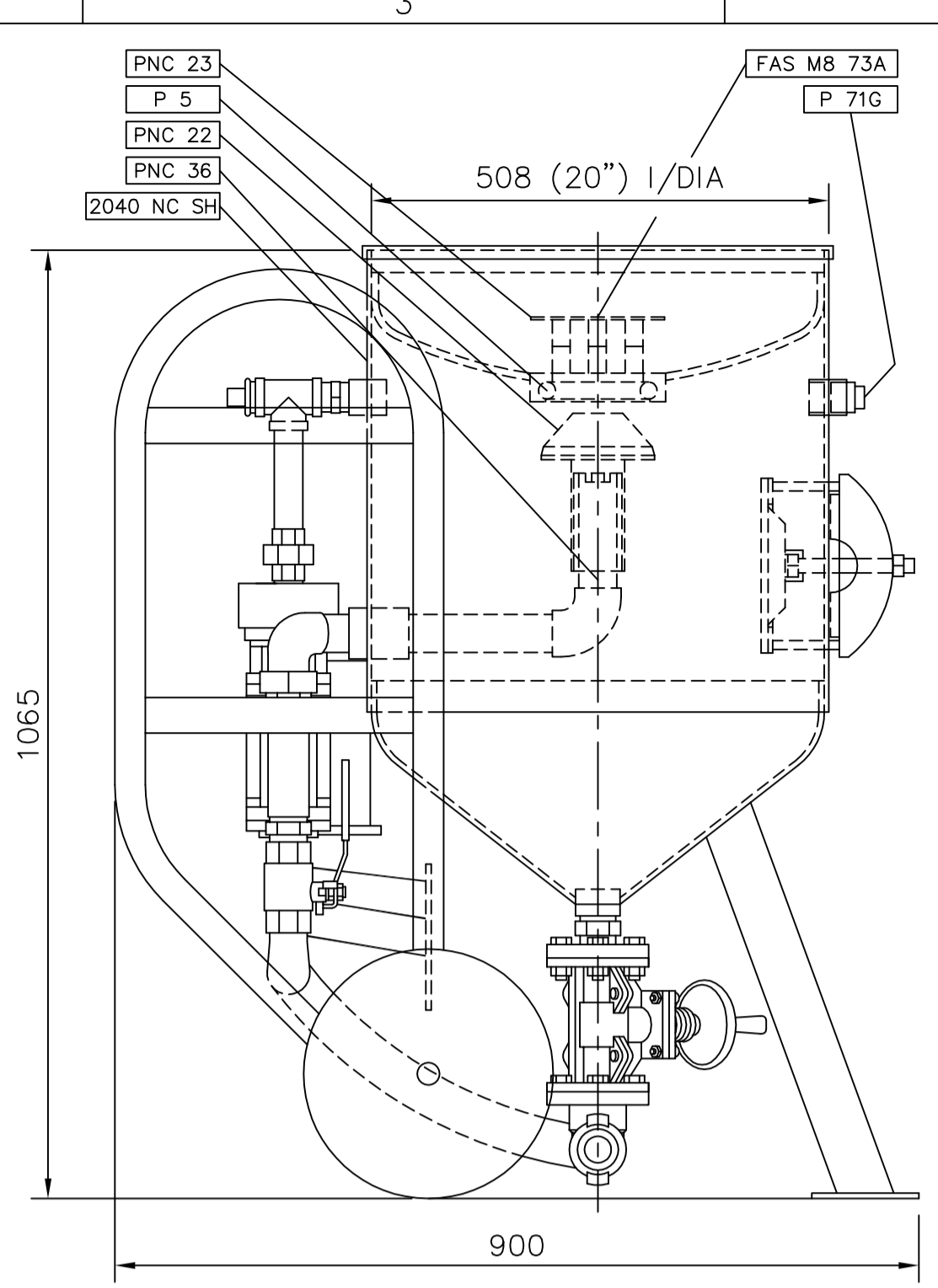
