CLEMTEX

Clemtex Electric Heavy Duty Spinblast Tool

SB-636-BE

The Clemtex SB-636-BE Heavy Duty Spinblast Tool is designed to abrasive blast clean the internal diameter of pipe. This unit includes a electric driven motor to rotate the blast head, and an adjustable carriage designed to center the tool in the pipe to produce a uniform blast cleaned surface.

PRODUCTION RATE

This tool is shipped with two (2) 1 ¼" threaded venture blast nozzles. This unit with operate with nozzle sizes ¼" to 5/8" I.D. The production rate varies depending on the degree of cleanliness required, surface condition, type of abrasive, nozzle size and blasting pressure. Contact a Clemtex Representative to determine an estimated production rate for your specific application.

TRAVEL RATE

The speed (feet per minute) that this tool is pulled through a pipe depends on the diameter of pipe, degree of cleanliness required, surface condition, abrasive size, nozzle size and blasting pressure. A platform or structural support for the wheels of the Spinblast tool to drive on must be provided at the exit/entrance of the pipe to support the weight of the tool. Do not manually lift the tool out of the exit point of the pipe while blasting.

BLASTHEAD ROTATING RATE

A variable speed electric motor turns the blast head of the tool. The motor should be adjusted to 5-12 RPM depending in pipe circumference to produce an even blasted surface.

BLAST HOSE CONNECTION

The blast hose connection on the tool is 2" NPS-M. A standard 2" threaded blast hose fitting (CFB00555) is required if the Spinblast tool in not attached to a pipe lance. The blast hose of pipe lance feeding the tool must be a minimum of 1 ¼" I.D. Smaller diameter hose or pipe lances could lead to premature wear on the Spinblast tool.

ELECTRIC MOTOR CONNECTION

The electric motor runs off of a 12VDC battery. If a 12VDC battery is not available, a 120VAC to 12VDC transformer (CLT-1) is available. The electric motor comes equipped with a Control box to adjust the speed of the motor as well as turning it on or off. This Control Box has a 50 ft. electric cord attached to it with a male plug (CEWMC) on one end and attaches to the electric motor by way of a female connection (CEWFC). Attach the male connection end of the control cord to a CEW25AC (not provided) which comes with alligator clips to attach to the positive (+) and negative (-) terminals of the 12VDC battery.

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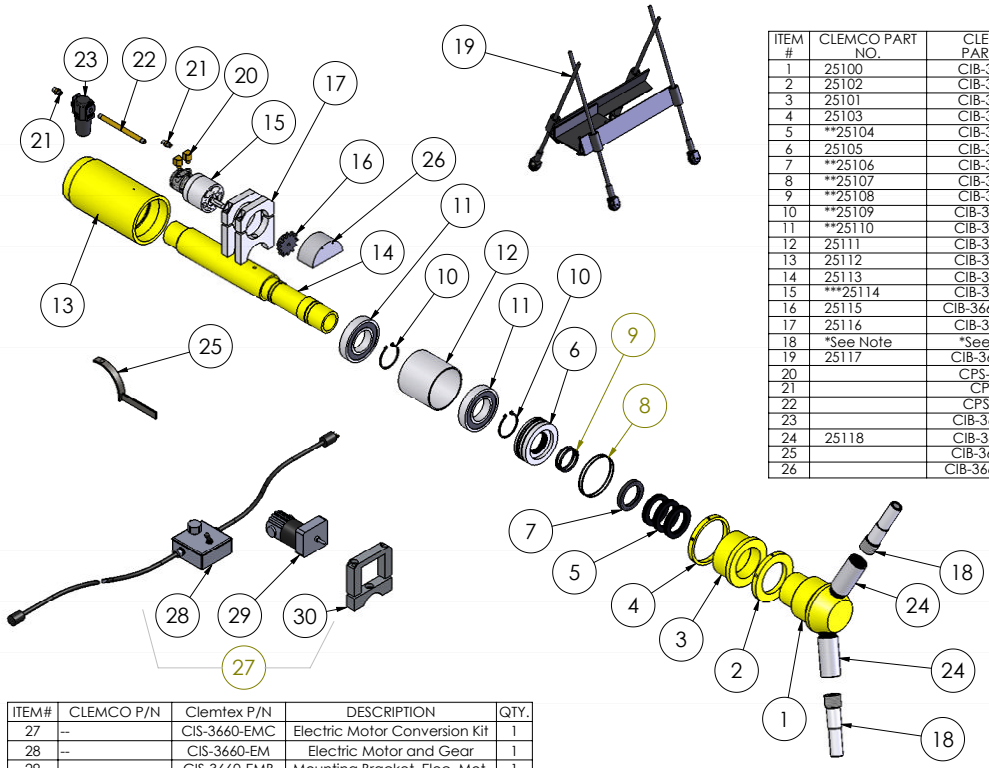

