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# ***OWNER'S MANUAL***

## ***Wet blast system WET BLAST FLEX***

***with W-92 booster pump,  
SC2048 blast machine, 500 l water tank and  
KB-52 wet blast head***

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[tional.com](http://www.clemco-international.com)

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# 1 Scope of manual

This owner's manual contains information regarding the operation and maintenance of the WET BLAST FLEX wet blast system, consisting of:

- W-92 frame-mounted booster pump with attached filter regulator
- SC2048 pressure blast machine with PT valve and RMS remote control valve
- KB-52 wet blast head
- 500 l water tank
- High-pressure water hose and suction hose.

## 2 Application and restrictions

The WET BLAST FLEX wet blast system is a blast machine which is connected to a self-priming pump (W-92) and a 500 l water tank. This system is intended for one operator. Water is injected directly into the blast media air flow (nozzle) and atomised via the wet blast head (water volume can be regulated via the needle valve and KB-52 nozzles). The water binds the dust that would normally be created during blasting. The W-92 booster pump is self-priming and is supplied directly from the water tank. The machine can also be used for dry blasting, washing down or air drying thanks to the intelligent control (see Table 2).

## 3 Description of the equipment

### 3.1 Components

The WET BLAST FLEX wet blast system in the base frame (see Figure 1) has the following main dimensions:

<i>Length</i>	<i>Width</i>	<i>Height</i>	<i>Weight</i>
2000 mm (without hoses)	800 mm	1500 mm (without crane eyes)	420 kg

**Table 1:** Main dimensions

The following components and devices are required for wet blasting with the WET BLAST FLEX wet blast system:

- Sufficiently sized air supply for blast machine and W-92 booster pump
- Water supply for 500 l tank (only required for filling up)
- WET BLAST FLEX wet blast system consisting of:
  - ⇒ W-92 booster pump
  - ⇒ KB-52 wet blast head
  - ⇒ SC2048 pressure blast machine with PT valve and RMS remote control valve

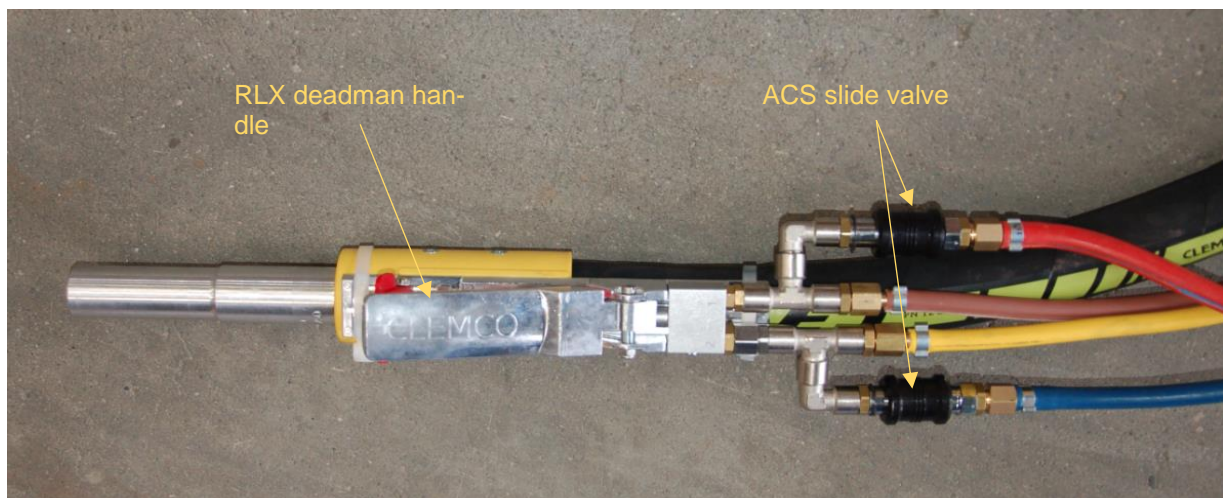
- ⇒ High-pressure water hose and suction/water hose
- ⇒ Water tank (500 litres)

Table 2 shows the processes that can be carried out using the WET BLAST FLEX wet blast system and controlled via the ACS slide valves on the RLX deadman handle with dual function.

Figure 1 shows the deadman handle with both ACS slide valves which are used to switch the blast media/water function on and off:

- The slide valve with the red hose is used to open and close the blast media function
- The valve with the blue hose is used to open and close the water function

The function is actuated in each case by sliding/pulling the ACS valve.