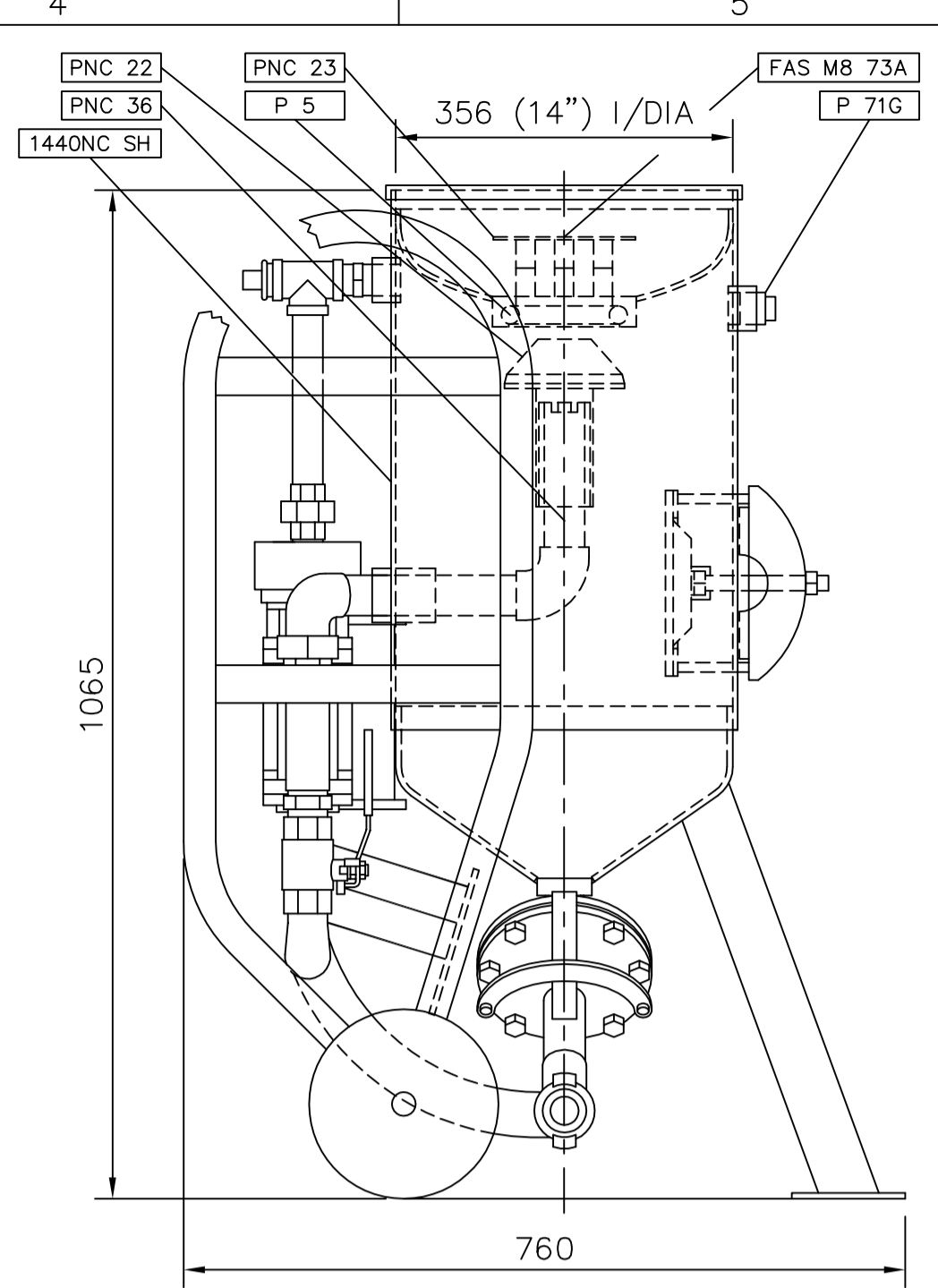


