



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

**DATE OF ISSUE: 04/98  
REVISION: F, 07/13**

** WARNING**

**Do not proceed with these instructions until you have READ the orange cover of this MANUAL and YOU UNDERSTAND its contents. \***

**These WARNINGS are included for the health and safety of the operator and those in the immediate vicinity.**

**\*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.

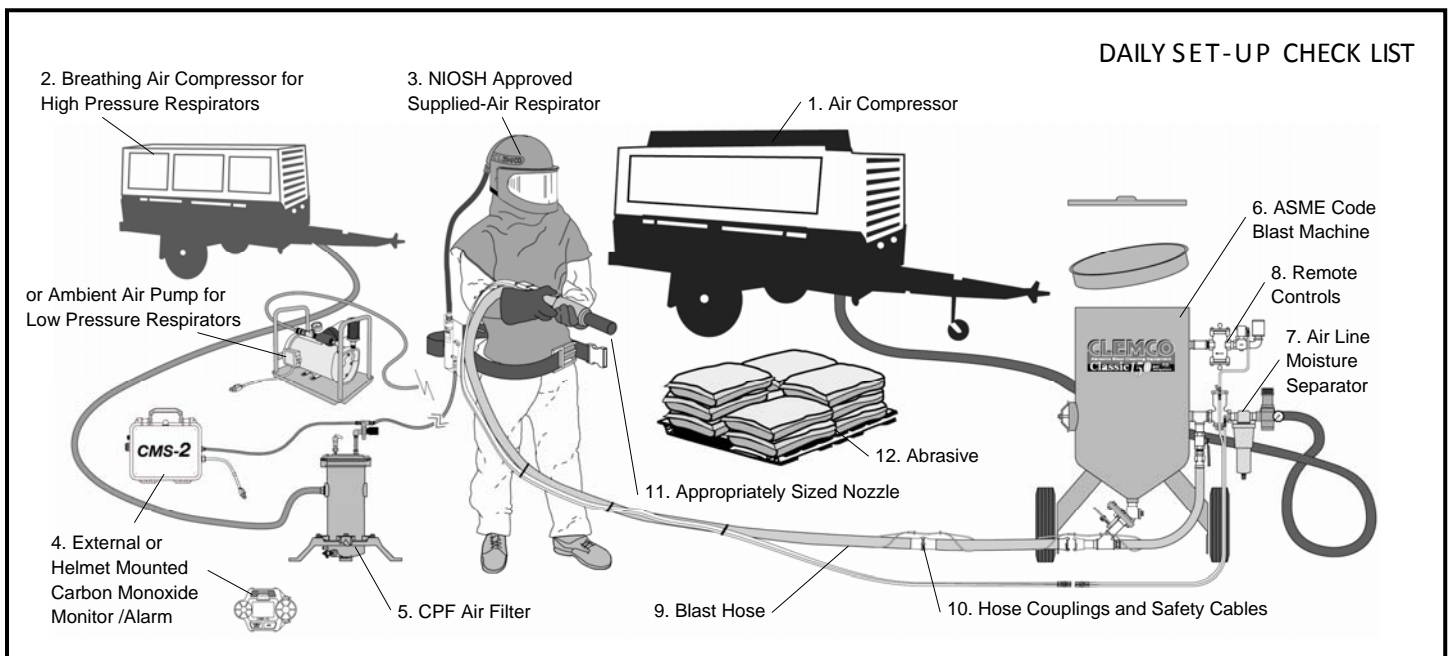
## *WARRANTY*

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



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

1.1.2 These instructions 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, and contains important safety information about abrasive blasting that may not be included in equipment operation manuals. To order additional copies, visit [www.clemcoindustries.com](http://www.clemcoindustries.com) or email [info@clemcoindustries.com](mailto:info@clemcoindustries.com).

### 1.2 Safety Alerts

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



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

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

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## CAUTION

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

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## ⚠ CAUTION

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

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## ⚠ WARNING

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

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## ⚠ DANGER

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

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### 1.3 Components and Operating Principles

#### 1.3.1 Components

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

#### 1.3.2 Instruction Maintenance Manuals

1.3.2.1 Individual manuals are included with optional accessories: Manuals provided with 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 start-up and adjustments are completed, remove the urethane cover plate and store manuals in the compartment, for future reference.

#### 1.3.3 Blast Machine

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

**⚠ WARNING**

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

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

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

**⚠ WARNING**

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

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

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

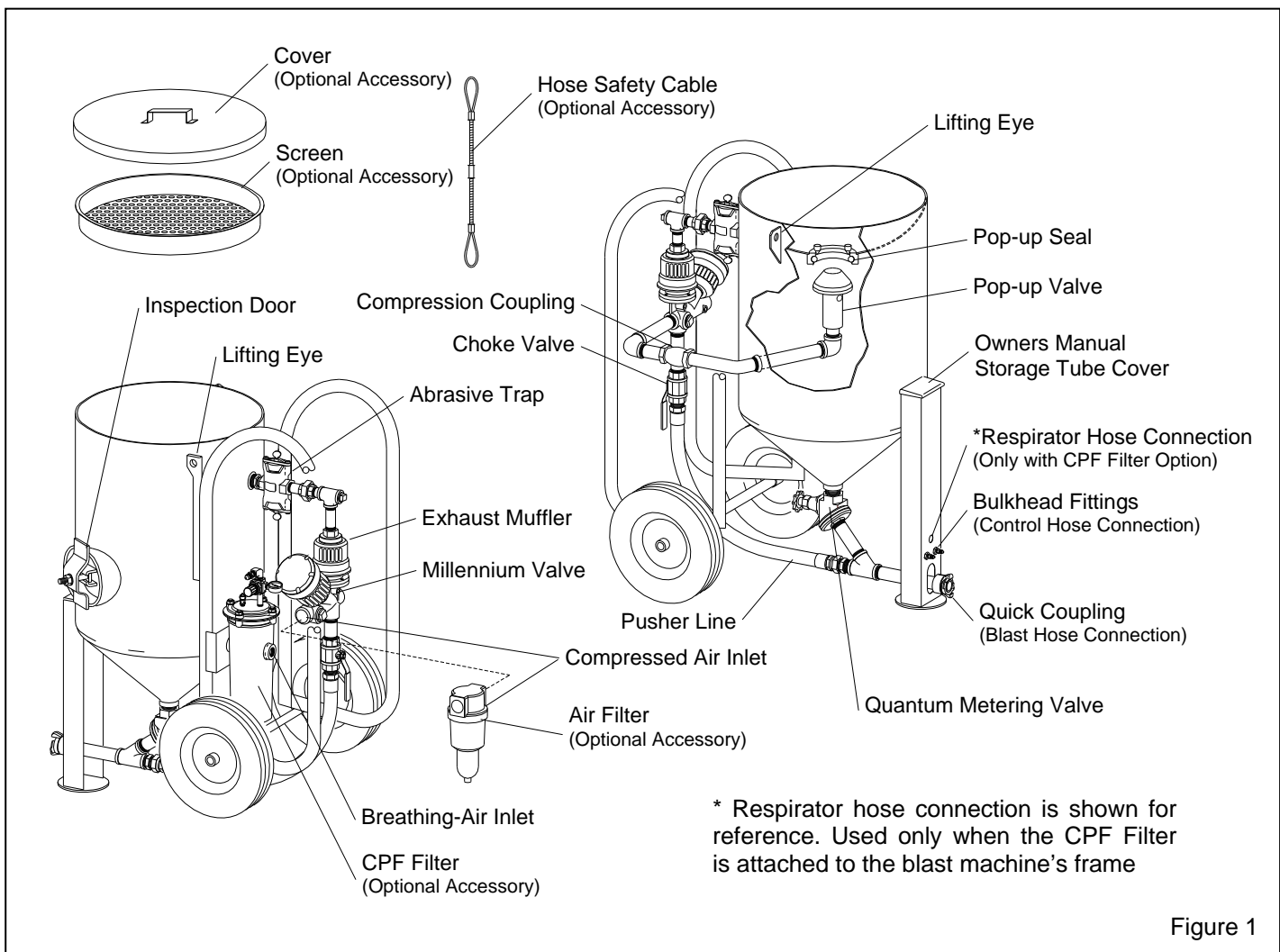


Figure 1

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

<sup>(1)</sup> American Society of Mechanical Engineers, Boiler and Pressure Vessel Code, 1989

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

### 1.3.4 Remote Controls

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

**1.3.4.2** The remote control system is an OSHA-required safety device. The control handle, located near the blast nozzle, is the activator for the remote control system. When the operator intentionally or unintentionally removes hand-held pressure from the remote control handle, the machine depressurizes, stopping air and abrasive flow through the nozzle. The remote control system "fails to safe", which means when any 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 controls deactivate the blast machine.