**Figure 1:** Deadman handle with ACS slide valves

<b>Process</b>	<b>Actuation</b>
Dry blasting (air and blast media)	Press the RLX deadman handle and open the ACS slide valve with the red hose (ACS with blue hose closed)
Washing down (air and water)	Press the RLX deadman handle and open the ACS slide valve with the blue hose (ACS with red hose closed)
Wet blasting (air, water and blast media)	Press the RLX deadman handle and open both ACS slide valves
Air drying	Press the RLX deadman handle and close both ACS slide valves

**Table 2:** Processes

### 3.2 Description of water tank

The water tank installed in the WET BLAST FLEX (see Figure 2) is made from UV-stabilised polyethylene. It has a capacity of 500 litres and a ¾" connection. It includes a scale for reading off the water level.



Figure 2: Illustration of water tank

### 3.3 Functional principle

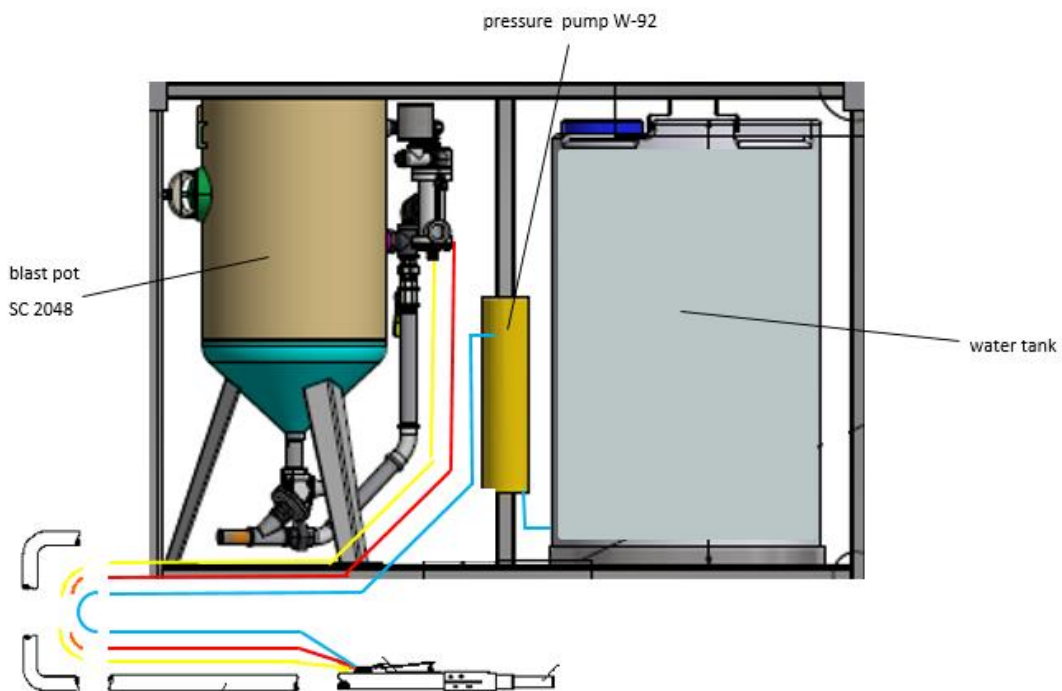


Figure 3: WET BLAST FLEX wet blast system

The blast machine and the W-92 booster pump (see Figure 3) are supplied with compressed air in parallel. The compressed air is cleaned in the connection filter and then drives the self-priming water pump via an air motor. The primed and pressurised water is pumped to the KB-52 wet blast head via a high-pressure water hose. The water is injected (ball valve open) into the blast media and air flow via the ring nozzle distributor of the wet blast head, and is atomised in the process. Blast media and dust

are wet/bound with water to enable low-dust/dust-free blasting. The needle valve and the nozzles on the KB-52 wet blast head ensure that the water is metered according to the blast parameters.

## 4 Operation

### 4.1 Requirements

The following technical data and maximum values of the WET BLAST FLEX must be observed during operation:

Maximum air inlet pressure for the sandblaster = <b>12 bar</b>
Theoretical ratio (water pressure to air pressure) = <b>4 : 1</b>
Water pump flow per double stroke = <b>75 cm<sup>3</sup></b>
Maximum water volume pumped = <b>15 l/min</b>
Air consumption of the W-92 booster pump at 8 bar = <b>0.15 m<sup>3</sup> / min</b>

**Table 3:** Technical data

### 4.2 Set-up for initial installation and reinstallation

(1) Set down the wet blast system	<ul style="list-style-type: none"> <li>– Level surface</li> <li>– Near the compressed air system</li> </ul>
(2) Install SC2048 pressure blast machine	<ul style="list-style-type: none"> <li>– Connect air supply</li> <li>– Fill with blast media</li> <li>– Adjust all relevant parameters (pressure, blast media flow, etc.)</li> </ul> <p><i>Follow the instructions in the SC-2048 pressure blast machine owner's manual!</i></p>
(3) Wet blast head (KB-52) already installed	<ul style="list-style-type: none"> <li>– Connect blast hose with nozzle and holder to wet blast head</li> <li>– Connect remote control hoses to the machine as well</li> </ul>
(4) Install W-92 booster pump	<ul style="list-style-type: none"> <li>– Compressed air (<b>set compressed air regulator to max. 8 bar</b>)</li> </ul>
(5) Install water tank	<ul style="list-style-type: none"> <li>– Unscrew safety lock</li> <li>– Open tank cover</li> </ul>