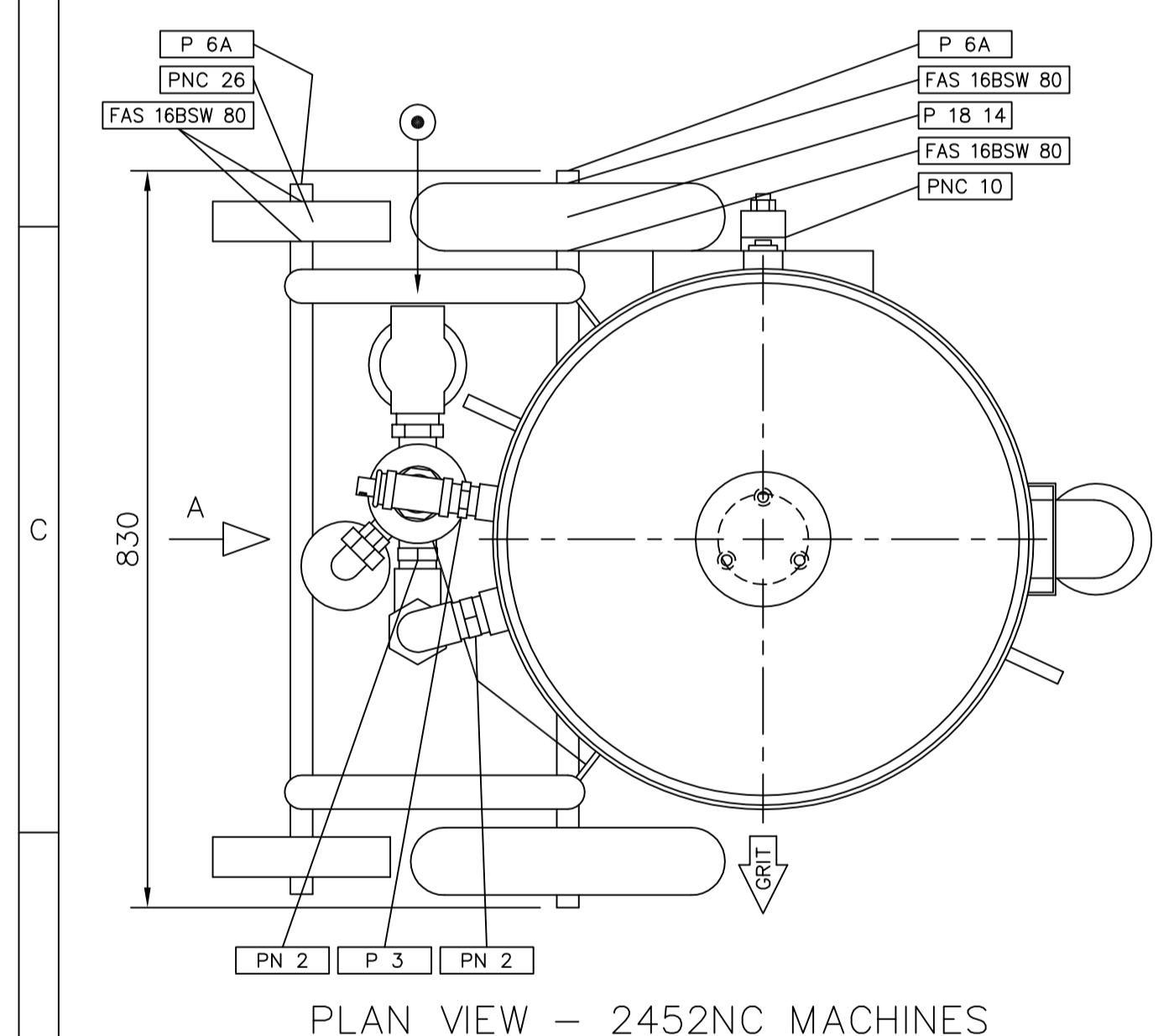
SIDE VIEW - 2452NC MACHINES



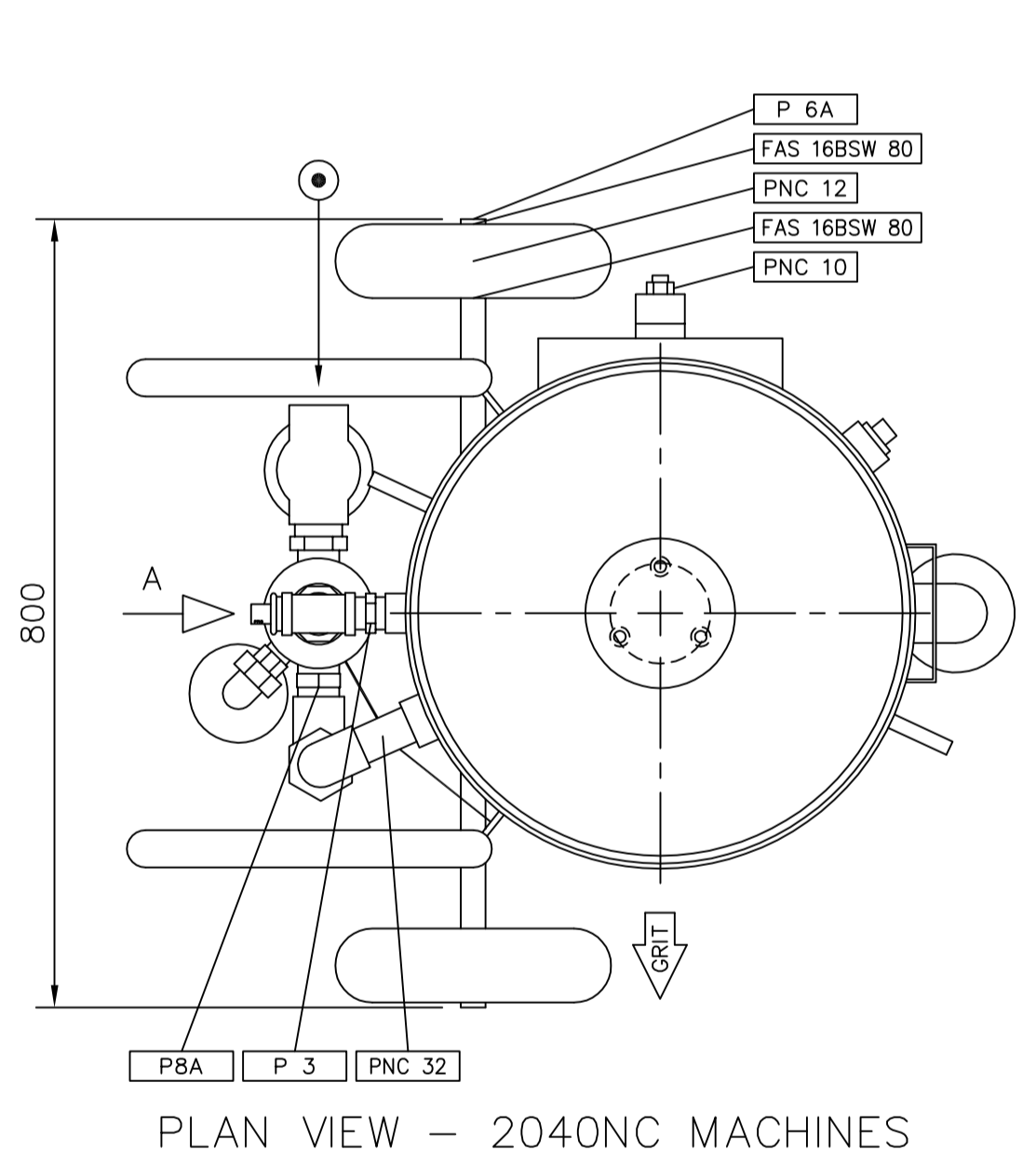
SIDE VIEW - 2040NC MACHINES



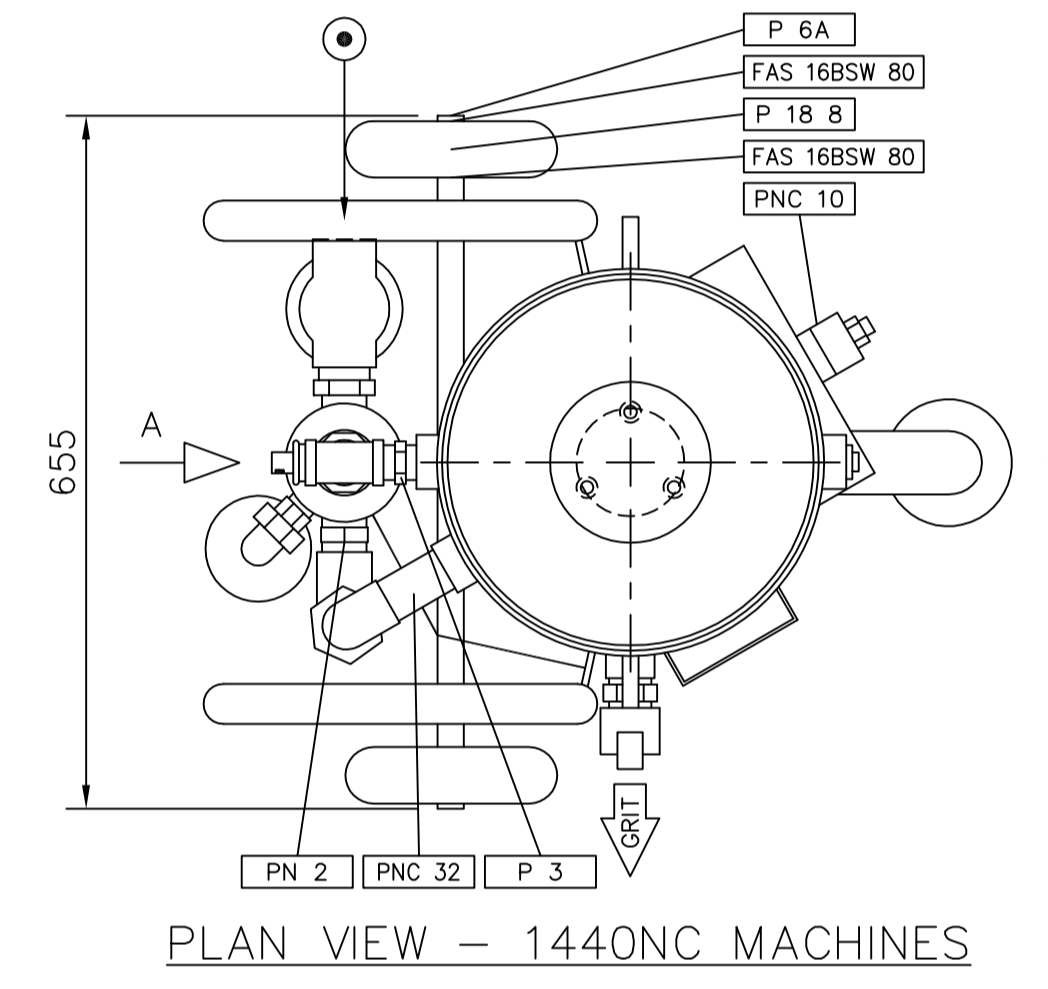
SIDE VIEW - 1440NC MACHINES



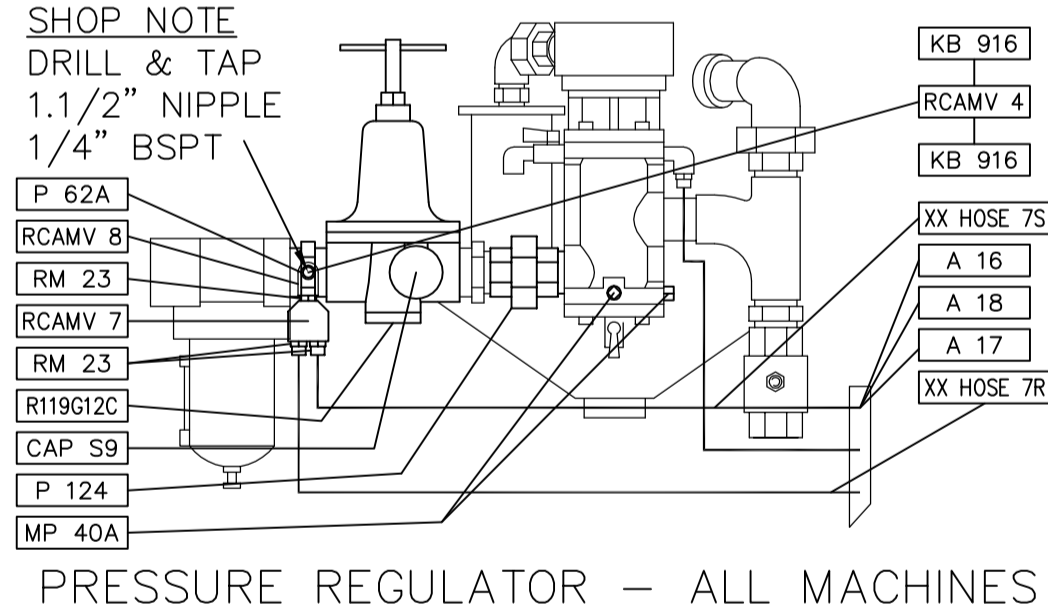
PLAN VIEW - 2452NC MACHINES



PLAN VIEW - 2040NC MACHINES



PLAN VIEW - 1440NC MACHINES

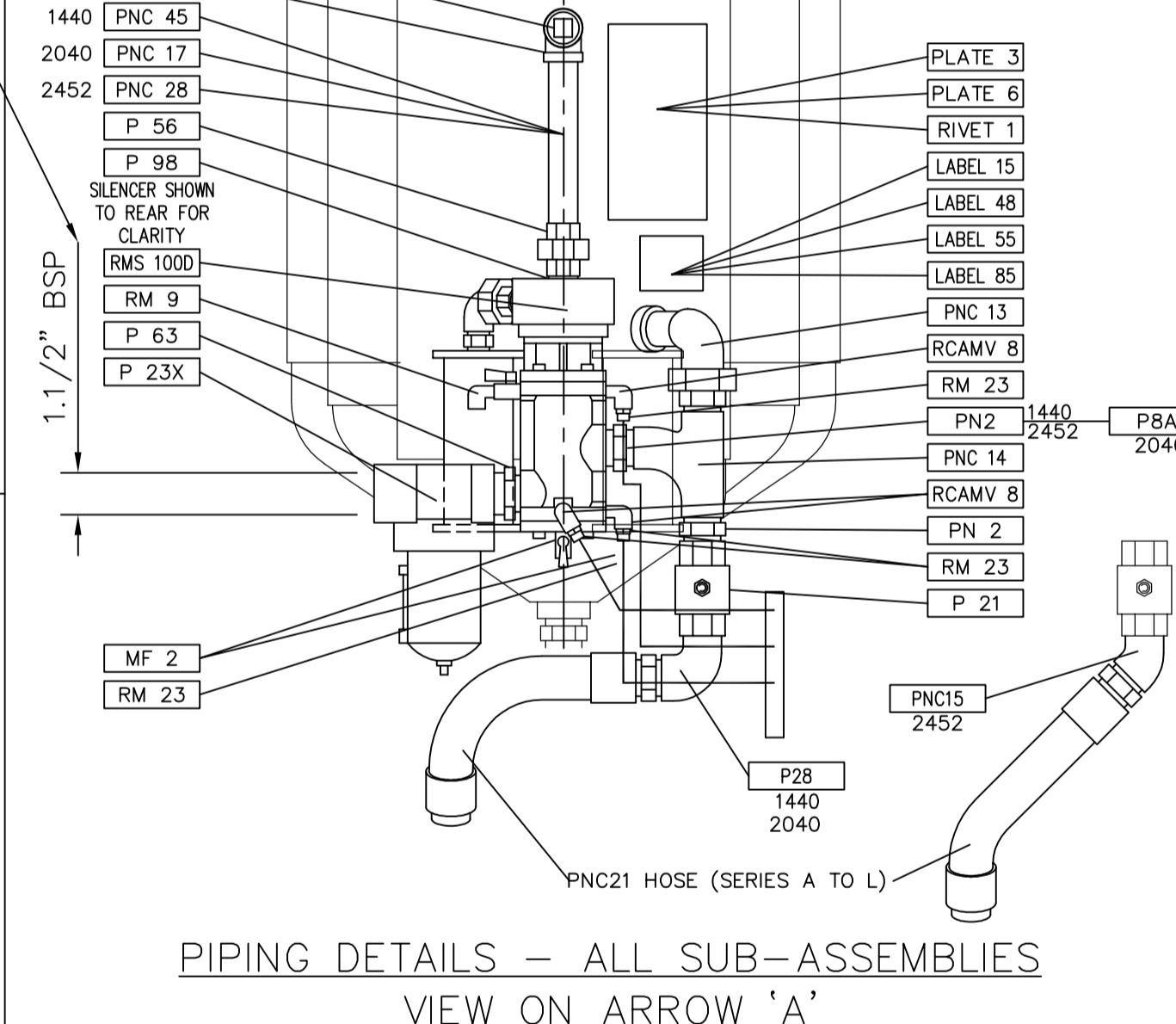


PRESSURE REGULATOR - ALL MACHINES

| PROD. CODE | DESCRIPTION | PROD. CODE | DESCRIPTION | PROD. CODE | DESCRIPTION |
|------------|----------------------------------|------------|---------------------------------|--------------|-------------------------------------|
| PNC 17 | PIPE - 1" NB x 140 LG | P 25 | SAFETY EDGING TRIM | 1440NC SH | CONTRACTOR SHELL |
