

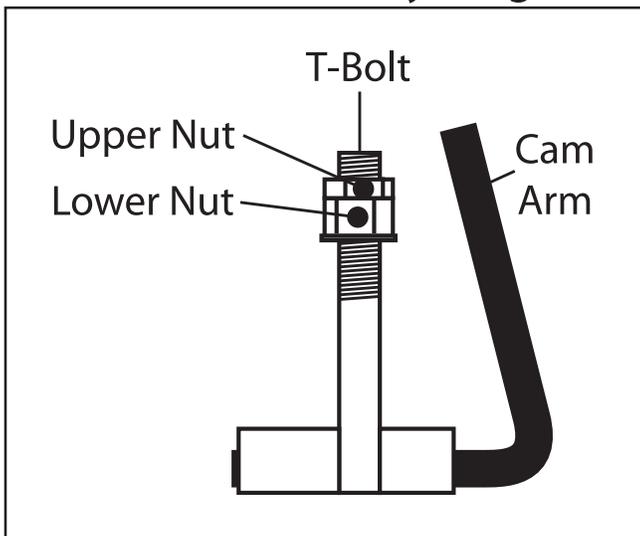


ASSEMBLY INSTRUCTIONS

Camlock Closure Assemblies



Cam-Lock Assembly Diagram



SETTING UP, OPENING AND CLOSING CAMLOCK CLOSURE ASSEMBLIES

Proper use of a Camlock Closure Assembly is to set the torque properly on the T-bolt nuts, and use the cams to open and close the lid by hand.

To open the closure, the pressure vessel must be fully depressurized. Use the safety valve to check for the presence of compressed air before attempting to open. If your equipment does not feature a safety valve, check for the presence of compressed air at the blowdown valve/muffler.

Once the absence of pressure has been confirmed, swing the cam arms down in alternating sequence while leaving the T-bolts that hold the lid down in place. Once all the cam arms are swung down, swing the T-bolts down in alternating sequence until all are down and the lid can be swung open. **If at any point during the opening process air can be heard or felt escaping around the lid, STOP IMMEDIATELY, the vessel is still pressurized!** To close the Camlock Closure Assembly, perform the reverse of the opening procedure.

If the T-Bolts cannot be swung into and out of place with the cam arms in the down position, they are not adjusted properly and they must be readjusted using the following procedure. To set the torque on each of the cam-locks, close the lid, swing the T-bolts into position and swing the cam arms up. Tighten the lower nut on each T-bolt to 20 ft-lb, then using 2 wrenches, hold the lower nut in place while tightening the upper nut snugly against the lower nut to prevent loosening. Lubricate the cams with a penetrating oil to ensure the cams don't seize up with rust and can be swung into place easily. Inspect the closure O-ring and replace if leaking.



WARNING: When the torque is set properly, the cam arms should be able to be swung into place by hand. NEVER use a tool or extension bar to force the cam arms into place



DANGER: Always use the safety valve (or blowdown valve/muffler if not present) on top of the pressure vessel to check for the presence of compressed air before opening the Camlock Closure Assembly. If you hear air escaping when you open the safety valve, the vessel is still pressurized. Never attempt to open the Abrasive Blaster while it is pressurized.