
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 38**

Item	Description	Stock No.
*	Service kit, Millen'm inlet seals (Fig 38a).....	22856
**	Service kit, Millen'm plunger tip (Fig 38b)....	22898
(-)	Millennium valve, inlet segment .....	21730
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 x M-JIC .....	02494
16.	Plug, 1-1/4" NPT .....	01762
17.	Plate, remote outlet adaptor .....	23597
18.	Gasket, adaptor plate .....	23261
19.	Screw, 5/16-NC x 1-1/4 hex-head .....	19509
20.	Washer, 5/16" lock .....	03217
21.	Nut, 5/16-NC hex .....	03211

**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

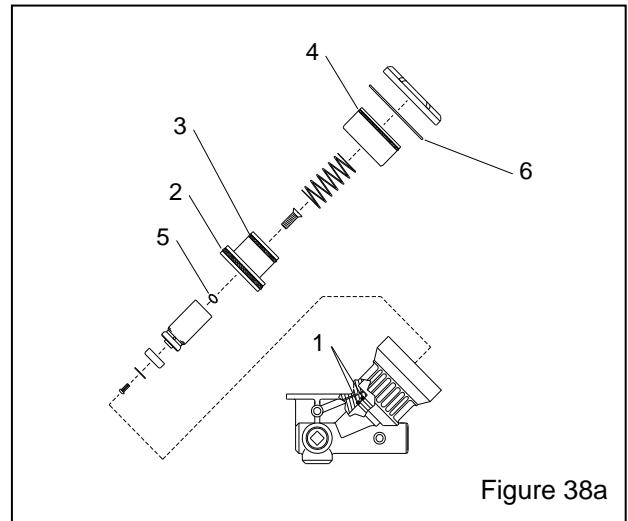
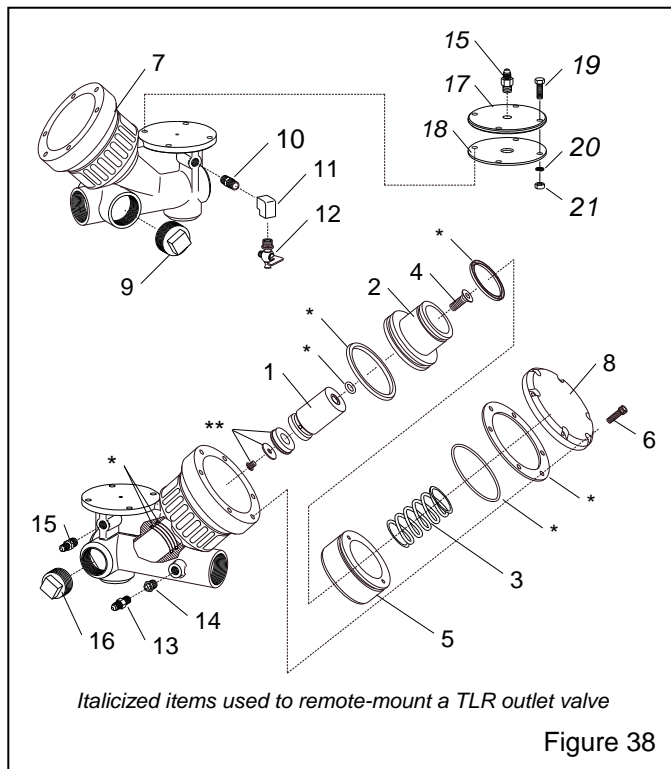


Figure 38a



*Italicized items used to remote-mount a TLR outlet valve*

Figure 38

**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

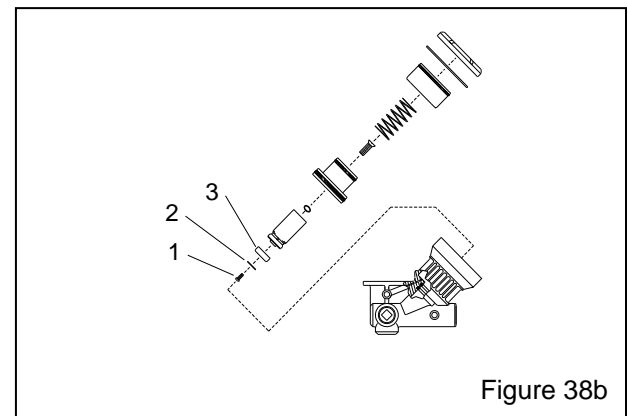


Figure 38b

**8.7 Millennium Valve Outlet Segment, Figure 39**

Item	Description	Stock No.
*	Service kit, outlet segment (Fig. 39a) .....	22857
**	Service kit, muffler (Fig. 39b) .....	22868
(-)	Millennium valve, outlet segment .....	21731
1.	Sleeve, inner .....	22612
2.	Piston .....	22613
3.	Housing, muffler, set of two halves .....	25988
4.	Valve body, exhaust .....	21345