	<ul style="list-style-type: none"> <li>- Add water (<b>max. 500 l</b>)</li> <li>- Close tank cover and screw safety lock back on</li> </ul>
<i>(6) Remove air from the system</i>	<ul style="list-style-type: none"> <li>- Supply compressed air to the W-92 booster pump (open ball valve)</li> <li>- Set pump pressure regulator to around 3 bar</li> <li>- Open the ball valve on the wet blast head</li> <li>- Leave the W-92 booster pump running until only water comes out of the nozzle (no air left in the system)</li> </ul>
<i>(7) Put on the protective equipment</i>	<ul style="list-style-type: none"> <li>- Resistant clothing</li> <li>- Air-fed helmet with correct connection to the breathing air supply (breathing air filter) and adjustment of the air volume with an air control valve attached to the belt</li> <li>- Leather gloves and safety shoes</li> </ul>

### **4.3 Daily set-up**

Not necessary if an initial installation or reinstallation has already been performed in accordance with chapter 4.2.

<i>(1) SC2048 pressure blast machine</i>	<ul style="list-style-type: none"> <li>- Connect air supply</li> <li>- Fill with blast media if applicable</li> <li>- Check all relevant parameters (pressure, blast media flow, etc.)</li> </ul> <p><i>Follow the instructions in the SC-2048 pressure blast machine owner's manual!</i></p>
<i>(2) Water tank</i>	<ul style="list-style-type: none"> <li>- Ready for use (top up water if necessary)</li> </ul>
<i>(3) Remove air from the system</i>	<ul style="list-style-type: none"> <li>- Supply compressed air to the W-92 booster pump (open ball valve)</li> <li>- Set pump pressure regulator to around 3 bar</li> <li>- Open the ball valve on the wet blast head</li> <li>- Leave the W-92 booster pump running until only water comes out of the nozzle (no air left in the system)</li> </ul>
<i>(4) Put on the protective equipment</i>	<ul style="list-style-type: none"> <li>- Resistant clothing</li> </ul>

	<ul style="list-style-type: none"> <li>- Air-fed helmet with correct connection to the breathing air supply (breathing air filter) and adjustment of the air volume with an air control valve attached to the belt</li> <li>- Leather gloves and safety shoes</li> </ul>
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#### **4.4 Startup and operation**

<i>(1) Wet blasting</i>	<ul style="list-style-type: none"> <li>- Start the blasting process with air only (press the deadman handle)</li> <li>- Open the water supply and regulate with the needle valve until a full water mist comes out of the nozzle, increase the air pressure with the regulator if necessary</li> <li>- Adjust the blast media supply (open the metering valve using the slide valve on the deadman handle) and the blast media/water quantities</li> </ul>
<i>(2) Wash down the blasted parts</i>	<ul style="list-style-type: none"> <li>- Close the media metering valve using the slide valve on the deadman handle</li> </ul>
<i>(3) Dry the blasted parts</i>	<ul style="list-style-type: none"> <li>- Close the water supply as well (using the slide valve on the deadman handle)</li> </ul>
<i>(4) Dry blasting</i>	<ul style="list-style-type: none"> <li>- Start the blasting process with air only (press the deadman handle).</li> <li>- Blast media supply (open the metering valve using the slide valve on the deadman handle)</li> </ul>



#### 4.5 Shutdown after finishing work

<i>(1) Blast the blast hose until empty and dry it</i>	<ul style="list-style-type: none"><li>- Close the media metering valve (close the metering valve using the slide valve on the deadman handle)</li><li>- Blast with air and water for around 10 seconds</li><li>- Close the water supply (deactivate the water pump using the slide valve on the deadman handle)</li><li>- Blast with air until no more water mist comes out of the nozzle.</li></ul>
<i>(2) Close the air supply</i>	<ul style="list-style-type: none"><li>- Close the air supply to the water pump and blast machine</li><li>- Close the air supply for the system air</li></ul> <p><i>Follow the instructions in the SC-2048 pressure blast machine owner's manual!</i></p>

#### 4.6 Shutdown when moving equipment

<i>(1) Blast the blast hose until empty and dry it</i>	<ul style="list-style-type: none"><li>- Close the media metering valve (close the metering valve using the slide valve on the deadman handle)</li><li>- Blast with air and water for around 10 seconds</li><li>- Close the water supply (deactivate the water pump using the slide valve on the deadman handle)</li><li>- Blast with air until no more water mist comes out of the nozzle.</li></ul>
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## 5 Maintenance

### 5.1 General

The **W-92 booster pump** of the WET BLAST FLEX is **maintenance-free**. The other components, however, are subject to wear during operation and must undergo regular maintenance in order to ensure safety and efficiency.

