

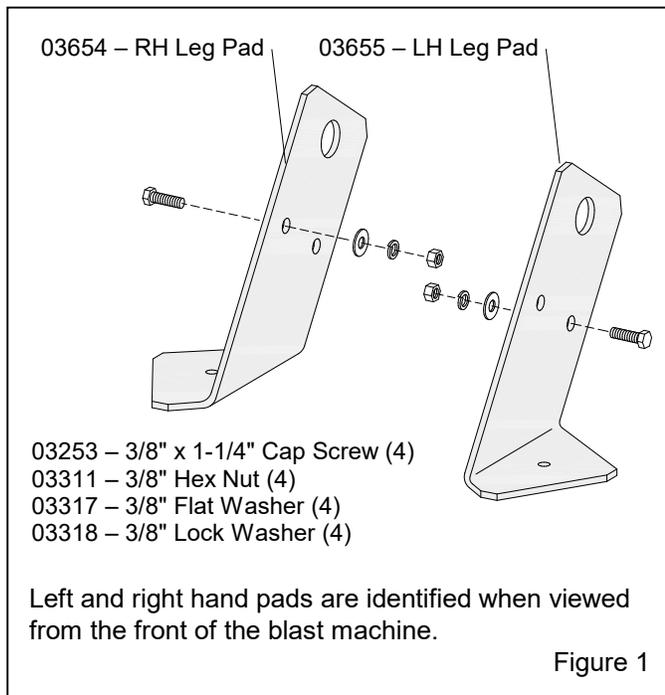


CONVERSION INSTRUCTIONS PORTABLE BLAST MACHINES TO STATIONARY BLAST MACHINES

1.0 INTRODUCTION

1.1 These instructions cover the conversion of classic-style Clemco portable blast machines to stationary blast machines. The style of leg pads shown in the illustrations represent the current style used on 3-cuft, 6-cuft, and 8-cuft blast machine. The style pads and method of removing wheels may be slightly different for earlier models, but the process is essentially the same. Time can be saved by reviewing the complete process before removing the wheels and attaching the leg pads.

1.2 The components in the 30073 conversion kit are shown in Figure 1. Pads and fasteners for older machine and other models are not offered as kits; pads and fasteners are ordered separately.



1.3 These instructions explain how to remove the wheels and attach leg pads one side at a time, which is the easiest method if lift equipment is not available. If appropriate rigging or blocks are available, lift both sides and block the axle pipe only enough to spin both wheels freely.

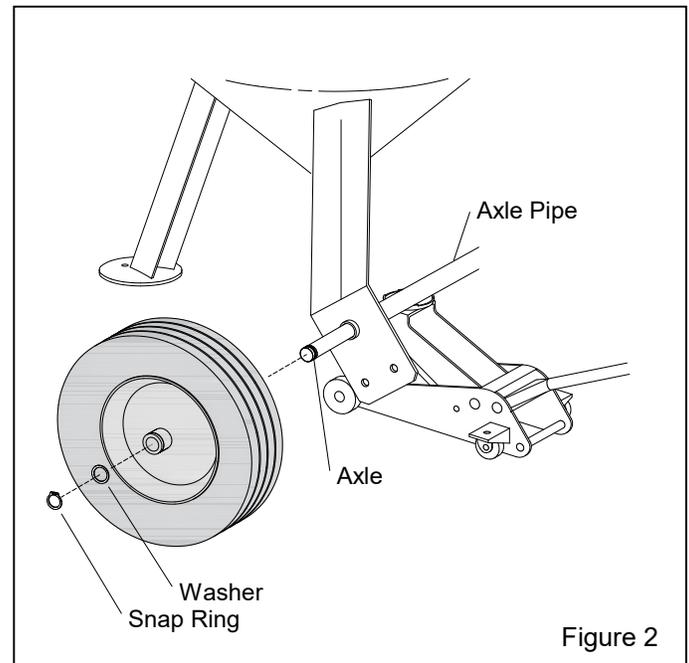
2.0 Remove Wheel from Blast Machine – Figure 2

⚠ WARNING

To avoid injury from the sudden release of trapped compressed air, lockout and tagout the air supply line and depressurize the air line.

NOTE: If the blast machine's air-supply line is hard piped, it may be necessary to loosen some connections before raising the blast machine.

