

**2-POT ABRASIVE
CLEANER STAND
O. M. 27788**

DATE OF ISSUE: 12/13
REVISION: Rev A, 07/21

 **WARNING**

Do not use this equipment before READING this MANUAL and UNDERSTANDING its contents.

These WARNINGS are included for the health and safety of the operator and those in the immediate vicinity. Failure to read and understand these warnings can result in injury or death.

Electronic files include a preface containing the same important information as in the orange cover.

© 2021 CLEMCO INDUSTRIES CORP.
One Cable Car Dr.
Washington, MO 63090
Phone (636) 239-4300
Fax (800) 726-7559
Email: info@clemcoindustries.com
www.clemcoindustries.com

INDUSTRIAL
Blast Facilities
by Clemco Industries Corp.

1.0 INTRODUCTION

1.1 Scope

1.1.1 These instructions cover setup, operation and replacement parts for the Clemco 2-pot abrasive cleaner stand. Manuals for other equipment used with the stand are:

Bucket Elevator.....Manual No. 21822
 AWAC Abrasive CleanerManual No. 20547

Blast machine cover assemblies are not included with the stand, and must be ordered to match the mounting style of the blast machine. Refer to Sections 5.2 and 6.0.

NOTE: The 2-pot stand raises the abrasive cleaner by approximately four feet. When used with standard bucket elevators, a four-foot elevator extension is required.

1.1.2 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, remote controls, and all other equipment used with this product.

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 or email info@clemcoindustries.com.

1.2 Safety Alerts

1.2.1 Clemco uses safety alert signal words, based on ANSI Z535.4-2011, 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 you to potential physical injury hazards. Obey all safety messages that follow this symbol to avoid possible injury or death.

NOTICE

Notice indicates information that is considered important, but not hazard-related, if not avoided, could result in property damage.

CAUTION

Caution indicates a hazardous situation that, if not avoided, could result in minor or moderate injury.

WARNING

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

DANGER

Danger indicates a hazardous situation that, if not avoided, will result in death or serious injury.

1.3 Description

1.3.1 The 2-pot abrasive cleaner stand supports a single AWAC abrasive cleaner above two blast machines. The hopper diverts cleaned abrasive equally into both machines. A slide-gate shut off valve, located above each abrasive chute, provides means to shut off abrasive flow to the machine(s) so they can be emptied for service or when not in use. The components of the stand are shown in Figure 1. Use Figure 2 as a reference to show how the stand appears when it is assembled. All fasteners to assemble the stand are included as is the mastic seal, which goes between the abrasive cleaner and stand.