**All connections must be closed and the system must be depressurised before starting any maintenance work (see 4.5 and 4.6)!**

## 5.2 Daily check list

(1) KB-52 wet blast head	Check for external and internal wear and leaking water  ⇒ Ring nozzle ⇒ O-ring
(2) Air filter (on the booster pump)	Clean if dirty (sight glass), make sure equipment is fully depressurised beforehand (see 4.5 and 4.6)
(3) Pressure blast machine, hoses & nozzle	<i>Follow the instructions in the SC-2048 pressure blast machine owner's manual!</i>

## 5.3 Weekly check list

Check for dirt on the air filter of the W-92 booster pump (sight glass) and clean if necessary. Make sure equipment is fully depressurised beforehand (see 4.5 and 4.6). Drain water from the filter (slightly open drain during operation). *The instructions in the SC-2048 pressure blast machine owner's manual must also be followed!*

## 5.4 Monthly check list

Check all hose couplings and hoses for wear or breakage and replace them if necessary. Make sure equipment is fully depressurised beforehand (see 4.5 and 4.6). Check water tank for leaks. *The instructions in the SC-2048 pressure blast machine owner's manual must also be followed!*

## 6 Troubleshooting

This section only refers to possible problems with the wet blast system

<b>Symptom</b>	<b>Possible cause</b>	<b>Remedy</b>
(1) W-92 booster pump is not running.	Ball valve closed on wet blast machine and/or on compressor.	Open.
	Compressed air regulator on booster pump set to 0 bar.	Change regulator setting.
(2) W-92 booster pump is running but no water is coming out of the nozzle.	Water tap and/or ball valve on wet blast machine closed.	Open.
	Water tank empty (when using a suction hose).	Refill water tank.
	Dirt trap on W-92 booster pump blocked.	Open and clean.
	Needle valve closed or blocked (limescale deposits).	Open/remove and clean.
(3) Blast machine	<i>The instructions in the SC-2048 pressure blast machine owner's manual must also be followed!</i>	

## 7 Replacement parts

### 7.1 WET BLAST FLEX wet blast machine



**Figure 4:** WET BLAST FLEX components

<i>Item</i>	<i>Stock no.</i>	<i>Description</i>
1	99839D	W-92 booster pump on its own
2	99375D	1/4" filter for W-92
3	99769D	1/4" pressure regulator
4	90285D	1/4" ball valve with internal and external thread
5	01019D	3/8" - 1/4" reducing nipple
6	94263D	1/4" plug connection, external
7	94273D	1/4" elbow no. 90 II
8	99580D	3/4" - 1/2" elbow RG no. 90
9	02462D	1/2" double nipple RG
10	99574D	1/2" dirt trap for W-92
11	99581D	GKA-12 coupling
12	94279D	High-pressure hose
13	24357D	Coupling adapter high-pressure hose

Table 4: WET BLAST FLEX components

7.2 W-92 booster pump

Materialpumpe Material Pump Section fluide			Serie Serie Série		Bestell-Nr. Order-No. Référence	
Typ ND 75 / 42 - R -			001		0619086	
Pos.-Nr. Pos.-No. Code	Best.-Nr. Order-No. Référence	Stück Pièces Pièce	● ○ *	Artikelbezeichnung	Part Description	Désignation des articles
01	0618632	1		Hochdruckkopf	pump head	tête de pompe
(02)	0619701	4		Schraube	screw	vis
03	0618624	1		Druckzylinder	pressure cylinder	cylindre de pression
04	0479608	1		Mutter	nut	écrou
05	0619698	1		Überwurfmutter	swivel nut	écrou-raccord
06	0499242	1		Schraube	screw	vis
07	0622125	1		Kolbenplatte	piston plate	plateau piston
08	0622141	1		Nutring	u-seal	joint en >U<
09	0491799	1	○	Gewindestift	threaded pin	vis-sans-tête
10	0618616	1		Verbindungstange	connecting rod	axe de raccord
11	0485977	1		Mutter	nut	écrou
12	0622169	1	○	Nutring	u-seal	joint en >U<
13	0622133	1	○	Ventilkolbenplatte	valve piston plate	plateau vanne à pointeau
14	0618675	1		Ventilschraube	valve screw	ens. soupape
15	0618640	1		Druckzylinder	pressure cylinder	cylindre de pression
16	0486736	1	○	Dichtung	gasket	joint
17	0486760	1	★ ○	Kugel	ball	bille
18	0486809	1		Zylindersift	cylindrical pin	goupille cylindrique
19	0618667	1		Gehäuse -BV-	housing	corps
	0622958	1	○	Reparatursatz	repair kit	jeu de réparation