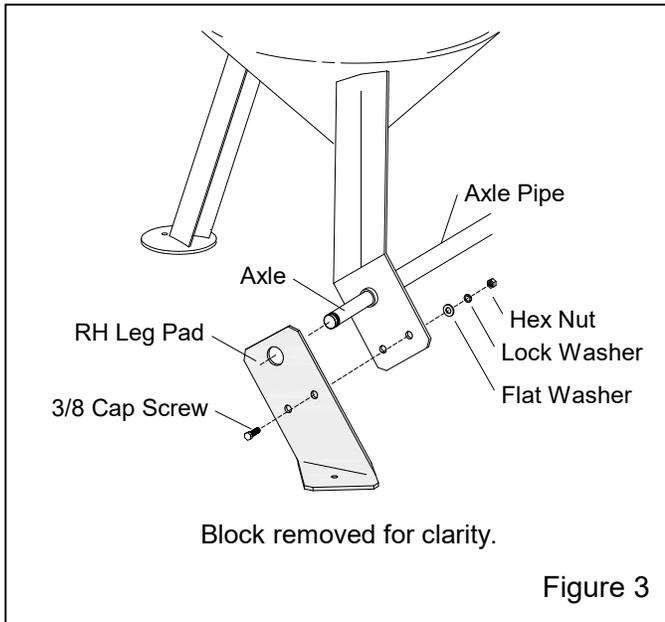
2.1 Use a jack or tilt the blast machine enough to place blocks, as shown in Figure 4, under one side of the axle pipe, lifting the blast machine only enough for the wheel to spin freely.



2.3 Remove the snap ring and washer, and then slide the wheel off the axle.

3.0 Attach Leg Pad onto Blast Machine – Figure 3

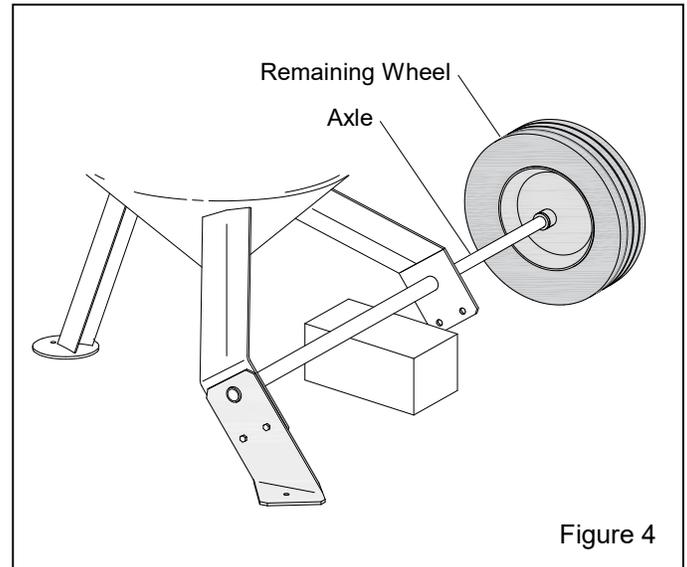
3.1 Attach the leg pads so the break (flat of the pad) is facing toward the outward side of the leg, as shown in Figure 3. Slide the pad over the axle and set it so the upper hole fits over the short protrusion of the axle pipe and against the leg. Slide a 3/8" cap screw through each hole in the pad and leg, as shown in Figure 3, and install flat washers, lock washers and hex nuts on the inward side to secure the pad.



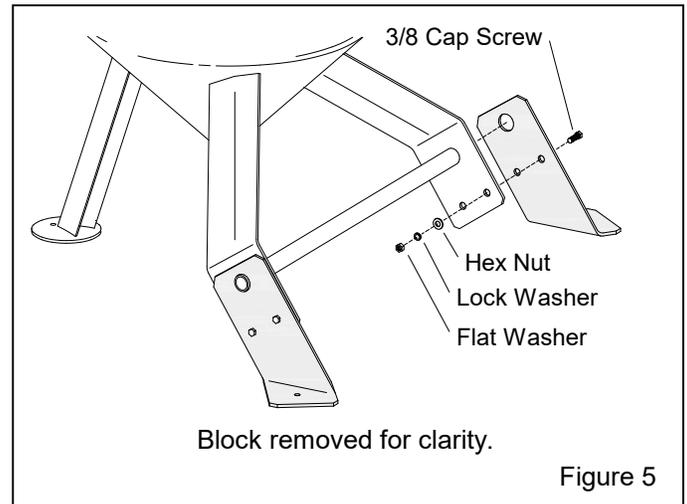
4.0 Remove Other Wheel and Attach Second Pad

4.1 Remove the jack or block from under the axle pipe and place it under the axle by the other leg, raising the wheel high enough so the wheel spins freely.

4.2 Slide the remaining wheel and axle from the axle pipe, as shown in Figure 4.



4.3 Attach the leg pads so the break (flat of the pad) is facing toward the outward side of the leg, as shown in Figure 5. Slide the pad over the axle and set it so the upper hole fits over the short protrusion of the axle pipe and against the leg. Slide a 3/8" cap screw through each hole in the pad and leg, as shown in Figure 5, and install flat washers, lock washers and hex nuts on the inward side to secure pad.



4.4 Remove the block. Holes in the pads and front leg are to anchor the blast machine to the floor for stability.