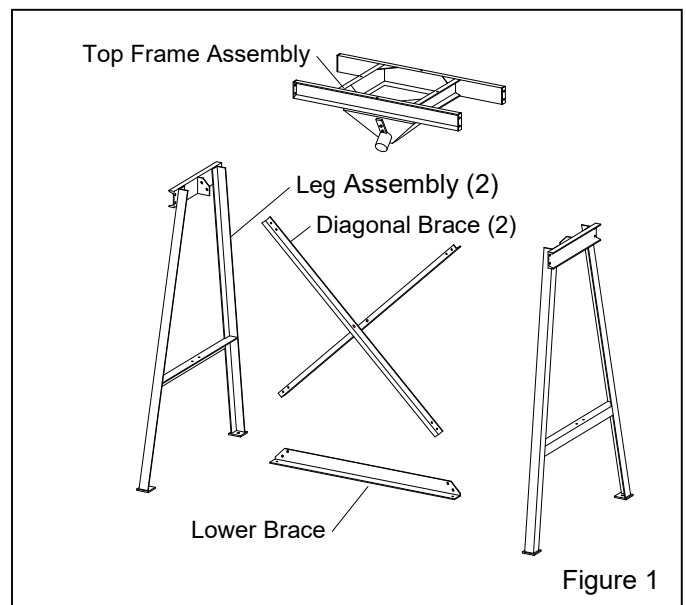


Figure 1

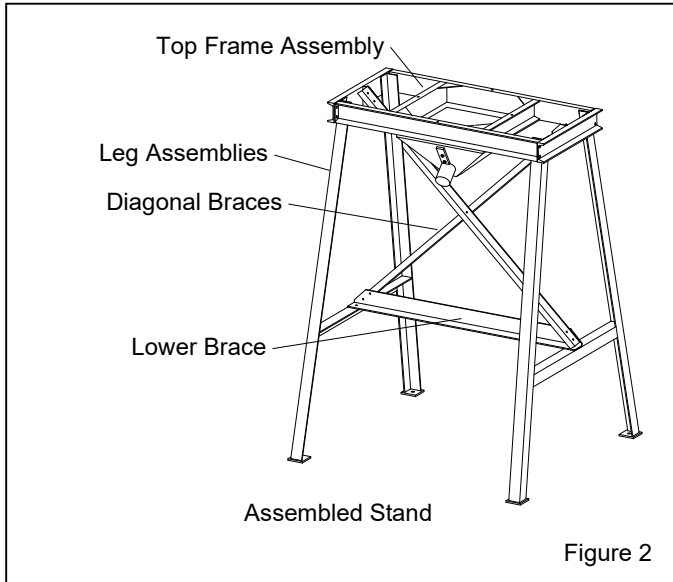


Figure 2

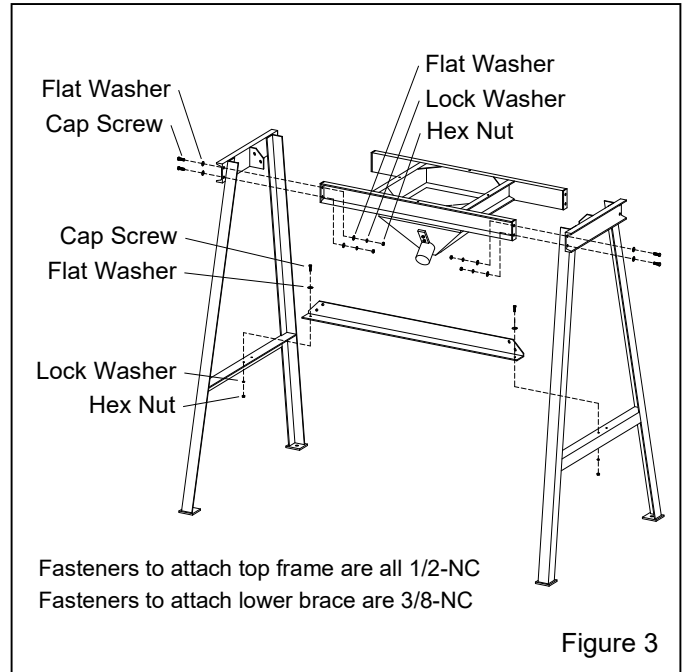


Figure 3

2.0 SETUP

2.1 Refer to Figure 3. Loosely attach the top frame and lower brace to the leg assemblies. The fasteners will be secured after the assembly is completed and squared. Fasteners used to attach the top frame assembly are all 1/2-NC; fasteners used to attach the lower brace are all 3/8-NC.

2.2 Refer to Figure 4. Attach the 2 diagonal braces to the brackets on the top frame and to the bolt hole on the leg assembly cross-support. Note the flat sides of the angled braces are placed against the brackets and lower brace, and are back-to-back with one another. Fasteners used to attach the diagonal braces are all 3/8-NC.