Materialpumpe  
Material Pump  
Section fluide

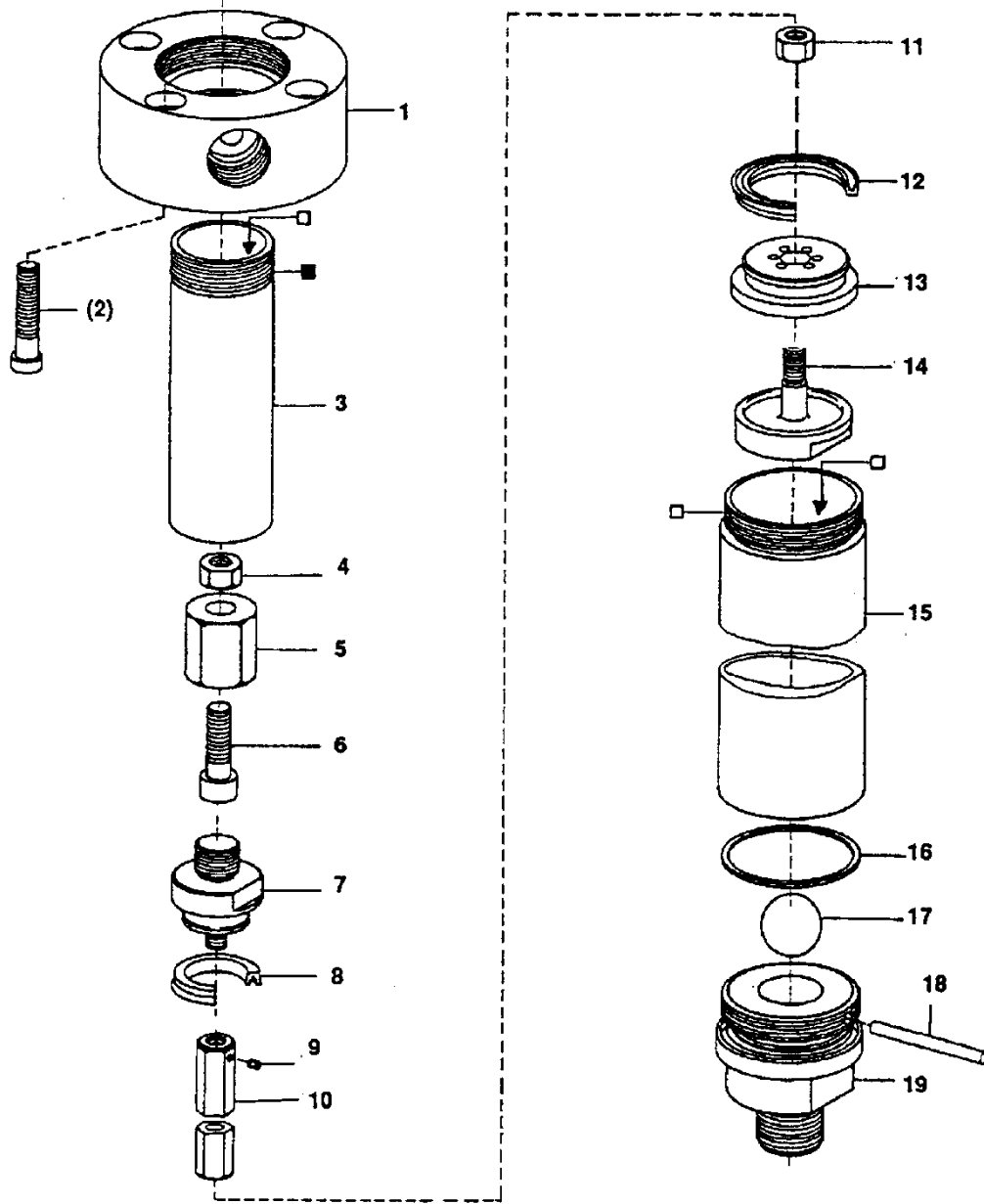
Typ ND 75 / 42 - R -

Serie  
Serie  
Série

001

Bestell-Nr.  
Order-No.  
Référence

0619086



0622958 Reparatursatz  
repair kit  
jeu de réparation  
(Nutting / u-seal / joint en >u<)

3/92

★ = Verschleißteile - Wear parts - Pièces d'usure usuelles  
● = Teile des Dichtungssatzes - Parts of seal kit - Pièces d'kit de joints  
○ = Teile des Reparatursatzes - Parts of repair kit - Pièces d'kit de réparation