| PNC 22 | POP UP VALVE ASSEMBLY | P 28 | ELBOW 1.1/4"x90" M&F M.I. | 2040 NC SH | CONTRACTOR SHELL |
| PNC 23 | UMBRELLA FOR NC TYPE MACHINE | P 29 | BAFFLE GRIT PIPE | 2452 NC SH | CONTRACTOR SHELL |
| PNC 26 | WHEEL 200mm DIA FOR 2452NC | P 3 | NIPPLE 1" M.I. | A 16 | TAILPIECE 1/4" |
| PNC 28 | PIPE - 1" NB x 230 LG | P 5 | SEALING RING | A 17 | O CLIP 1/2" |
| PNC 32 | PIPE - 1.1/4" NB x 85 LG | P 56 | UNION 1" FEM M.I. | A 18 | UNION NUT BRASS 1/4" |
| PNC 36 | POP UP VALVE STEM 2040NC | P 62 | NIPPLE 1.1/2" M.I. | CAP S9 | GAUGE-AIR PRESSURE |
| PNC 38 | POP UP VALVE STEM 2452NC | P 62A | NIPPLE 1.1/2" D&T HEX 1/4" M.S. | FAS 16BSW 80 | WASHER - 1" PLAIN |
| PNC 45 | PIPE - 1" NB x 200 LG | P 63 | NIPPLE 1.1/2" x 1.1/4" M.I. | FAS 8BSW 11 | SET SCREW 1/2" |
| R119G12C | REGULATOR 1.1/2" T-HANDLE ADJUST | P 65 | PIPE - 1.1/4" NB x 125 LG | FAS 8BSW 3 | BOLT 1/2" |
| RCAMV 2 | LOWER FLANGE & TEE 1.1/4" | P 68 | ELBOW 1.1/4"x90" FEM M.I. | FAS 8BSW 80 | WASHER |
| RCAMV 4 | BULKHEAD ADAPTOR 1/4" C/W NUT | P 6A | COTTER PIN-SPLIT 40mm | FAS 8BSW 90 | NUT 1/2" |
| RCAMV 7 | TWINBLOCK 1/4" | P 7 | VALVE-EXPENDABLE ABR/METERING | FAS M8 73A | SCREW - PAN HEAD x 40 LG BZP |
| RCAMV 8 | ELBOW 1/4" BR M/F | P 71G | PLUG 1" M.I. | HD 004 | CLAMP - 2 BOLT 1.1/4" HOSE |
| RCAMV 9 | ADAPTOR 1/4" x 1/8" BR | P 8 | Y PIECE 1.1/4" FEM M.I. R/LINED | IND 11096 | GRIT VALVE N/C |
| RIVET 1 | HAMMER DRIVE RIVET | P58 | TEE 1" FEM M.I. | KB 916 | SEAL - 1/4" DOWTY |