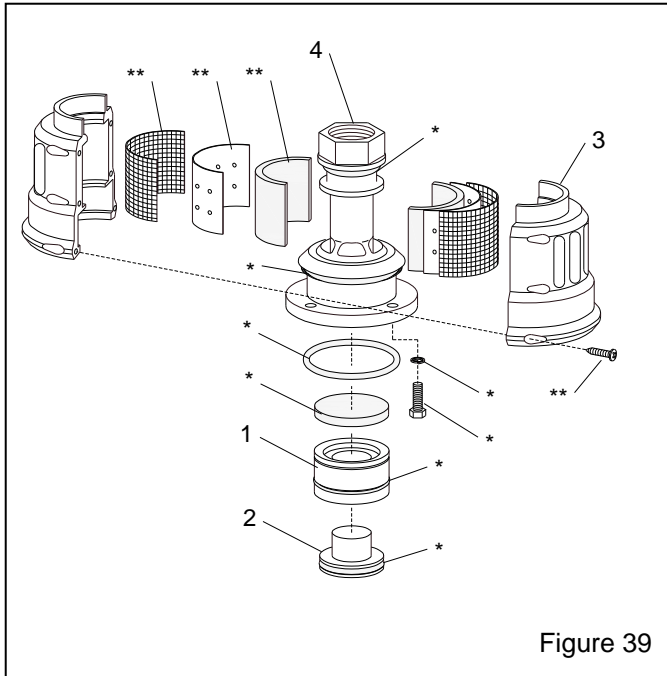


Figure 39

**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"

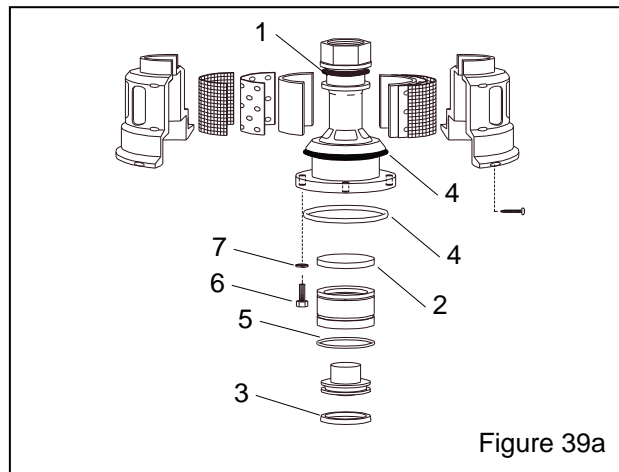


Figure 39a

**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"

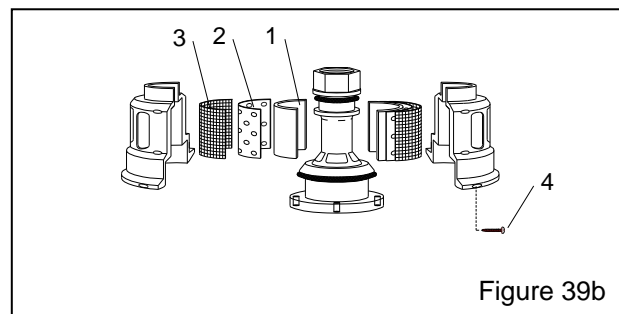
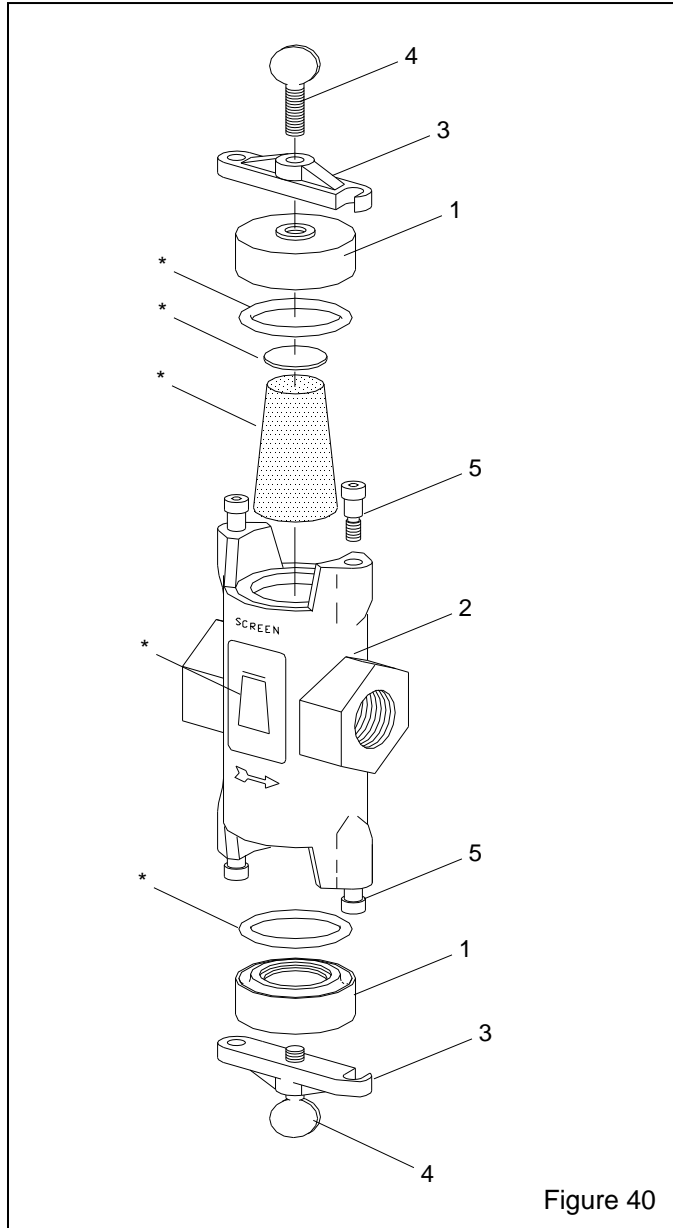


Figure 39b