## **⚠ WARNING**

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

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

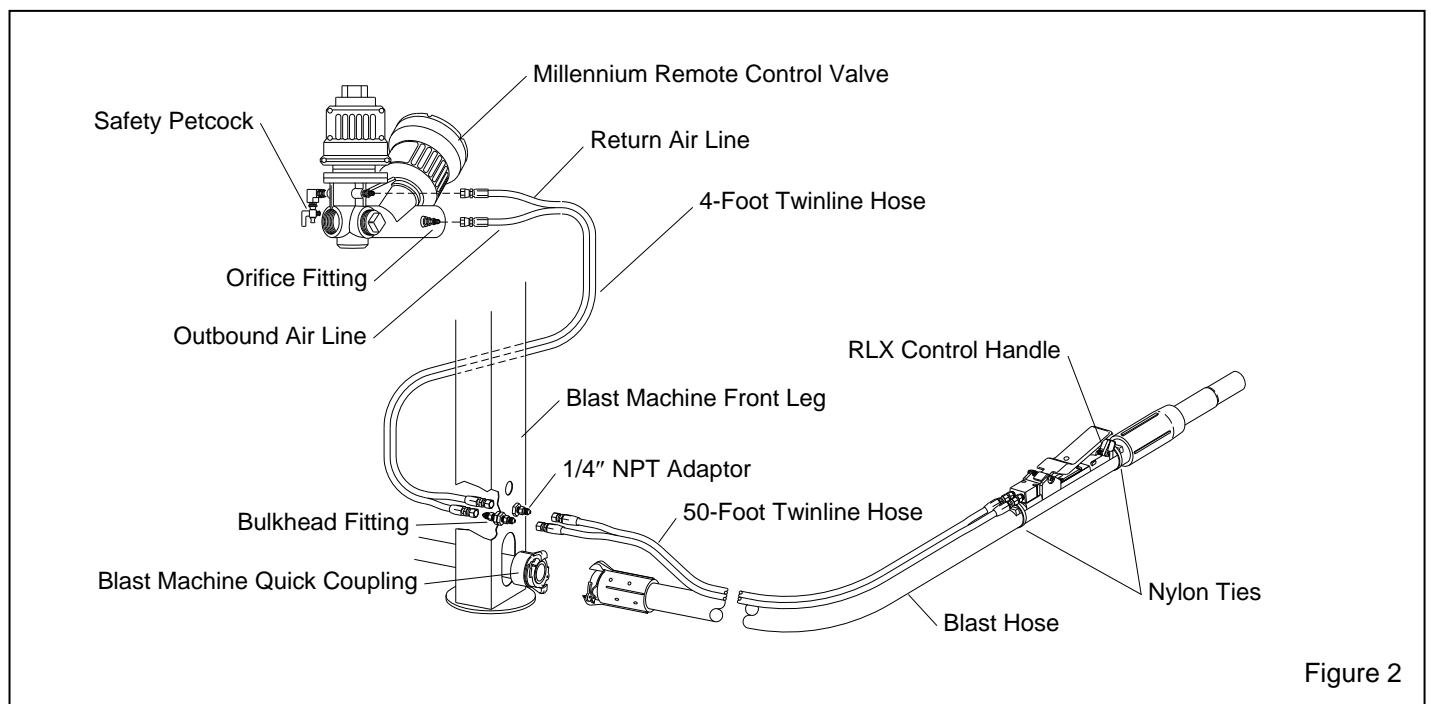


Figure 2



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

### 1.3.5 Electric Remote Control Option

**1.3.5.1** Electric remote controls (electro-pneumatic) are recommended when the nozzle and remote control handle are farther than 100 feet from the blast machine. Pressure drop of pneumatic systems over longer distances increases actuation time, which prevents fast, safe operation. Contact your local Clemco Distributor for 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 by use of a manual drain located at the bottom of the filter.

### 1.3.7 Frame and Cart

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

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## 1.4 Abrasive

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### WARNING

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

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

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

**1.4.2 Abrasive Size:** The choice of abrasive size depends on the desired profile, cleaning rate, nozzle size and availability of clean dry air. Generally, larger and denser abrasive provide a deeper profile, while smaller abrasives clean faster. Most abrasive blasting is done with abrasive between 16 and 80 mesh. Larger sizes may be used if the nozzle orifice is large enough to prevent particles to pass without jamming. Finer abrasive is 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 abrasive containing free silica.

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

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

**1.4.6 Silicon Carbide, Aluminum Oxide, and Garnet:** These are the most aggressive, high volume abrasives in the blasting industry. Aggressive abrasives such as these 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 the Sentinel or Auto-Quantum, to prevent surging at startup.

**1.4.8 Lightweight Abrasive:** Occasionally, plastic media, and most agricultural media may be used in a standard blast machine. Exclusive use of plastic, or other lightweight media, requires a blast machine with a 60° conical bottom.

## 2.0 INITIAL SET-UP

### **⚠ WARNING**

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

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

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

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

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

### **⚠ WARNING**

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

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

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

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

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

### 2.2 Set up for multiple blast machines operating from a common compressed air supply

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

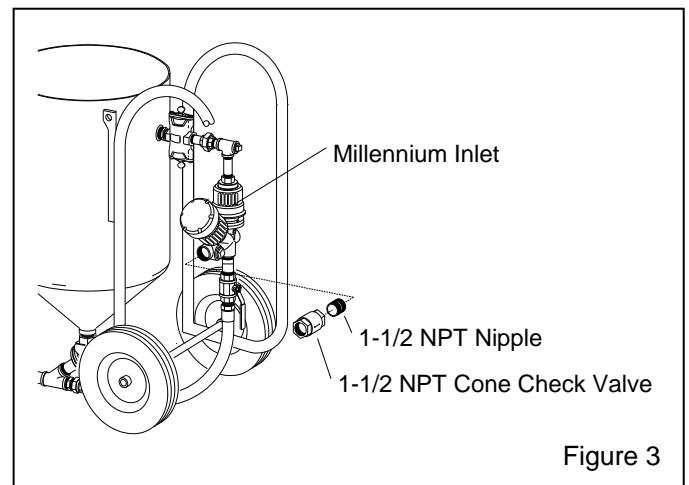


Figure 3

### **⚠ CAUTION**

**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 could reverse air from the machine that is under pressure, and could contaminate the compressed air supply with abrasive laden air. Install check valves at the piping inlet to prevent the reversal of air.**

**2.2.2** 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. Do not use a swing check valve, which may break in blast machine applications. When installing the valve, make sure the directional arrow is pointing in the direction of the air flow, toward the machine.

**2.3 Compressed-Air Supply Hose Connection**

**2.3.1** Install an air supply hose fitting to the Millennium valve inlet or optional compressed air filter, that is compatible with the compressed-air supply hose from the compressor. For best blasting performance, use 1-1/4" ID or larger air line when using up to a 5/16" orifice nozzle, 1-1/2" or larger when using up to a 3/8" nozzle, and 2" or larger when using up to a 1/2" nozzle. Refer to the compressed air and abrasive consumption chart in Figure 4 for approximate air consumption.

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 4

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**2.4 Breathing Air Connections, Optional CPF Filter, Refer to CPF Owner's Manual 04143**

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** DANGER**

**Do not connect the CPF 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 the CPF Filter to explode under the high pressure of bottled air. A rupture of this nature could cause severe injury or death.**

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---

** 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.**

---

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

**2.4.2** Connect an air supply hose fitting that is compatible with the air supply hose from an air source that meets OSHA requirements for respirable air, to the CPF Filter inlet, as shown in Figure 1. Pressure supplied to the filter must not exceed 150 psi.

**2.4.3** For models with CPF filter attached, connect the 5-foot respirator lead hose to the fitting at the top of the CPF filter and the compatible fitting on the front leg of the blast machine. Refer to Figure 1 for fitting location.

**2.4.4** 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**

**3.1.1 Transporting a blast machine**

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

---

** WARNING**

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

**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 could cause the operator to slip or lose balance. Sudden weight shifts when the machine is tilted on an incline, and slipping or tripping while moving the machine will cause the operator to lose control of the machine, causing severe injury and property damage.**

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** WARNING**

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

---

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

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

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

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

## 3.2 Start-Up

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

**3.2.2** Connect an air line from the compressor to the air supply hose connector installed on the blast machine inlet.

**3.2.3** Make sure the coupling gaskets are in place and in good condition before connecting the blast hose to the quick coupling on the blast machine. When connecting the hose, make sure the coupling spring lock pins are at 180 degrees from one another (Pins should enter the open hole of the adjoining coupling). The spring lock pins prevent accidental separation of hose couplings during blasting.

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

### **⚠ WARNING**

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

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

**3.2.6** Connect an air line between a source of respirable breathing air meeting the requirements for Grade D or higher quality, and the CPF filter inlet. See Section 2.4. The maximum inlet pressure for the CPF Filter must not exceed 150 psi.

### **⚠ DANGER**

**Do not connect the CPF 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 the CPF Filter to explode under the high pressure of bottled air. A rupture of this nature could cause severe injury or death.**

### **⚠ WARNING**

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

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

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

**3.2.9** Close the Quantum abrasive metering valve. Closed position is when the knob has been turned fully clockwise. Refer to Section 4.1.

