

CLEMTEX

Spinblast Tool SB-636-A

The Spinblast tool cleans the interior of pipes from 8" I.D. to 36" I.D. The tool connects to most abrasive blasting machines in place of a standard nozzle. As the tool passes through the length of the pipe being cleaned, abrasive is ejected by two special nozzles mounted on a rotating head.

INSTALLATION

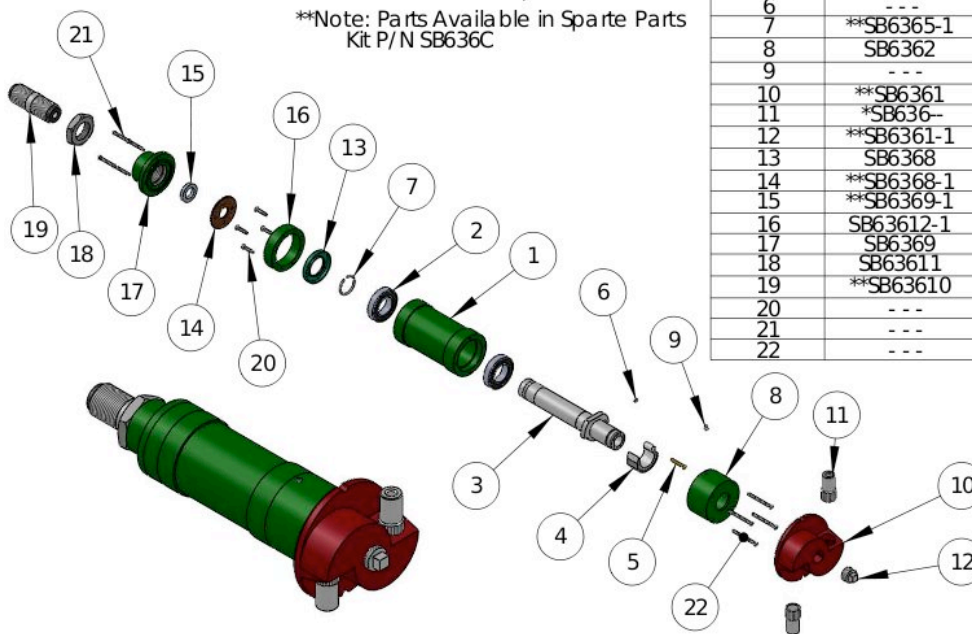
- Loosen the lock nut and remove the rubber nipple assembly from the Spinblast tool.
- Slide the larger body collar over the tool approximately 1" back from the rotating head. Secure with two locking screws. Reinstall the rubber nipple assembly. Adjust for proper drag. The smaller lance collar is for the pipe lance and should be located as far away from the tool as needed to prevent the lance from bowing.
- Select the appropriate set of legs and attach the wheels using clevis pins. Install on both collars and adjust so the tool is centered and on an even plane. (Wheels must be running in a straight line with the tool).

OPERATION

- Mount the Spinblast tool in the appropriate centering carriage.
- Before beginning, rotate the Spinblast head by hand. IT MUST NOT ROTATE FREELY. THERE MUST BE SOME DRAG. Drag indicates that the leather dust seal which protects the bearing is under adequate pressure, and that the brake will slow the rotating head to optimum blasting speed. If the head rotates freely, tighten the rubber-lined nipple at the rear of the unit. When drag is achieved, tighten down the steel locking nut to hold the nipple in place.
- Using CF couplings, connect the blast hose to one end of the pipe lance and the Spinblast tool to the other. Secure with safety wires.
- Position the pipe in a convenient location. Since the pipe need not be rotated, it can be cleaned in stacks.
- With the Spinblast tool just inside the pipe to be cleaned, apply AIR ONLY to the tool. Check to make sure that no air or dust is escaping from the four pressure relief holes on the rear end plate. Escaping dust or air indicates that there is not enough pressure on the leather dust seal, or that it is worn out. A LOOSE OR WORN OUT DUST SEAL COULD CAUSE SEVERE DAMAGE TO THE SPINBLAST TOOL IN A MATTER OF MINUTES.
- Using the pipe lance, push the Spinblast tool to the far end of the pipe. Then add abrasive to the air. Supply a rich air/abrasive mixture. TOO LEAN A MIXTURE WILL CAUSE PREMATURE WEAR ON THE ROTATING HEAD.
- Pull the tool back towards you steadily and evenly. The speed is determined by the desired finish. CHECK FOR PROPER DRAG AFTER THE FIRST 15 MINUTES OF USE AND AT LEAST EVERY 30 MINUTES THERE AFTER. TIGHTEN THE RUBBER LINED NIPPLE IF NECESSARY.