**8.8 Abrasive Trap, Figure 40**

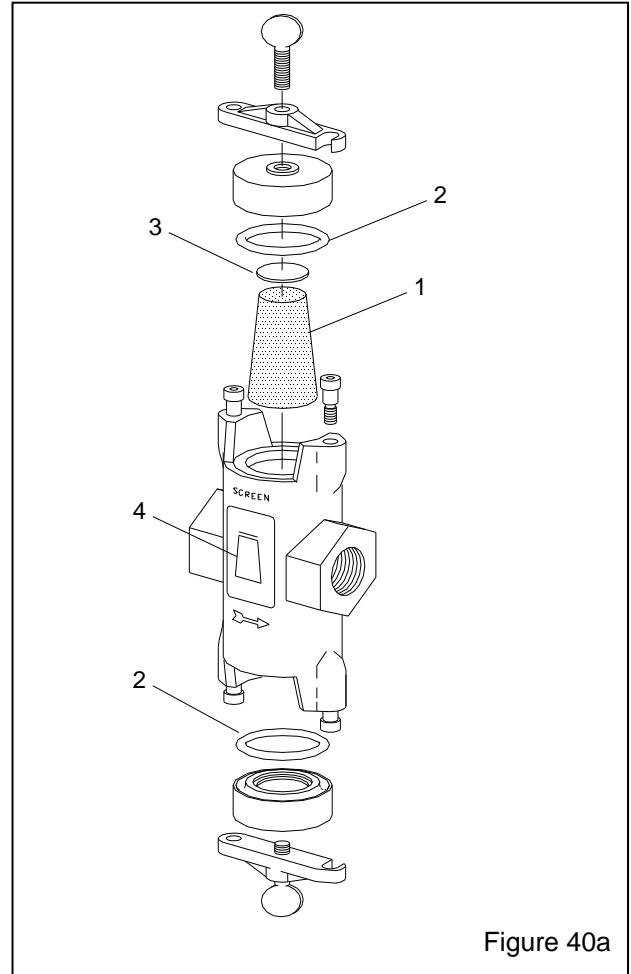
Item	Description	Stock No.
(-)	Abrasive trap .....	02011
*	Service kit, abrasive trap (Fig. 40a) .....	01925
1.	Cap .....	02014
2.	Body .....	02015
3.	Lock bar .....	02016
4.	Screw, 3/8-NC x 1" thumb .....	03289
5.	Shoulder screw, 3/8" x 3/8" .....	03291