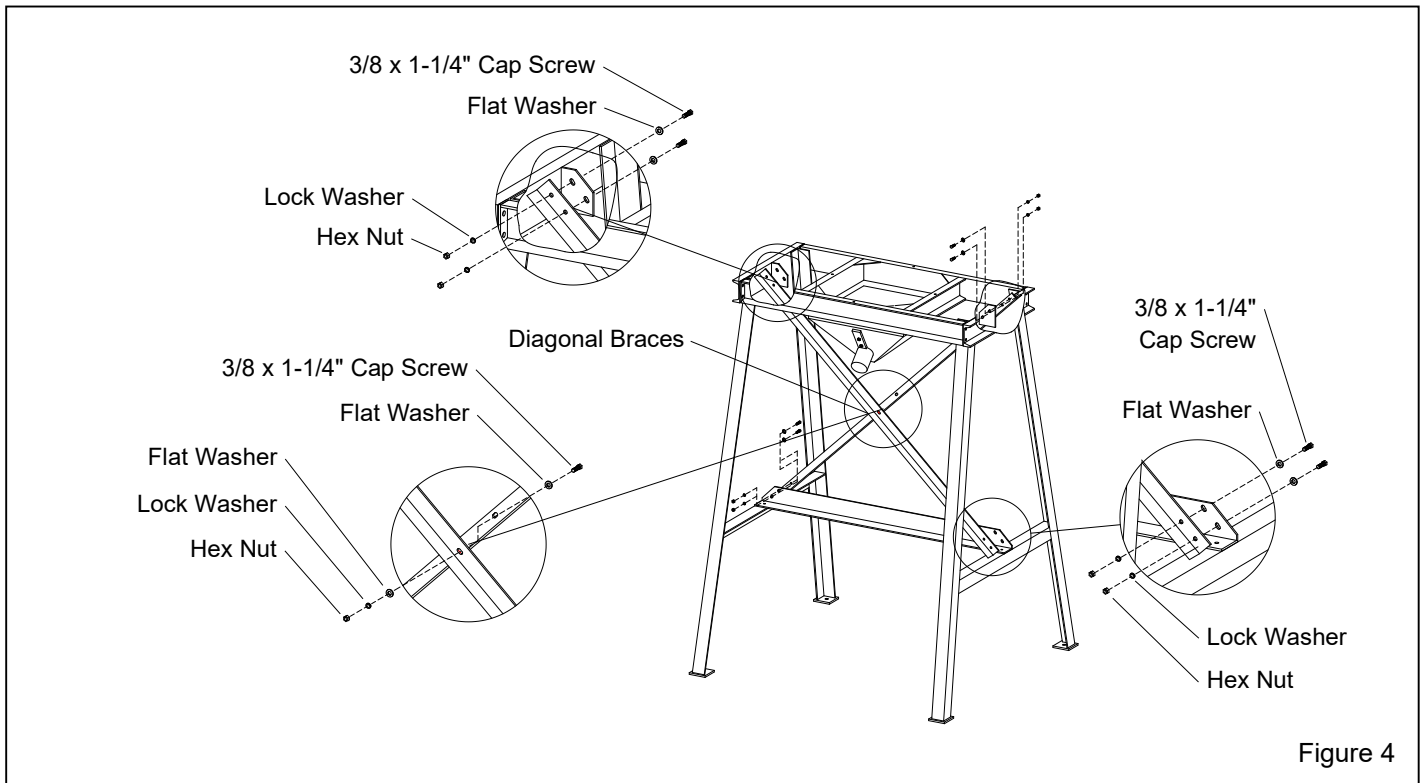
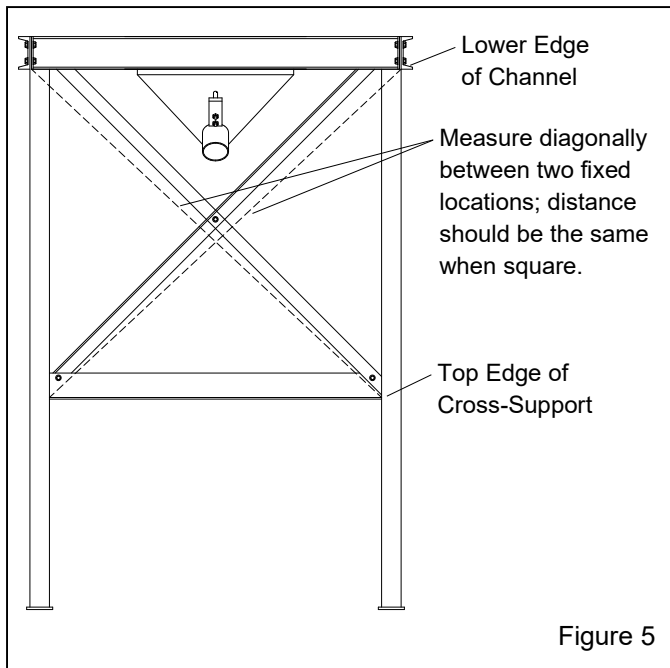


Figure 4

2.3 Align the center holes on the diagonal braces and install fasteners as shown in Figure 4.

2.4 Make sure the stand is plumb by measuring diagonally between two identical points on both sides of the stand. The measurements can be taken any place as long as they are in the same place on both sides. An example is shown as dashed lines in Figure 5. Tighten all fasteners when stand is plumb.