**3.2.10** Open the safety petcock on the inlet section of the Millennium valve. It is open when the lever is in-line with the petcock, as shown in Figure 5.

### **⚠ WARNING**

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

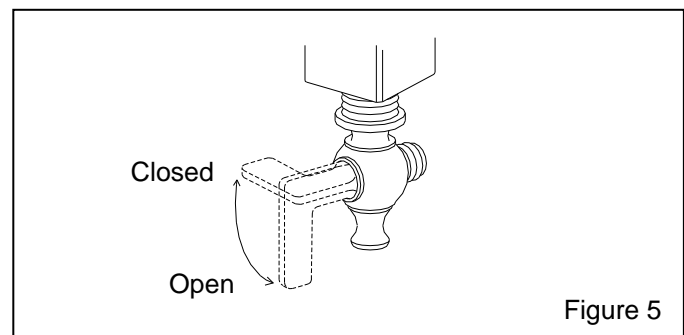


Figure 5



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

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

---

 **WARNING**

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

---

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

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

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

**3.2.16** Load abrasive into the machine according to the instructions in Section 3.6.

**3.2.17** Do not allow anyone around the blast machine except machine tenders, who are appropriately attired in approved personal protective equipment.

---

 **WARNING**

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**All persons, except for the blast machine tender, must stay clear of the blast machine, because the machine tender or blast operator may pressurize or depressurize the machine at any time. These actions may vent abrasive under pressure and cause dust and toxins to become airborne. The sudden release of compressed air generates noise when the machine is pressurized or depressurized. Either condition could result in injury. The machine tender must wear suitable personal protective equipment including an approved respirator, plus approved eye, face, and hearing protection.**

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

### **3.3 Blasting Attire**

**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.

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 **WARNING**

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

**No dust is safe to breathe. Abrasive blasting produces harmful dust. Failure to wear approved respirators could result in serious lung disease or death. Blast operators must wear properly-fitted and maintained NIOSH-approved, type-CE supplied-air respirators approved for abrasive blasting.**

**During abrasive blasting, abrasive particles and dust in the area around the blast machine and blast nozzle become airborne. Everyone working in the vicinity of abrasive blasting must wear properly-maintained, NIOSH-approved, respiratory protection and eye protection appropriate for the job site hazards.**

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

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### 3.4 Blasting

3.4.1 Don all protective, blasting attire per Section 3.3.

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

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

---

### CAUTION

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

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### 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 could result from uncontrolled blasting. Ref. 29 CFR 1910.244 (b).**

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3.4.4 Adjust abrasive flow per Section 4.1.

### 3.5 Stop Blasting

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

3.5.2 When the control handle lever is released, the 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.

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

3.5.4 When finished blasting, shutdown per Section 3.8.

---

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

---

3.6.1 Load abrasive by pouring it into the concave head. Use a screen (screen comes with blast machine packages) placed over the head to prevent objects from falling inside. Foreign objects will jam the machine. Abrasive flows through the filling port into the machine. Keep the abrasive level below the pop-up valve to prevent abrasive above the pop-up valve from being forced up and out of the machine when it pressurizes.

3.6.2 When the 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.

3.6.3 Begin blasting or resume blasting per Section 3.4.

### 3.7 Emptying the Machine of Abrasive

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

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

3.7.3 To prevent wear of the nozzle holder threads, the nozzle should be firmly attached to the nozzle holder. Removing the nozzle is discouraged. If

circumstances require the nozzle to be removed, also remove the nozzle washer. Purging the machine without a nozzle in place will erode the thread area of the nozzle holder, which could cause a hazardous condition.

## **⚠ 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 could 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. Worn nozzle washers could cause nozzle thread erosion.**

**3.7.4** Point the nozzle into a drum or suitable container, or in the direction of the abrasive disposal site.

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

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

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

## **3.8 Shutdown**

**3.8.1** Empty the blast machine per Section 3.7.

**3.8.2** When finished blasting, and after cleanup is completed, remove the respirator outside the respirator-use area where the air is safe to breathe.

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

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

**3.8.5** Shutdown the compressor.

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

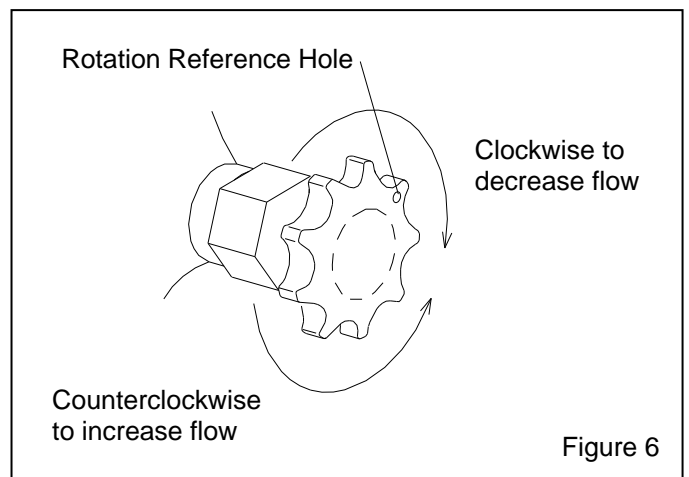
## **4.0 ADJUSTMENTS**

### **4.1 Abrasive Metering, Figure 6**

**4.1.1** Adjust abrasive flow by turning the knob on the metering valve located at the bottom of the blast machine.

**4.1.2** Use the hole in the knob as a reference to monitor its rotation; counting turns enables resetting the abrasive flow to the original adjustment, should temporary changes be required.

**4.1.3** The valve is closed when the knob has been 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 the correct flow is attained.



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

---

## 5.0 PREVENTIVE MAINTENANCE

### 5.1 Daily Inspection

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

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

---

### WARNING

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

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

---

### WARNING

**The threads on the nozzle and nozzle holder must be inspected each time the nozzle is secured to the holder. A loose-fitting nozzle may eject under pressure and could 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. Worn nozzle washers could cause nozzle thread erosion.**

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

---

### WARNING

**Malfunctioning control handles could cause unintentional actuation of a blast machine, or prevent a machine from deactivating upon release. Malfunctioning control handles must be taken out of service immediately and 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, or pipe fittings at the bottom of the cone, stop blasting immediately and repair or replace worn parts. If leaks are allowed to continue, abrasive erosion could cause irreparable damage to the blast machine.
- Check all external piping, control hoses, and valves for leaks. If leaks are found, stop blasting and repair.
- Inspect blast hose, couplings, and nozzle holders for leaks. At the first sign of a leak, stop blasting and inspect all items for wear.

---

### WARNING

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

### 5.2 Weekly Inspection

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

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

5.2.2 During blasting do the following:

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

---

### 5.3 Monthly Inspection

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

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

### 5.4 Periodic Inspection

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

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

---

## 6.0 SERVICE MAINTENANCE

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### WARNING

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

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

---

### 6.1 Removing Damp Abrasive From the Blast Machine.

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

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

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

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

---

### WARNING

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

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

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

---

### WARNING

**The threads on the nozzle and nozzle holder must be inspected each time the nozzle is secured to the holder. A loose-fitting nozzle may eject under pressure and could 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. Worn nozzle washers could cause nozzle thread erosion.**

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

---

### 6.2 Clearing Obstructions in the Abrasive Metering Valve and Blast Machine.

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

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

6.2.3 Remove the wing nuts securing the abrasive metering valve's cleanout cover.



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

**6.2.5** If the metering valve is clear, remove the blast machine inspection door, and check 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 are secure before starting the air supply.