| RM 23 | ADAPTOR 1/4"x1/4" | P 8A | NIPPLE 1.1/4" F.S. 3000# | LABEL 15 | LABEL - CONTRACTOR PATENT |
| RM 42 | ADAPTOR 1/4" FEMALE | P 8A 6 | NIPPLE 1.1/4" F.S. 6000# | LABEL 48 | LABEL - EAR PROTECTION WARNING |
| RM 67 | ELBOW 1/8" FEMALE | P 8A 6S | NIPPLE 1.1/4" F.S. MACHINED | LABEL 55 | LABEL - C.E. |
| RM 69 | NIPPLE 1/8" | P 11 | COUPLING 1.1/4" FOR BLAST M/C | LABEL 85 | LABEL - BLAST CLEANING WARNING |
| RM 9 | PETCOCK - 1/4" | P 98 | NIPPLE 1" x 3/4" M.I. MACHINED | MF 2 | TAP - 1/4" M & F PLATED |
| RMS 100D | RECOVA VALVE W/SILENCER ASS'Y | PLATE 3 | NAMEPLATE - WARNING | MP 40A | PLUG 1/4" M.S. GALV. |
| SGV 2 | UPPER FLANGE | PLATE 6 | NAMEPLATE - VESSEL I.D. | MPC 210 | VALVE ABRASIVE METERING 1.1/4" MALE |