ITEM #	CLEMCO PART NO.	CLEMTEX PART NO.	DESCRIPTION	QTY.
1	25100	CIB-3660-1	Blast Head	1
2	25102	CIB-3660-3	Bushing, Main Body	1
3	25101	CIB-3660-2	Lock Ring, Blast Head	1
4	25103	CIB-3660-4	Lock Ring, Bushing	1
5	**25104	CIB-3660-5	Packing Gasket, Gland	3
6	25105	CIB-3660-9	Seal Gland	1
7	**25106	CIB-3660-6	Seal	1
8	**25107	CIB-3660-7	O-Ring, Gland, Outer	2
9	**25108	CIB-3660-8	O-Ring, Gland, Inner	2
10	**25109	CIB-3660-10	Lock Ring	2
11	**25110	CIB-3660-11	Bearing	2
12	25111	CIB-3660-12	Spacer Sleeve	1
13	25112	CIB-3660-13	Body	1
14	25113	CIB-3660-14	Tube	1
15	***25114	CIB-3660-15	Air Motor & Gear Reducer Assy	1
16	25115	CIB-3660-SPRKT	Sprocket	1
17	25116	CIB-3660-17	Mounts, Air Motor	1
18	*See Note	*See Note	Nozzle (*See Note)	2
19	25117	CIB-3660-CA	H. D. Centering Carriage	1
20		CPS-14x90	Street Elbox, 1/4" x 90, Brass	2
21		CPS-14	Nipple, 1/4" x Close	2
22		CPS-14x6	Nipple, 1/4" x 6"	1
23		CIB-3660-MT	Moisture Trap, 1/4"	1
24	25118	CIB-3660-NE	Nozzle Extension	2
25		CIB-3660-KW	Spanner Wrench	1
26		CIB-3660-NGG	Gear Guard, Nylon	1

*Note: Specify Blast Nozzle Size
CSD01387 3/8" Venturi Nozzle
CSD01388 7/16" Venturi Nozzle
CSD01389 1/2" Venturi Nozzle
**Note: PartsAvailable in Spare Parts Kit
***Note: Air Motor Kit P/N 25119 Available in Spare Parts Kit

ITEM#	CLEMCO P/N	Clemtex P/N	DESCRIPTION	QTY.
27	--	CIS-3660-EMC	Electric Motor Conversion Kit	1
28	--	CIS-3660-EM	Electric Motor and Gear	1
29	--	CIS-3660-EMB	Mounting Bracket, Elec. Mot.	1
30	--	CIS-3660-EMC	Control Kit, Electric Motor	1

OPERATING INSTRUCTIONS

1. Normal operating pressure for this unit is 90-100 psig of clean dry compressed air. Use a Clemtex Needle Pressure Gauge (NPG-100) to confirm the operating pressure at the Spinblast Tool.
2. Attach a minimum 1 ¼" I.D. blast hose to the Spinblast Tool.
3. Attach the Control Box female end to the Electric Motor on the Spinblast Tool.
4. Attach the Control Box Male end to a 12VDC power source.
5. Adjust the speed control to the electric motor drive to maximum speed (12 RPM).
6. Turn off the power to the electric motor drive.
7. Adjust the carriage so that the Spinblast Tool is centered in the pipe.
8. Drive the Spinblast Tool through the pipe unit the rotating blast head protrudes from the pipe.
9. Provide an exit support for the Spinblast Tool to land on as it exits the pipe.
10. Turn on power to begin rotation of the blast head.
11. Open the blast line control valve to begin the blasting operation.
12. If needed, adjust the speed of the electric motor to slow down the rotation to the desired speed.
13. Pull the Spinblast Tool through the pipe at a consistent speed that will provide the desired blast cleanliness.
14. As the Spinblast Tool exits the pipe, turn off the blast line control valve to stop the blast operation, then turn off the power to stop the rotating blast head.

MAINTENANCE

Routine maintenance must be performed to achieve maximum blasting performance of this Tool.

1. Remove the blast head at the end of each shift (8-10 hours) and clean the packing gland and blast tube of all oil, dust and abrasive. Apply a thin layer of grease to the end of the blast tube and slide the packing gland to the proper position.
2. Applied grease to the Spinblast Tool through the grease fitting on the body of the tool. Apply grease until excess grease appears from the internal seal gland o-rings or seal.
3. Install the blast head on the Spinblast Tool and tighten the lock nut to secure the head. The blast head should be hand tight. Do not over tighten the blast head.
4. Attach the control box to the electric motor and supply power to determine if you have an even rotation of the blast head. If the rotation is inconsistent, adjust the blast head until rotation is even.

CLEMTEX

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