■ = Sicherungsmittel 50 ml - Engineering adhesive 50 ml -  
Colle industrielle 50 ml  
□ = Schmiermittel (säurefr. Fett) - Lubrication grease (acid-free) -  
Matière grasse (non acide)

Best.-Nr. 000015  
Best.-Nr. 000025

Pos.-Nr. in Klammern () sind keine Bestandteile dieser Baugruppe - Items marked thus () are not part of assembly shown - Les pièces marquées d'une () ne font pas partie du sous-groupe

<b>Luftmotor</b> <b>Air Motor</b> <b>Moteur pneumatique</b>	<b>Serie</b> <b>Serie</b> <b>Série</b>	<b>Bestell-Nr.</b> <b>Order-No.</b> <b>Référence</b>
<div style="border: 1px solid black; padding: 2px;">Typ D 70 / 42 - 02</div>	<div style="border: 1px solid black; padding: 2px;">004</div>	<div style="border: 1px solid black; padding: 2px;">0470414</div>

Pos.-Nr. Pos.-No. Code	Best.-Nr. Order-No. Référence	Stück Pieces Pièce	● ○ ★	Artikelbezeichnung	Part Description	Désignation des articles
01	0460370	2		Schraube	screw	vis
02	0460508	2		Schraube	screw	vis
	0473820	1		Deckel komplett Position 3-5	cover assembly	couverture complet
03	0470309	1		Deckel	cover	couverture
	0470236	1		ohne Abbildung	not illustrated	non illustré
	0470252	1	★ ○	Dämpfungsscheibe	dampening spacer	rondelle
05	0473162	1	○	Zackenring	washer serrigated	rondelle elastique
06	0470279	1	★ ○	Dämpfungsscheibe	dampening spacer	rondelle
07	0470201	1		Zapfen	bolt	boulon
08	0470147	1		Scheibe	spacer	rondelle
09	0473111	1	★	Mitnehmer komplett	carrier assembly	toc d'entraînement complet
10	0470287	1	★ ○	Dämpfungsscheibe	dampening spacer	rondelle
11	0473170	1	★ ○	Steuerkolben komplett	control piston assembly	piston de contrôle complet
12	0468894	4		Schraube	screw	vis
13	0473189	2		Zylinderstift	cylindrical pin	goupille cylindrique
14	0460591	4		U-Scheibe	washer	rondelle
15	0470368	1		Dämmplatte	dampening plate	silencieux
(16)	0473200	1		Bügelgriff	handle	poignée de transport
17	0460184	2		Mutter	nut	écrou
18	0473812	2		Gewindestift	threaded pin	vis-sans-tête
19	0492701	1		Oberteil komplett	cylinder head assembly	partie supérieur complet
20	0484989	1		Reduziernippel	reducing nipple	raccord de reduction
21	0470120	1		Befüllungsrohr	air inlet pipe	tube d'air
22	0470392	2	● ○	O-Ring	o-ring	joint torique
(23)	***	1		Sicherheitsventil	safety valve	vanne de sécurité
24	0470155	1		Bundbuchse	shoulder bush	frete
25	0470384	1	○	Sicherungsring	retaining ring	circlip
26	0476137	1		Scheibe	spacer	rondelle
27	0310204	1	★ ● ○	Nutring	u-seal	joint en >u<
28	0310190	1	★ ● ○	O-Ring	o-ring	joint torique
29	0610623	1		Kolbenplatte	piston plate	plateau piston
30	0310174	1	★ ● ○	O-Ring	o-ring	joint torique
31	0610631	1	○	Führungsring	guide ring	bague de guidage
32	0610658	1	○	Scheibe	spacer	rondelle
33	0470325	2	★	Schnepper	toggle	bascule
34	0473081	2	★	Schnepperlager	toggle bearing	roulement
35	0617709	2	★	Druckfeder	spring	ressort
36	0470171	2		Lagerbuchse	bearing bush	coussinet
37	0473065	1	★ ○	Umssteuerachse komplett	guide axle assembly	axe de contrôle complet
38	0470104	1	★	Motorachse	motor axle	axe de moteur
39	0310514	1	● ○	O-Ring	o-ring	joint torique
40	0470139	1	★	Zylinder	cylinder	cylindre
41	0310514	1	● ○	O-Ring	o-ring	joint torique
42	0473251	1	○	Sicherungsring	retaining ring	circlip
43	0482625	1	★ ● ○	Führungsbuchse komplett	guide bush assembly	coussinet complet
44	0485268	1		Unterteil komplett	bottom assembly	partie inférieur complet
	0484334	1	●	Dichtungssatz	seal kit	jeu de joints
	0604364	1	○	Reparatursatz	repair kit	jeu de reparation