**6.3 Millennium Valve Inlet Segment, Ref. Figure 7.**

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

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

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

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

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

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

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

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

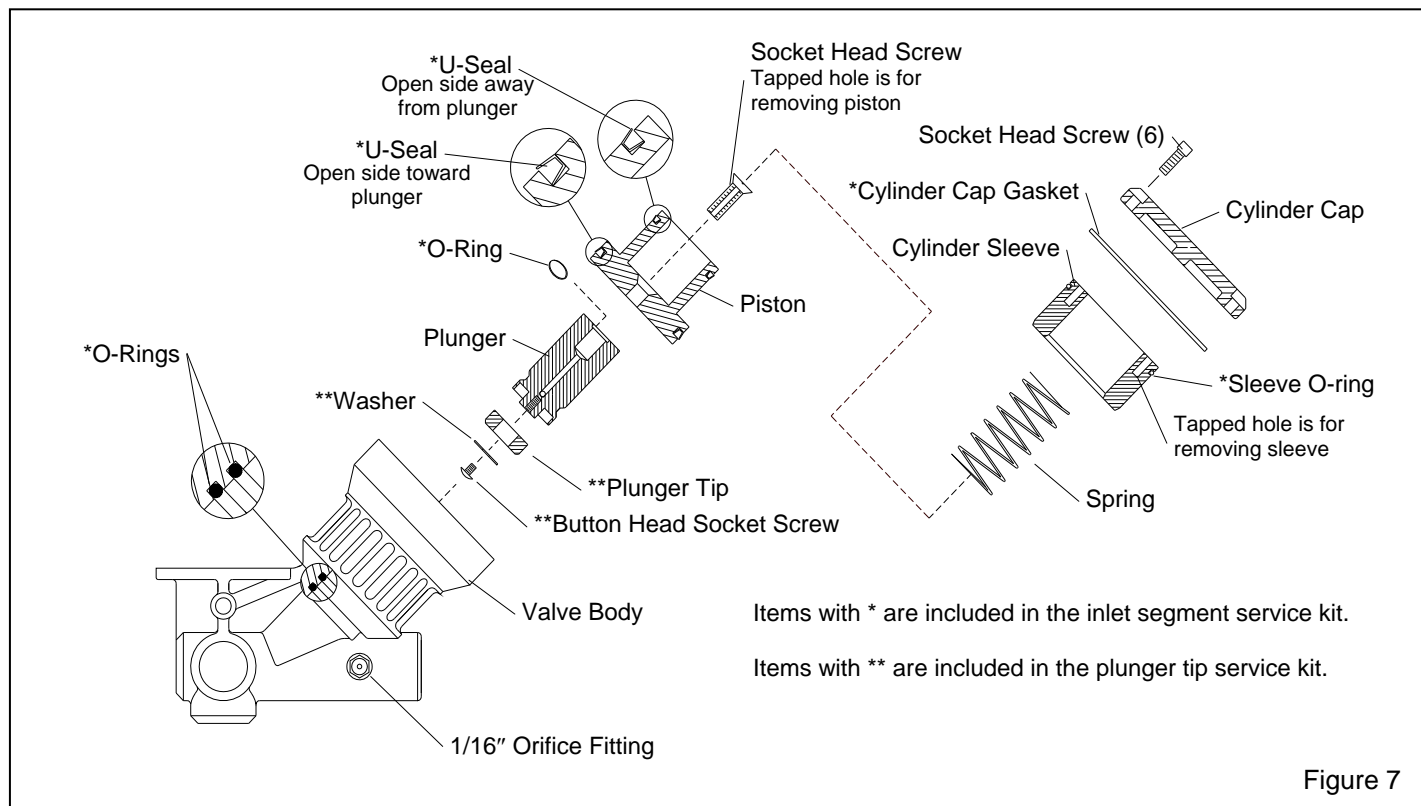


Figure 7

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

**6.3.8** Lubricate o-rings and u-seals with a silicone-based lubricant.

**6.3.9** Replace both o-rings in the valve body.

**6.3.10** Place the u-seals into the grooves on the piston, the open side of the large seal faces the plunger, and the open side of the small one faces away from the plunger, as shown in Figure 7.

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

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

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

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

**6.3.15** If fittings on the body were removed, make sure the 1/16" orifice fitting is threaded into the port as shown in Figure 7.

**6.4 Millennium Valve Outlet Segment,  
Ref. Figure 8**

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

**6.4.1** Loosen the exhaust piping union nut.

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

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

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

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

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

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

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

**6.4.8** Lubricate the u-seal with a silicone-based lubricant, and place the u-seal into the groove in the piston. The open side of the seal must face the bottom of the piston, as shown in Figure 8.

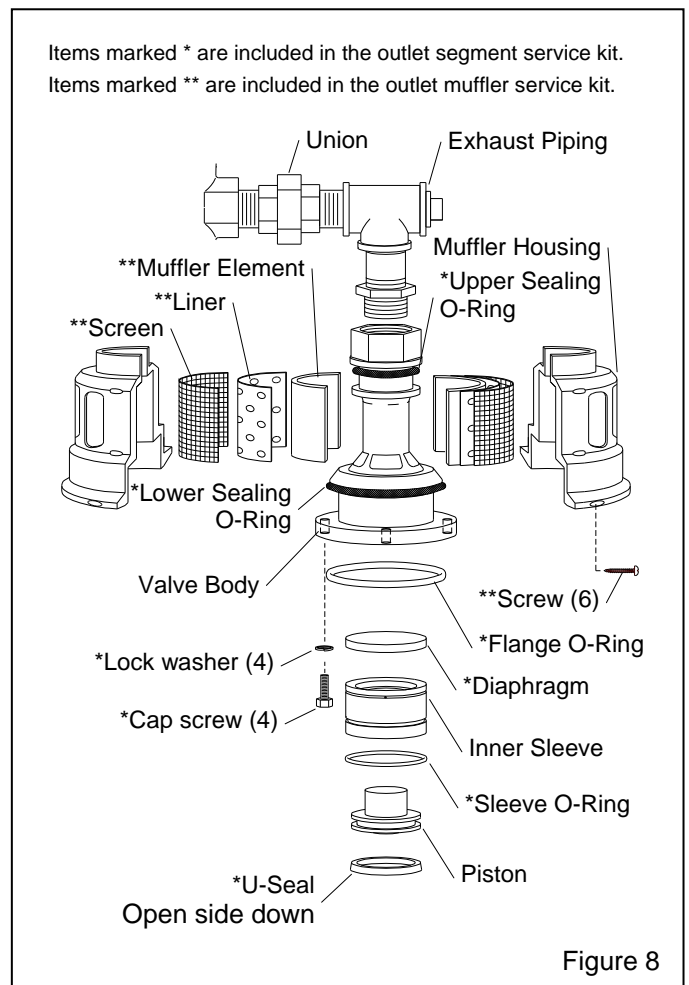


Figure 8

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

**6.4.10** Insert the piston into the sleeve.

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

**6.4.12** Slide the piston and sleeve assembly into the valve body, the piston faces away from the bottom of the body, as shown in Figure 8.

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

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

## 6.5 Exhaust Muffler, Figure 8

**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 that prevents air from passing through the porous element. Replace the elements if blocked.

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

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

## 6.6 RLX Control Handle

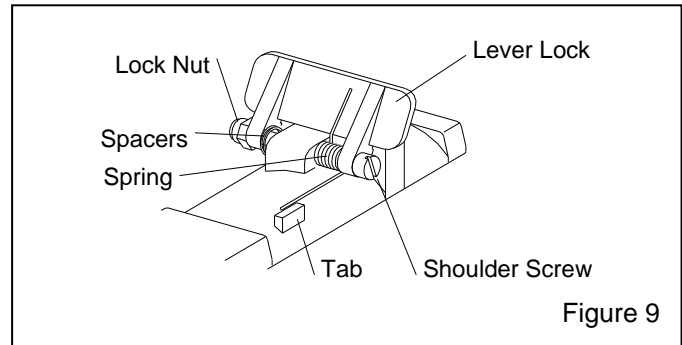
NOTE: A service kit is available for the RLX Control Handle. To avoid unscheduled down-time, a kit should be kept on-hand.

### 6.6.1 Spring replacement

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

### 6.6.2 Lever Lock replacement, Figure 9

**6.6.2.1** Remove the lock nut from the shoulder screw. Before removing the screw, note the positions of the spacers and spring, as shown in Figure 9. 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.

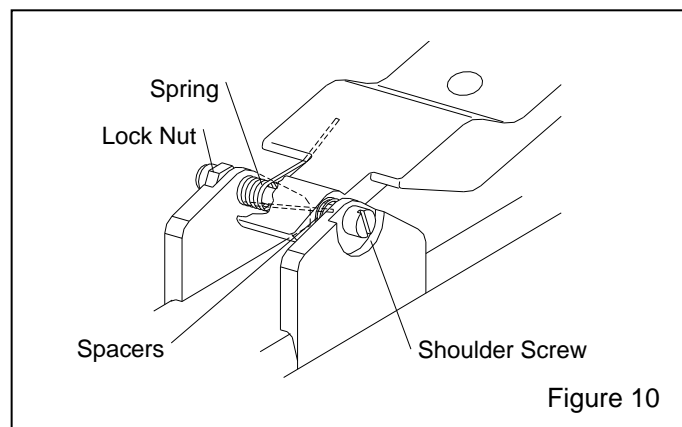


**6.6.2.2** Install a new lever lock and spring, and reassemble in reverse order.

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

### 6.6.3 Handle lever replacement, Figure 10

**6.6.3.1** Remove the lock nut from the shoulder screw. Before removing the screw, note the positions of the spacers and spring as shown in Figure 10. The bent end of the spring is against the handle lever, facing up. The straight end is against the body, facing down.



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

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

### 6.6.4 Rubber button replacement

6.6.4.1 Remove the old rubber button.

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

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

### 6.6.5 Gasket replacement

6.6.5.1 Remove the handle lever per Section 6.6.3.

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

6.6.5.3 Install a new gasket.

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

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

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

### 6.7 Quantum Manual Metering Valve, Figure 11

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.

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

6.7.2 Remove the cleanout cover wing nuts and cleanout cover.

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

6.7.4 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.