| STC 15 | ADAPTOR - 1.1/4" TAIL & MALE | PN 2 | NIPPLE 1.1/4" M.I. | P 124 | UNION - 1.1/4" M&F M.I. |
| XX HOSE 4C | BLAST HOSE - HODGE x1.1/4" I/D | PNC 10 | INSPECTION DOOR ASSY COMPLETE | P 17 | STEEL GRIT VALVE |
| XX HOSE 7 | HOSE - AIR 1/4" I/D (BLUE) | PNC 12 | WHEEL 11" RUBBER TYRED-NC2040 | P 18 14 | WHEEL 14" DIA. RUBBER TYRED |
| XX HOSE 7R | HOSE - AIR 1/4" I/D (RED) | PNC 13 | ELBOW UNION 1.1/4" M&F M.I. | P 18 8 | WHEEL 8" DIA. RUBBER TYRED |
| XX HOSE 7S | HOSE - BREATHING AIR 6mm I/D | PNC 14 | TEE PITCHER 1.1/4" M.I. | P 21 | VALVE 1.1/4" F BALL VALVE |
| XX HOSE 7Y | HOSE - AIR 1/4" I/D (YELLOW) | PNC 15 | ELBOW 1.1/4"x45" M&F M.I. | P 23X | WATER SEP/AIR FILTER 1.1/2" |