\*\*\* Bestell-Nummer für Sicherheitsventil siehe Maschinenkarte  
Order number for safety valve see card of machines  
Référence de soupape de sûreté voir carte machine

★ = Verschleißteile - Wear parts - Pièces d'usure usuelles  
● = Teile des Dichtungssatzes - Parts of seal kit - Pièces d'kit de joints  
○ = Teile des Reparatursatzes - Parts of repair kit - Pièces d'kit de reparation

■ = Sicherungsmittel 50 ml - Engineering adhesive 50 ml -  
Colle industrielle 50 ml  
□ = Schmiermittel (säurefr. Fett) - Lubrication grease (acid-free) -  
Matière graisse (non acide)

Best.-Nr. 000015  
Best.-Nr. 000025

Pos.-Nr. in Klammern ( ) sind keine Bestandteile dieser Baugruppe - items marked thus ( ) are not part of assembly's shown - Les pièces marquées d'une ( ) ne font pas partie du sous-groupe

Luftmotor  
Air Motor  
Moteur pneumatique

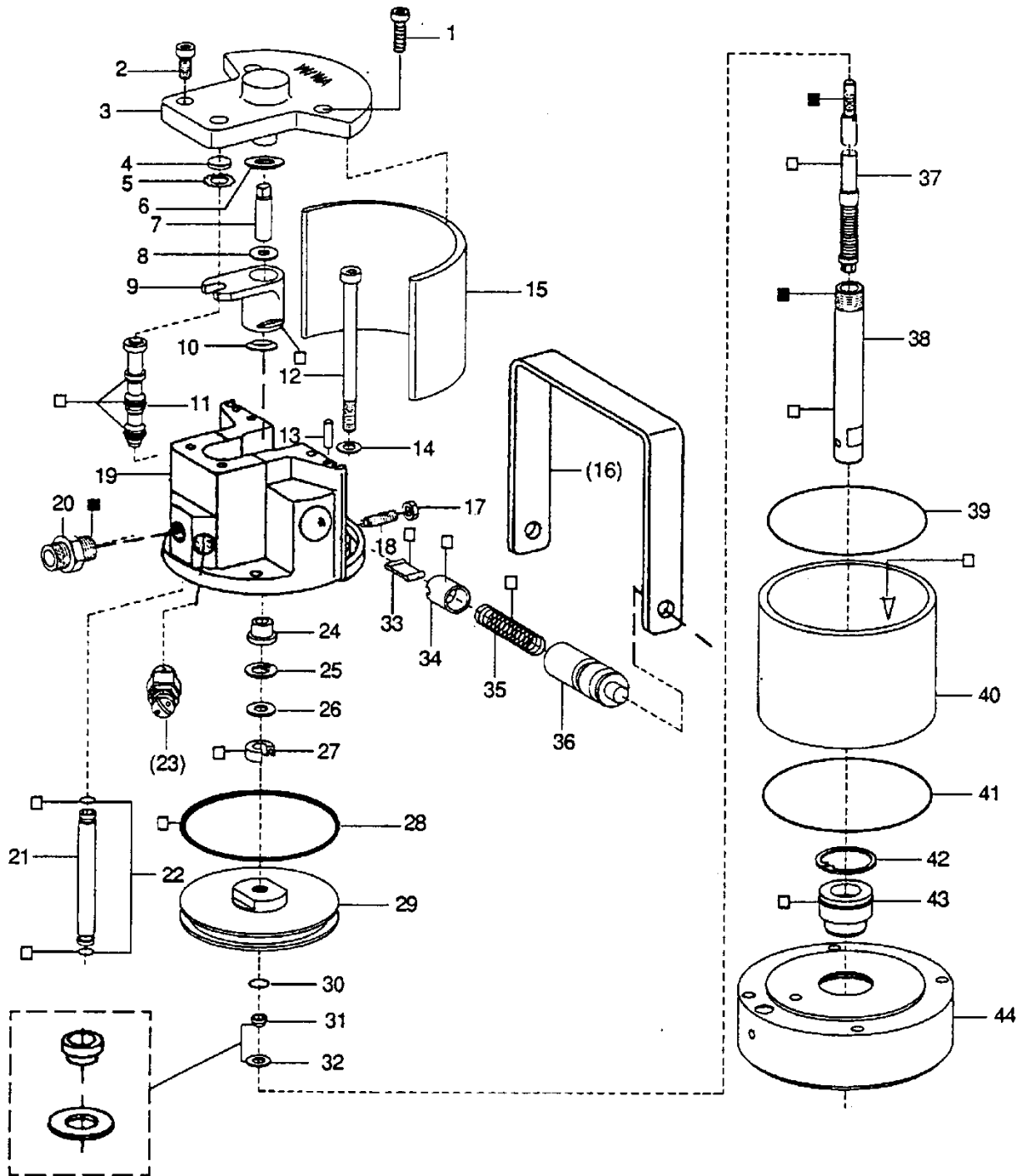
Typ D 70 / 42 - 02

Serie  
Serie  
Série

004

Bestell-Nr.  
Order-No.  
Référence

0470414



0484334 Dichtungssatz  
seal kit  
jeu de joints

0604364 Reparatursatz  
repair kit  
jeu de reparation

10/91

★ = Verschleißteile - Wear parts - Pièces d'usure usuelles  
● = Teile des Dichtungssatzes - Parts of seal kit - Pièces d'kit de joints  
○ = Teile des Reparatursatzes - Parts of repair kit - Pièces d'kit de reparation

■ = Sicherungsmittel 50 ml - Engineering adhesive 50 ml -  