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

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

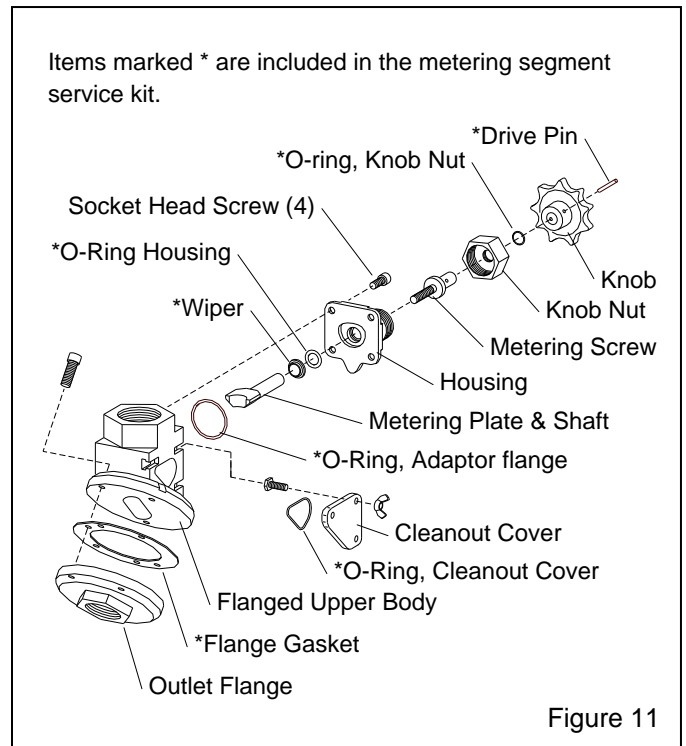
6.7.7 Use a drive pin and hammer to force the roll pin from the knob, and remove the knob.

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

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

6.7.10 Clean the 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, binding or metal filings.

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



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

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

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

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

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

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

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

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

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

**6.7.21** Place a new o-ring on the cleanout cover, and securely attach the cover.

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

## 6.8 Replacing the Pop-Up Valve, Figure 12

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

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

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

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

**6.8.5** Slide the new pop-up valve over the guide, and then screw the valve guide (with the pop-up valve on it) into position inside the machine. Tighten the guide, 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.

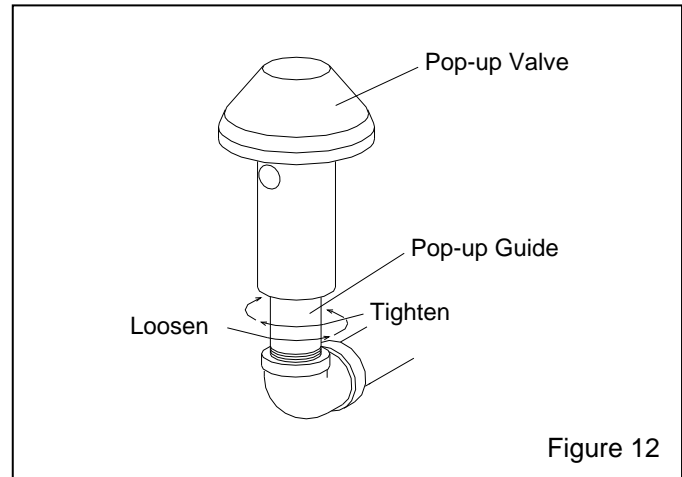


Figure 12

**6.8.6** Refer to Figure 13 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.

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

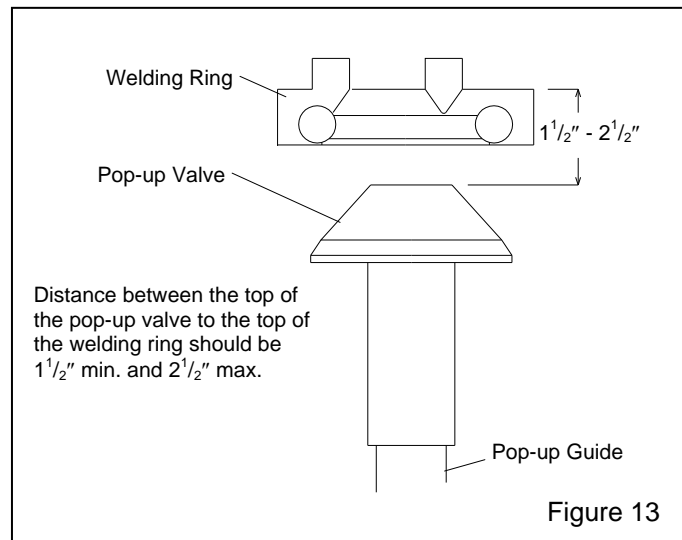


Figure 13



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## 6.9 Replacing the Pop-Up Seal

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

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

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

## 6.10 Abrasive Trap

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

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

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

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

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

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

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

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

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

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## 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.

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### WARNING

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

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

### 7.1 Neither Abrasive nor Air Comes Out of the Nozzle while the Machine is Under Pressure

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

**7.1.2** Make sure 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. Refer to Section 4.1.

**7.2.2** Blast machine may be empty.

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

**7.2.4** Check the abrasive metering valve for obstructions. 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 in-line with the piping.

**7.3.2** Abrasive metering valve may be open too far. Refer to 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 certain amount of abrasive surge is normal at start-up. Should the flow of abrasive continue to surge, reduce the amount of abrasive in the air stream by adjusting the metering valve. Refer to Section 4.1.

**7.4.2** Check the abrasive trap and exhaust muffler for blockage. Slow depressurization will load the blast hose with abrasive, and cause surging at start-up. 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 in-line 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 worn from recycling. Replace abrasive.

### 7.6 Blast Machine Does not Pressurize

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

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

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

**7.6.4** Check for air escaping through the opening under the control handle lever. If no air is escaping, the orifice on the inlet valve (shown in Figure 2) is blocked,

or the line from the orifice to the control handle is blocked and must be cleared.

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

**7.6.6** Check control lines and fittings for leaks or breaks.

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

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

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

**7.6.8** Close the safety petcock, and press the control handle lever. Verify that no air escapes through the vent hole on the cylinder body of the inlet valve body. Air escaping from this vent indicates worn seals in the inlet valve. Service the valve 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** Insufficient-size air supply hose or reduced-size fittings between the compressor and blast machine. Refer to Section 2.3.1.

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

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

### 7.7 Blast Machine Does not Depressurize or Depressurizes Too Slowly

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

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

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

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7.7.4 Check for blockage in the control hose.

7.7.5 Check the fitting on the inlet valve (shown in Figure 17, Item 13). It must have a 1/16" orifice.

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

## 7.8 Outlet Valve Does not Seal

7.8.1 Outlet valve diaphragm worn or outlet valve requires service. 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 Check the handle lever for damage that may cause binding against the body.

7.9.2 Check the spring for damage or fatigue.

7.9.3 Replace the handle lever or spring as necessary.

## 7.10 Lever Lock Fails to Pop Up When the Handle Is Released

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

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

7.10.3 Replace lever lock or spring as necessary.

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**8.0 ACCESSORIES AND REPLACEMENT PARTS**

**8.1 Accessories**

- (-) Cover, steel, for 16" blast machine .....02335
- (-) Cover, poly bag with Clemco logo for  
2 and 3 cu. ft. machines, medium ..... 15097
- (-) Screen, for 16" blast machine .....03099
- (-) Safety cable, 1-1/2" to 3" OD hose ..... 15013
- (-) Safety cable, 1-1/2" to 4" OD hose .....27405

**8.2 Blast Machine, Figure 14**

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

14.	Millennium valve	21336
15.*	Gasket, CFP coupling, package of 10	08853
16.	Wye, standard 1-1/4"	01818
17.	Internal pop-up guide, 1-1/4" x 6" toe	01753
18.	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.	CPF-20 Air filter, optional	03578
25.	Cartridge replacement, CPF filter	03547
26.*	Coupling, nylon, CQPS-1	21088
27.*	Nozzle holder, nylon, NHP-1	04106
28.*	Hose, 1" ID x 50 ft. Supa-T	23104
29.*	Nozzle, TMP-4	23520
30.*	Washer, nozzle, NW-25, pack of 10	91024
31.	Adaptor, 1-1/4" NPT x JIC	22529
32.**	Hose, 5-ft respirator extension, coupled.	24510
33.**	Fitting, 1/4" NPT bulkhead	05605
34.**	Adaptor, 1/4" NPT x 3/8" hose	01019

\* Models shown are supplied with original blast machine systems.