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- *Note: Specify Nozzle
 -SB63613 Nozzle 1/4" Orf. x 1 3/4"
 -SB63614 Nozzle 5/16" Orf. x 1 3/4"
 -SB63615 Nozzle 5/16" Orf. x 3"
 -SB63616 Nozzle 3/8" Orf. x 1 3/4"
 -SB63617 Nozzle 3/8" Orf. x 3"
- **Note: Parts Available in Spare Parts Kit P/N SB636C



ITEM NO.	PARTNO.	DESCRIPTION	QTY.
1	SB63612	Main Body	1
2	SB6366	Sealed Bearing	2
3	**SB6365	Tube	1
4	**SB6364	Brake with Lining	1
5	---	Break Pin	1
6	---	Brake Pin Set Screw	1
7	**SB6365-1	Bearing Lock Ring	1
8	SB6362	Brake Housing	1
9	---	Break Housing Set Screw	1
10	**SB6361	Nozzle Head	1
11	*SB636--	Tungsten Lined Nozzle	2
12	**SB6361-1	1 in. Plug	1
13	SB6368	Bearing Seal	1
14	**SB6368-1	Leather Dust Seal	1
15	**SB6369-1	Tungsten Washer	1
16	SB63612-1	Seal Retainer	1
17	SB6369	Rear End Plate	1
18	SB63611	Locking Nut	1
19	**SB63610	Nipple Rubber Lined	1
20	---	Screw, 10-24 x 1 in.	4
21	---	Screw, 10-24 x 1.5 in.	4
22	---	Screw, 10-24 x 2.25 in.	4

MAINTENANCE

Leather Dust Seal

- The leather dust seal (14) must be kept under adequate pressure, and must never be allowed to wear through. Check for drag on the rotating head after the first 15 minutes of use and at least every 30 minutes thereafter and every time before using the tool. Inspect the leather dust seal for wear every four hours unless your experience indicates a longer life. To replace the dust seal, back off the rubber-lined nipple (19) and remove the end plate (17). Be careful not to drop the tungsten carbide washer (15); it is extremely brittle. Clean the exposed bearing seal (13) and the grooved end of the tube (3). Apply a liberal coating of Vaseline or cup grease to the exposed parts and install a new leather dust seal with the smooth side toward the bearing seal. After re assembly check for proper drag on the rotating head.

Tungsten Carbide Washer

- Replace the tungsten carbide washer (15) before it wears larger than the opening in the tube (3).

Nozzles

- Rotate both of the blast nozzles one quarter turn daily. This will promote even nozzle wear, and assure the longest possible nozzle life.

Nozzle Head and Plug

- Replace the nozzle head plug (12) every eight hours, unless your experience indicates a longer or shorter life. (The operating pressure, type of abrasive, and type of nozzle affect the wear rate). Replace the nozzle head when it wears out. When removing or replacing either the nozzle head (10) or the

plug, remove the set screw (9) in the brake housing (8) and insert a screw driver or other similar tool into the hole to prevent the tube casting from turning.

Brake Lining

- Inspect the brake lining daily. Replace the brake (4) before the lining wears too thin that it damages the brake shoe or the brake housing (8).

Lock Ring/Bearing Seal

- To replace the bearings (2) or remove the steel tube (3), the rear end plate (17) must be removed to expose 4 screws holding the retainer ring (16) on to the main body. Remove the retaining ring to expose the tube lock ring (7). Do not reuse lock ring or bearing seal.

Tube Casting and Bearings

- Remove lock ring and bearing seal (see section 6) and nozzle head (see section 4). Remove brake housing (8). Drive or press tube casting out through the front of the main body. To replace bearings, drive or press bearings out each end of the main body and reassemble in reverse order.

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