



## Heavy Duty Spin Blast Tool Assembly



Step 1 – Secure the threaded end of the spin blast tube. Slide bearing over the unthreaded end of the tube to the back machined position



Step 2 – Slide the lock ring over the unthreaded end of the tube, snap into machined groove to hold bearing in place









Step 3 – Slide spacer sleeve over the unthreaded end of the tube against bearing Note: Spacer will be loose and off-centered until Step 6.



Step 4 – Slide the bearing over the unthreaded end of the tube. Bearing must be inserted against spacer. Install lock ring to hold bearing in place.



Step 5 – Secure spin blast tool body. Insert the threaded end of tube into internally threaded end of body.









Step 6 – Apply a generous amount of grease to the outside surface area of the bearings and spacer sleeve. Press the tube assembly against the back surface of the body.





Step 7 – Apply a generous amount of grease to o-ring grooves in the packing gland. Insert two outer o-rings and two inner o-rings into gland.
Press bearing seal into gland with rubber seal facing out.





Step 8 – Insert packing gland assembly in unthreaded end of tube. Gland must be installed with the bearing seal facing against the bearing.
Gland must be inserted to the position where the grease filling tap and the gland machined grease groove are in line.







Step 9 – Install the rubber packing gland (3 per set) over the unthreaded end of the tube assembly.



Step 10 – Apply grease to main body bushing. Screw locking ring to edge of bushing. Screw bushing into main body hand-tight. Tighten bushing additional ¼ turn. Lock bushing to main body with lock ring.



Step 11 – Screw locking ring onto blast head. Screw blast head on to main body hand-tight.







Step 12 – Screw locking ring against main body hand-tight. Tighten locking ring an addition 1/4 turn to lock blast head in place.



Step 13 – Install grease fitting on main body. Inject 1½ ounces of Mobil SHP-22 lithium grease or equivalent.



Step 14 – Installation of air motor drive assembly. Attach air motor mounts to main tube.



Step 15 – Place air motor assembly on mounts aligning sprocket teeth in chain. Note: Sprocket position will raise or lower by rotating air motor assembly Tighten bolts on top brackets evenly to secure air motor assembly.







Step 16 – Install air inlet hose with moisture trap and crowsfoot to air motor. Install exhaust hose to air motor.

Note: These hoses may be switched to reverse the rotation of the blast head



Step 17 – Install nozzle extensions if required (optional)



- Step 18 Bolt carriage to spin blast tool assembly via tapped threads (2) on Bottom of tube.
  - Note: When not utilizing carriage, tapped threads must be plugged before operating tool.