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

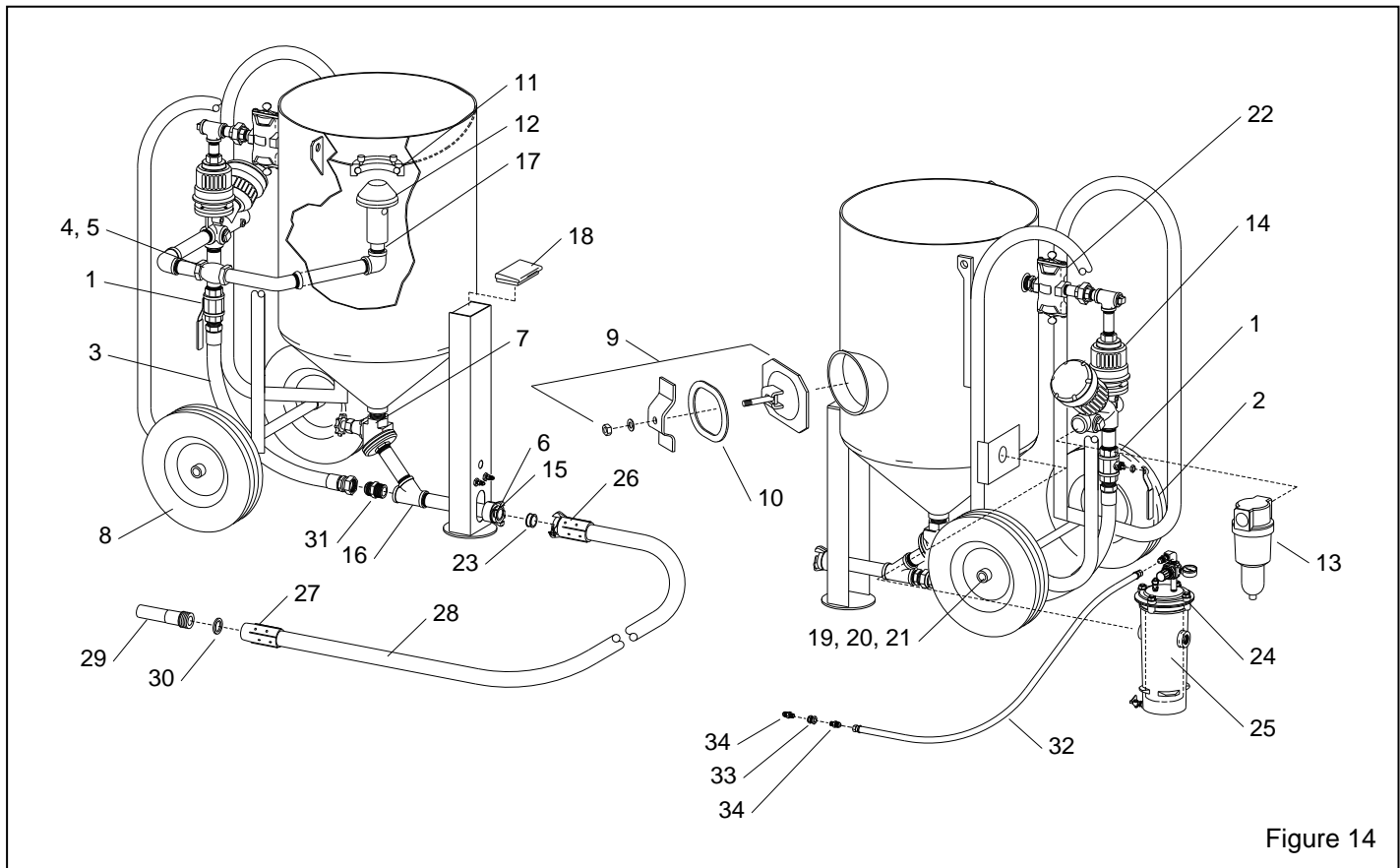


Figure 14

**8.3 Remote Control System Parts, Figure 15**

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

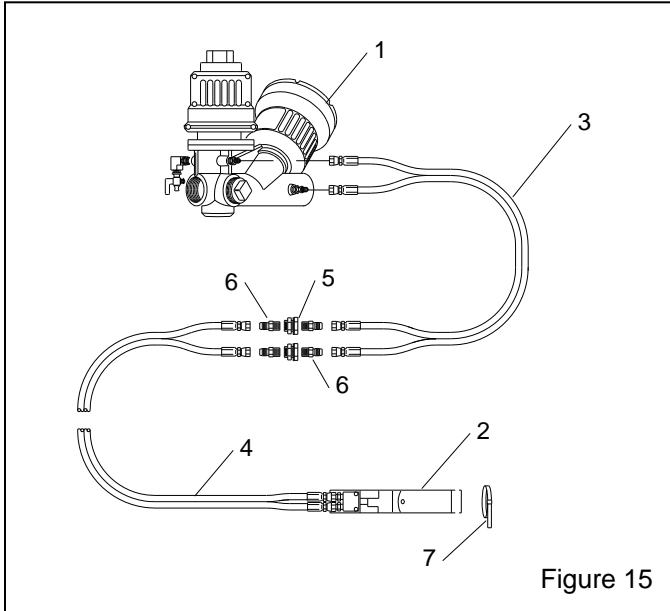


Figure 15

**8.4 Quantum Manual Abrasive Metering Valve, Figure 16**

Item	Description	Stock No.
(-)	Quantum manual metering valve w/wye ...	22845
*	Service kit, metering segment (Fig. 16a)...	22854
1.	Upper body, flanged .....	21314
2.	Screw, 3/8-NC x 1" socket head.....	22655
3.	Outlet 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

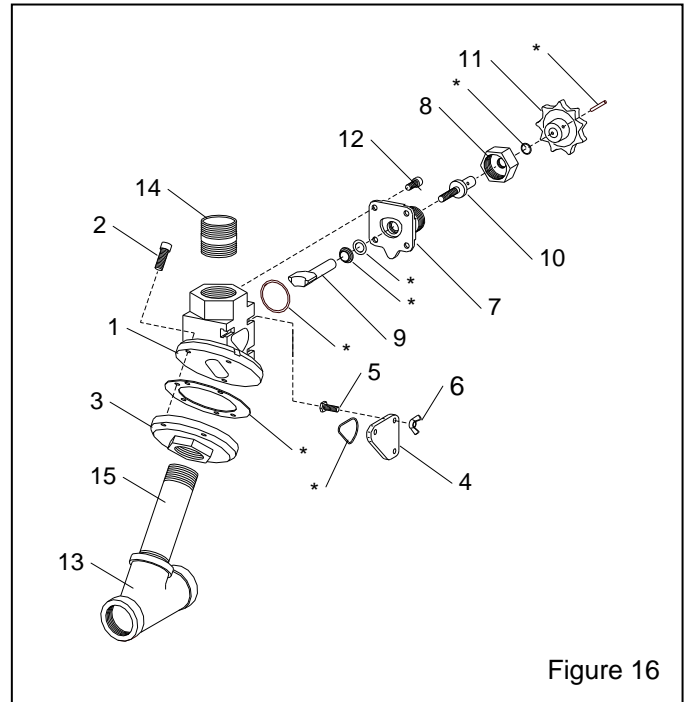


Figure 16

**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

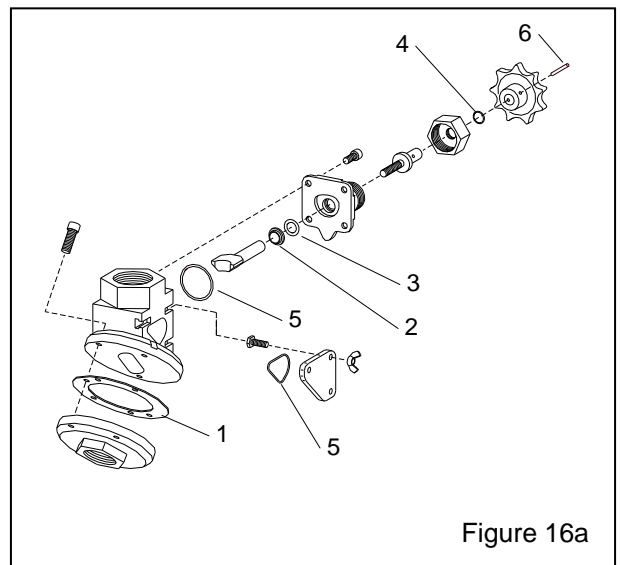


Figure 16a

**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 17**

Item	Description	Stock No.
*	Service kit, Millennium Inlet seals (Fig 17a)..	22856
**	Service kit, Millennium plunger tip (Fig 17b)..	22898
1.	Plunger .....	22600
2.	Dual piston .....	22602
3.	Spring, 4" long .....	22604
4.	Screw, socket, w/internal threads .....	22650
5.	Sleeve, cylinder .....	22603
6.	Screw, 5/16-NC x 1-1/4", socket head .....	22611
7.	Body, inlet valve .....	21338
8.	Cap, cylinder .....	21339
9.	Plug, 1-1/2" NPT .....	02477
10.	Nipple, 1/4" NPT hex .....	02808
11.	Elbow, 1/4" NPT 90° female .....	06373
12.	Petcock, 1/4" NPT .....	01993
13.	Adaptor, 1/8" NPT w/1/16" orifice .....	01945
14.	Bushing, 1/4" x 1/8" brass .....	02010
15.	Adaptor, 1/4" NPT .....	02494
16.	Plug, 1-1/4" NPT .....	01762