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Matière graisse (non acide)

Best.-Nr. 000015

Best.-Nr. 000025

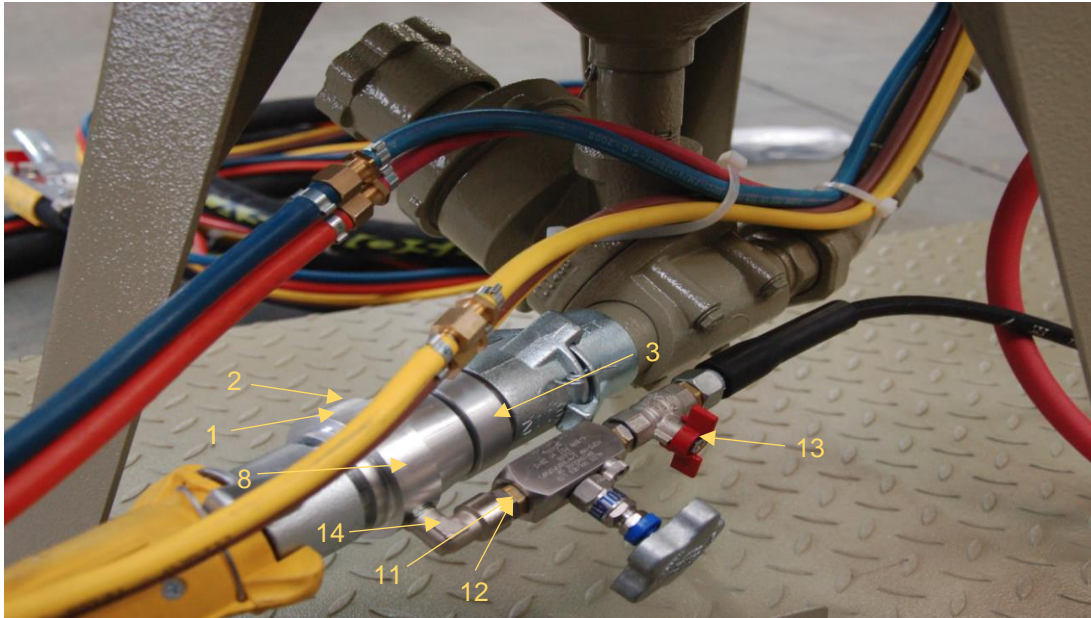
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### 7.3 KB-52 wet blast head

#### 7.3.1 KB-52 wet blast head (for blast hoses larger than 19 x 7)

The WET BLAST FLEX uses the KB-52 wet blast head. Rather than being mounted on the front of the nozzle as in its original application, the wet blast head is mounted behind the media metering valve. This ensures that the water does not mix with the blast media before reaching the blast hose.



**Figure 5:** KB-52 wet blast head with ball valve and needle valve

<i>Item</i>	<i>Stock no.</i>	<i>Description</i>
1	90369D	KB-52-1 wet blast head complete with 3 nozzles
2	93129D	Housing for KB-52 or KB-52-1 wet blast head
3	90630D	Steel ring for KB-52 (ring nozzle)
4	90371D	Steel ring for KB-52-1
5	100036	KB-52-1 water nozzle with bore hole
6	90372D	KB-52-1 water nozzle without bore hole (2 required)
7	00854D	Seal (blast hose side)
8	94322D	Needle valve for KB-52
9	94349D	Seal (nozzle side)
10	90631D	O-ring for ring nozzle
11	01020D	3/8" double nipple, brass
12	01019D	3/8" - 1/4" reducing nipple, brass
13	99917D	3/8" ball valve, 50 bar
14	90061D	3/8" elbow IE
15	99639D	Double nipple, 2" coarse thread (option to install the wet blast head in the centre of the hose)

**Table 5:** KB-52 wet blast head with ball valve and needle valve