**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 Pneumatic Control Handle, Figure 41**

Item	Description	Stock No.
(-)	RLX Control Handle Assembly .....	10565
*	Service kit, Pneumatic RLX (Fig. 41a) .....	22859
1.	Handle lever .....	10573
2.	Body .....	10568
3.	Pneumatic adaptor .....	10562
4.	Adaptor, 1/8" NPT x M-JIC (2 required) .....	01940
5.	Tie, nylon .....	02195

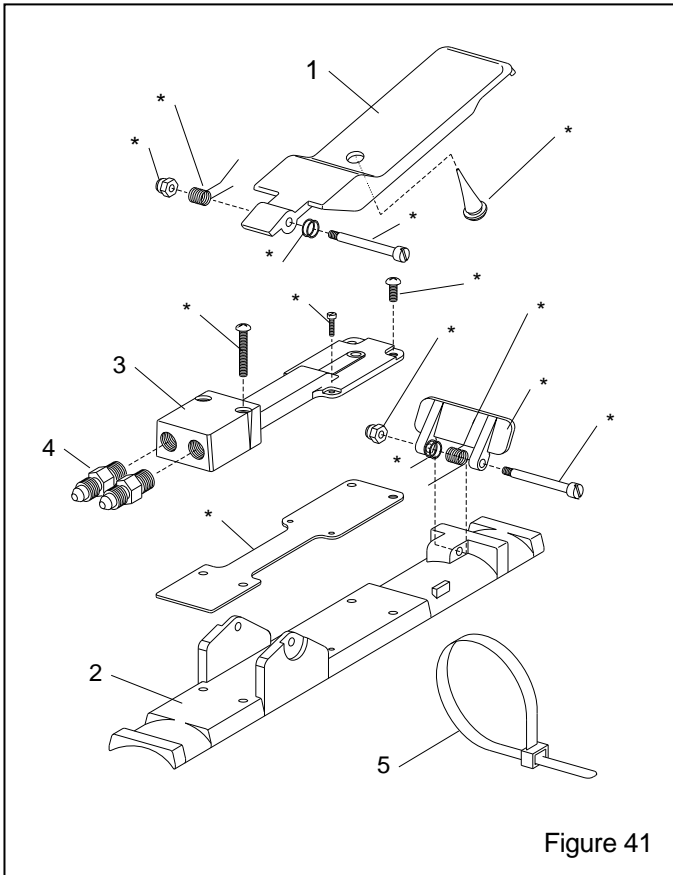


Figure 41

**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"

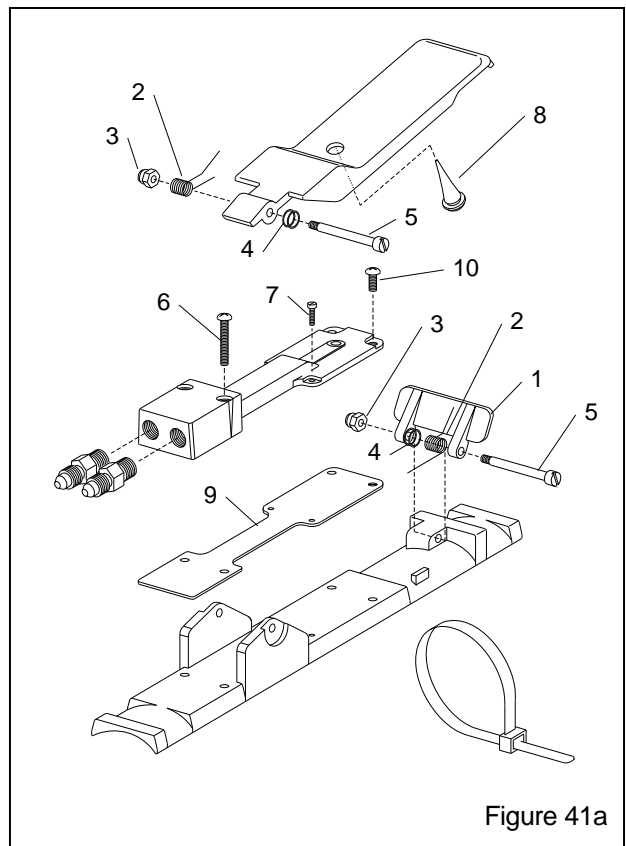


Figure 41a