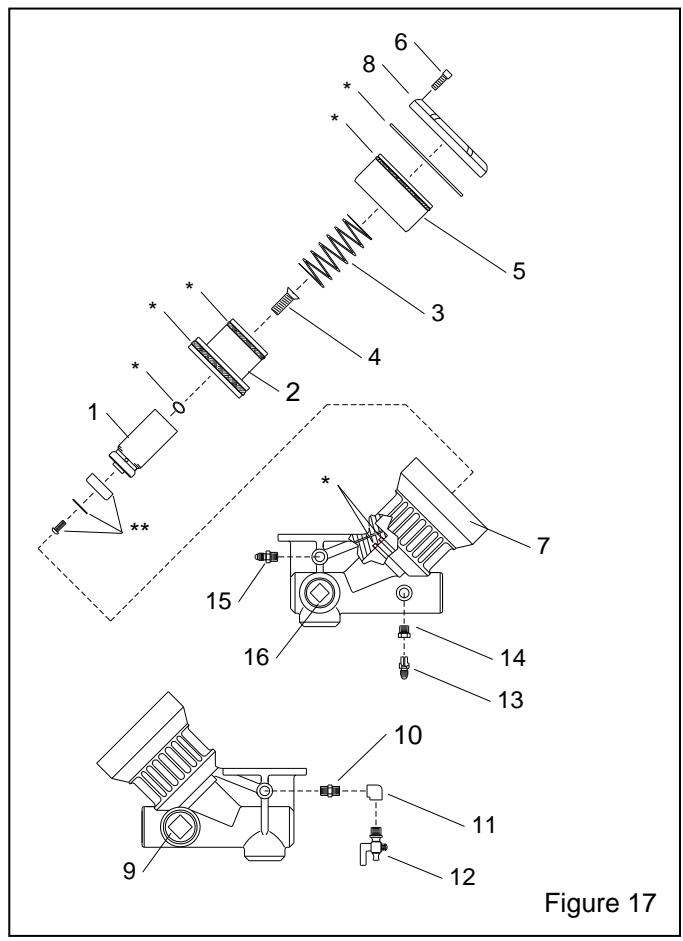


Figure 17

**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

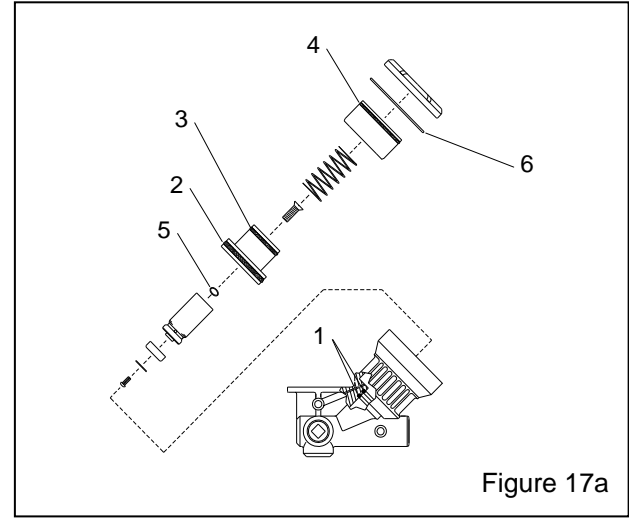


Figure 17a

**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

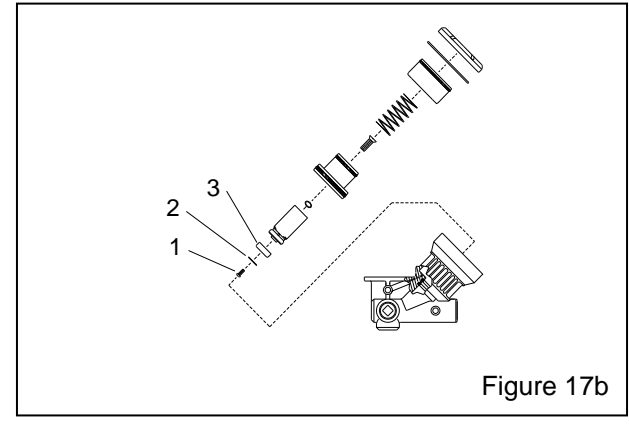
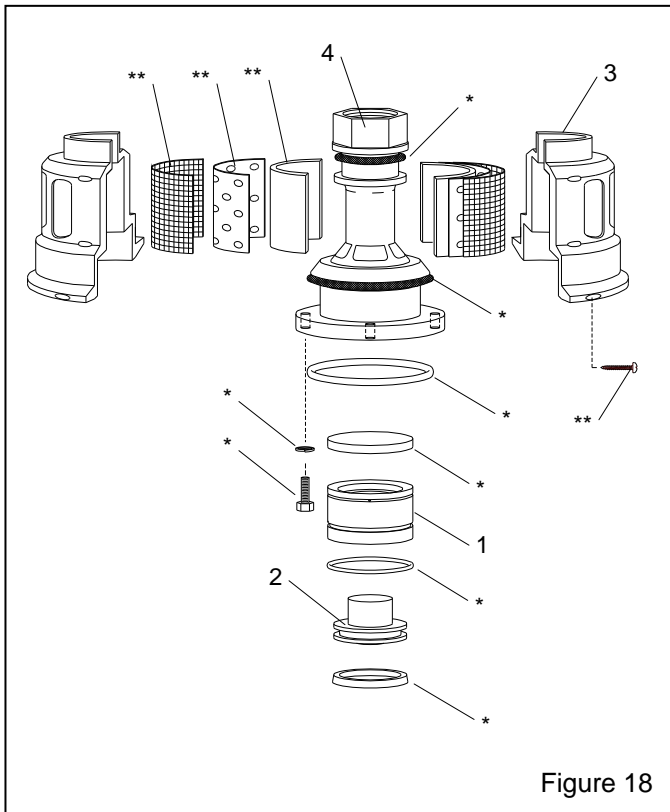


Figure 17b

**8.7 Millennium Valve Outlet Segment, Figure 18**

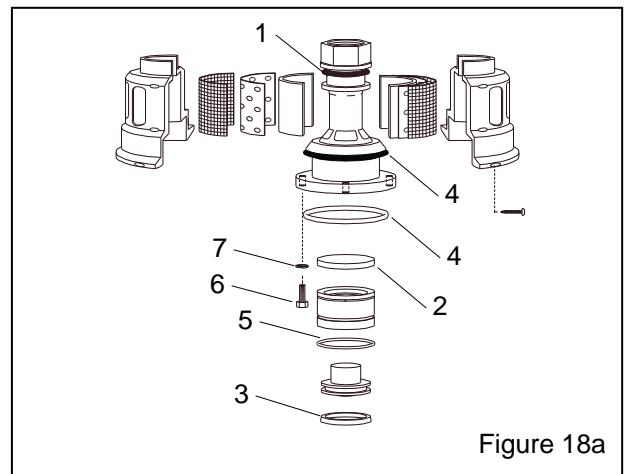
Item	Description	Stock No.
(-)	Outlet segment assembly includes all items shown in Figure 18 ....	21731
*	Service kit, outlet segment (Fig. 18a) .....	22857
**	Service kit, muffler (Fig. 18b).....	22868
1.	Sleeve, inner .....	22612
2.	Piston .....	22613
3.	Housing, muffler, 2 required .....	21346
4.	Valve body, exhaust .....	21345



**22857 SERVICE KIT  
MILLENNIUM OUTLET SEGMENT**

Refer to owner's manual for service instruction.

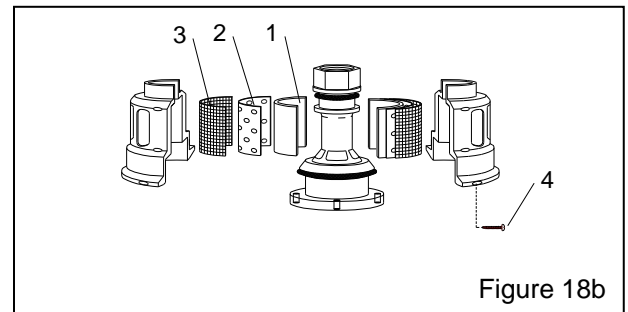
Item	Qty	Description
1.	1	O-ring, 1-5/8" ID nominal
2.	1	Diaphragm
3.	1	U-seal, piston
4.	2	O-ring, 3" ID nominal
5.	1	O-ring, 2-7/16" ID nominal
6.	4	Cap screw, 5/16-NC x 1"
7.	4	Lock-washer, 5/16"



**22868 SERVICE KIT  
MILLENNIUM OUTLET MUFFLER**

Refer to owner's manual for service instruction.