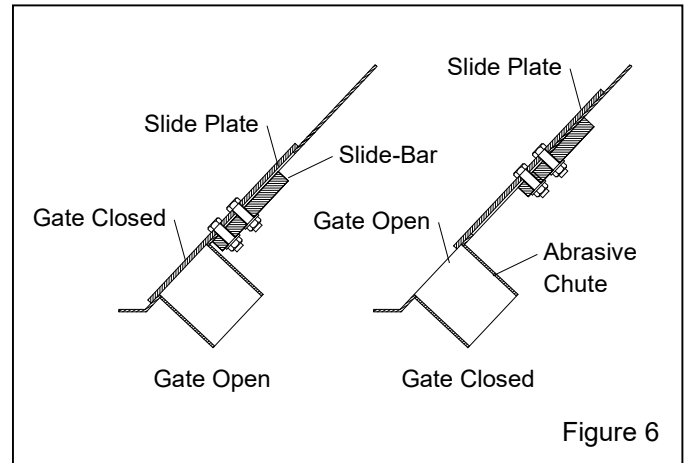


3.0 SLIDE-GATE SHUT OFF VALVE

Before placing the abrasive cleaner on the stand, observe the slide-gates from both the inside and outside of the hopper. The slide plate is visible from inside the hopper and the bar is accessible from outside.

3.1 Close slide-gates and empty the blast machine when the machine will be unused for an extended period, or when emptying a machine for service. If a machine contains abrasive and is out of service for a period of time, condensation could develop inside the machine and cause flow problems due to damp abrasive.

3.2 **To open the slide-gate**, loosen the lock nuts on the slide-bar and slide the gate up, as shown in Figure 6; it moves within a slot on the hopper. Snug the nuts to secure the gate in the open position. When open, abrasive automatically refills the blast machine each time the machine depressurizes.

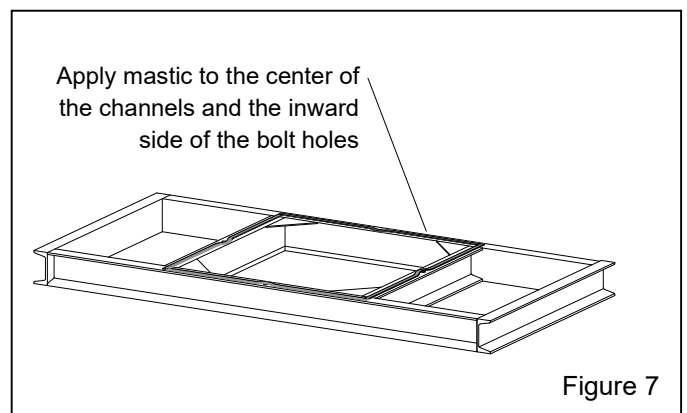


3.3 **To close the slide-gate**, loosen the nuts on the slide-bar and slide the gate down, as shown in Figure 6; this moves the slide plate over the abrasive chute and stops abrasive flow in the blast machine. Snug the lock nuts to secure the gate in the closed position.

4.0 ASSEMBLE THE AWAC ONTO THE STAND

4.1 Apply mastic to the center of the top frame channels and the inward side of the bolt hole, as shown in Figure 7. Extra mastic is provided; make sure the frame on which the abrasive cleaner flange rests is totally sealed.

4.2 Refer to the AWAC abrasive cleaner manual to assemble the abrasive cleaner.



5.0 PLACE BLAST MACHINES and INSTALL COVERS

5.1 Place blast machines as shown in Figure 8; position them so the blast hose outlets are facing toward the blast site or blast room so that there will be as few bends as possible in the blast hose.

5.2 Refer to Figure 8 and attach cover as follows.

- **Blast machine with flange:** Place both covers (with gasket attached to the flange) on the machines as shown in Figure 8. Align the bolt holes and secure the cover using the eight 3/8-NC x 1-1/4" cap screws, lock washers, and hex nuts provided.
- **Blast machine without flange:** Place both covers on the machines as shown in Figure 8.