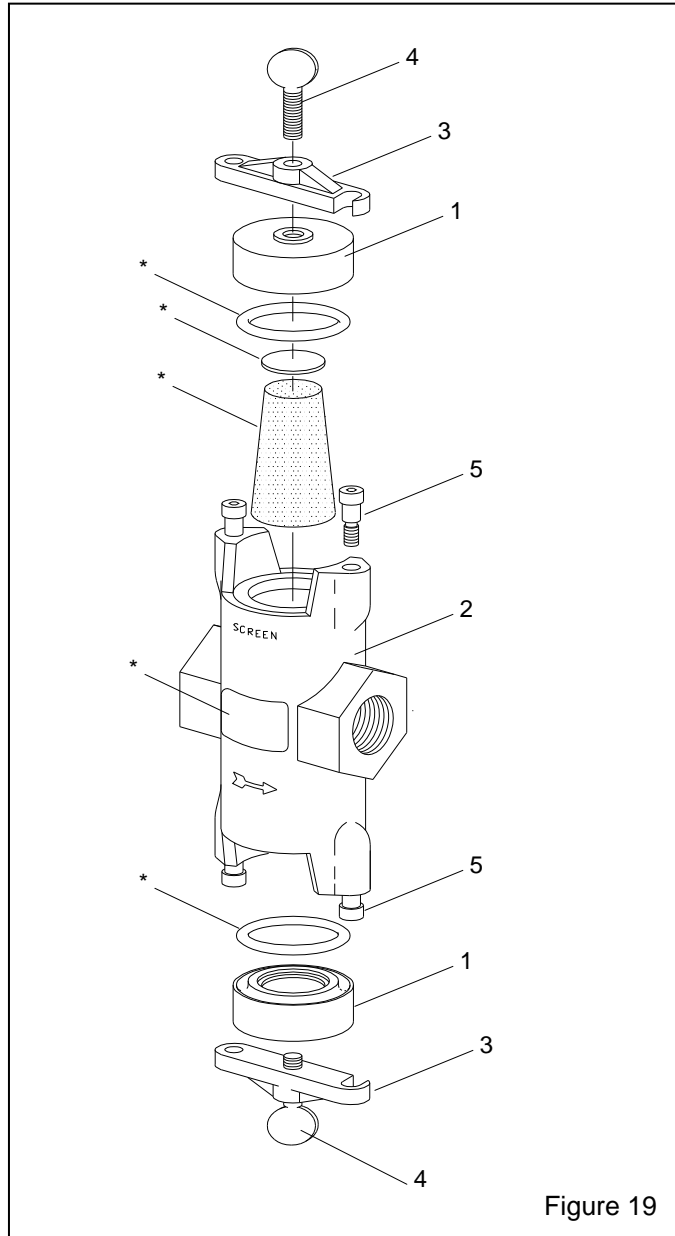
Item	Qty	Description
1.	2	Muffler element
2.	2	Liner, perforated rubber
3.	2	Screen
4.	6	Screw, 12 x 1"





8.8 Abrasive Trap, Figure 19

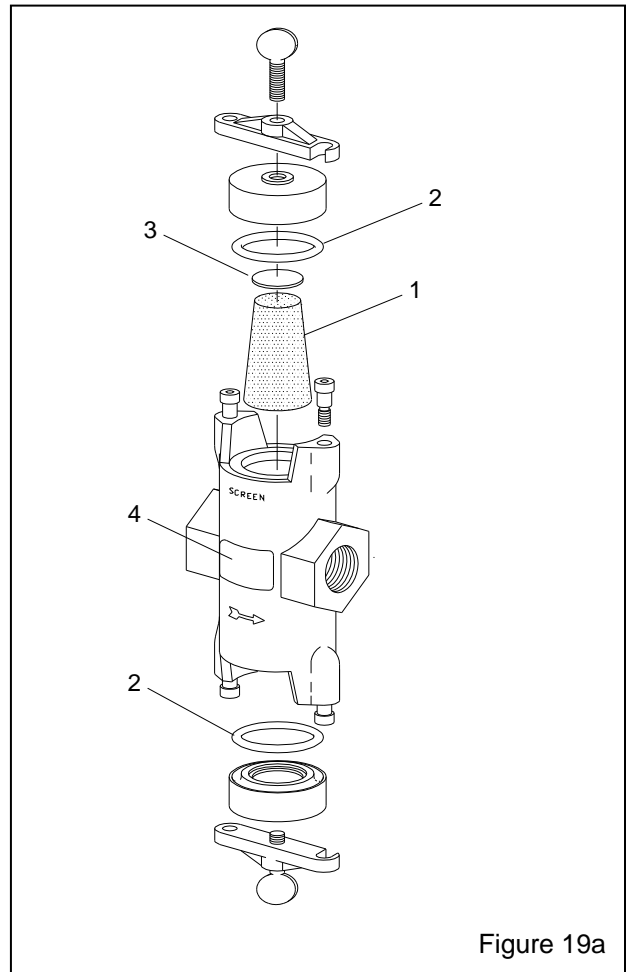
Item	Description	Stock No.
(-)	Abrasive trap .....	02011
*	Service kit, abrasive trap (Fig. 19a) .....	01925
1.	Cap .....	02014
2.	Body .....	02015
3.	Lock bar .....	02016
4.	Screw, 3/8-NC x 1" thumb .....	03289
5.	Shoulder screw, 3/8" x 3/8" .....	03291



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, Figure 20**

Item	Description	Stock No.
(-)	RLX Pneumatic Control Handle Assembly ...	10565
*	Service kit, Pneumatic RLX (Fig. 20a) .....	22859
1.	Handle lever .....	10573
2.	Body .....	10568
3.	Pneumatic adaptor .....	10562
4.	Adaptor, 1/8" NPT (2 required) .....	01940
5.	Tie, nylon wire .....	02195

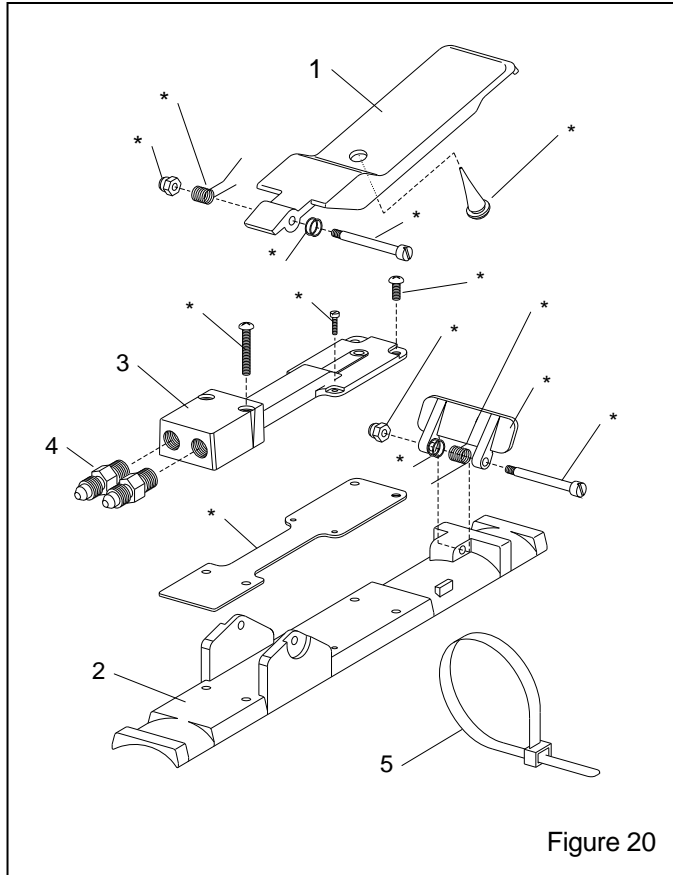


Figure 20

**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"

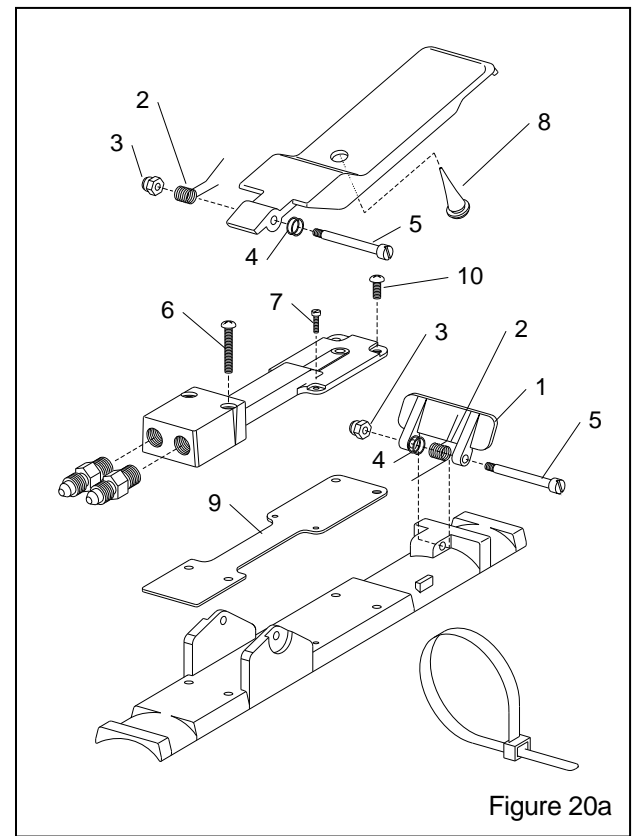


Figure 20a