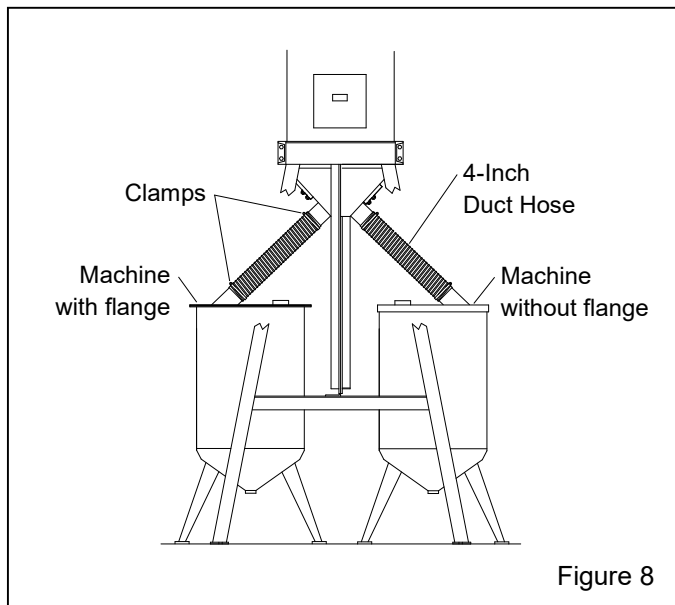


Figure 8

5.3 Slide two clamps over each 4-inch transfer (duct) hoses, and then slide the hoses onto the abrasive chutes and the cover's inlet pipes. Tighten the clamps to secure the hose.

5.4 Refer to Section 3.0 and open or close the slide-gates as needed.

Refer to the AWAC abrasive cleaner manual or the recovery system manual before loading abrasive.

6.0 REPLACEMENT PARTS and ACCESSORIES Refer to Figure 9

Item	Description	Stock No.
(A)	Cover assembly, 28.38" diameter for 24" blast machine with a flange03104
(B)	Cover assembly, 24.75 "diameter for 24" blast machine without a flange02582
(-)	Mastic seal, per foot, between abrasive cleaner and stand, specify ft. required	
	10 ft standard length06105
1.	Hose, 4" duct (transfer), per foot	
	2 ft standard length00716
2.	Clamp, hose, 4-1/2", each02806
3.	Filter, 3-1/2" x 7" air inlet27051
4.	Gasket, 5/16" x 1" strip, per foot00187
5.	Gasket, 5/16" x 3/4" strip, per foot00189
6.	Clamp, filter hold-down, each00251
7.	Screw, 10 x 3/4 self-tap, each12722

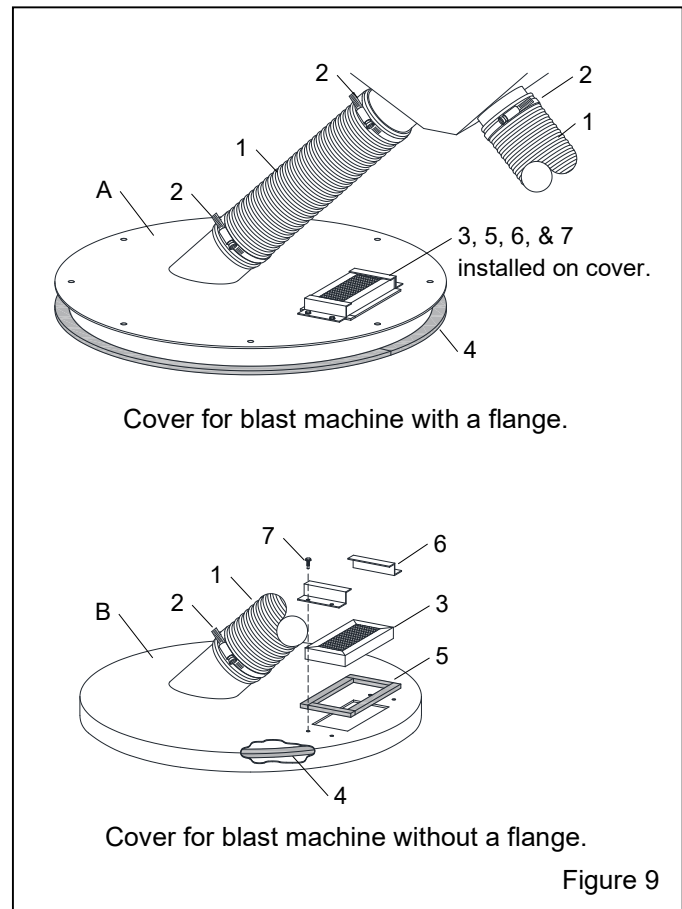


Figure 9