NOTE: CUSTOMER TO PURCHASE AIR INLET FITTINGS TO SUIT THEIR AIR HOSES

| ASSEMBLY PART NUMBERS | | | | |
|----------------------------|-----------------|-----------------|-----------------|-----------------|
| VALVE | MODEL No | 1440NC VERSIONS | 2040NC VERSIONS | 2452NC VERSIONS |
| FLAT SAND VALVE | 1440NC FSV R | 2040NC FSV R | 2452NC FSV R | |
| MINOR GRIT VALVE | 1440NC MPC210 R | 2040NC MPC210 R | 2452NC MPC210 R | |
| STEEL GRIT VALVE | 1440NC SGV R | 2040NC SGV R | 2452NC SGV R | |
| REMOTE CONTROL GRIT VALVE | 1440NC TV R | 2040NC TV R | 2452NC TV R | |
| PRESS. REG. KIT (OPTIONAL) | R119G12C KIT | R119G12C KIT | R119G12C KIT | |



PIPING DETAILS - ALL SUB-ASSEMBLIES
VIEW ON ARROW 'A'

| ISSUE No | MOD. No | DRAWN | CHECKED | DATE |
|----------|----------|---------|---------|----------|
| 7 | 5371 | A.W. | N.D.S. | 01.02.17 |
| 6 | 5238 | A.LEWIS | | 08.10.15 |
| 5 | 5211 | A.LEWIS | | 09.07.15 |
| 4 | 3638 | M.LEE | | 20.07.01 |
| 3 | 3529 | M.LEE | | 15.2.01 |
| 2 | 3520 | M.LEE | | 1.2.01 |
| 1 | ORIGINAL | M.LEE | | 1.11.00 |

GENERAL NOTES

- 1) MATERIAL: COLD ROLLED MILD STEEL SHEET TO BS 1449 GRADE CR4 OR EQUIVALENT; HOT ROLLED MILD STEEL SECTIONS TO BS 4360 GRADE 43A OR EQUIVALENT. FINISH: SELF-COLOUR FOR PAINTING.
- 2) REMOVE ALL SHARP EDGES AND BURRS.
- 3) JOINTS AND CONSTRUCTION TO SUIT MANUFACTURERS' STANDARD PROCESSES.
- 4) DIMENSIONS AND TOLERANCES TO BS 308.
- 5) MACHINED SURFACES UNLESS STATED.
- 6) THREADS TO BS 3643 6H/6g OR BS 21 UNLESS STATED.
- 7) *
- 8) *
- 9) *

WELDING

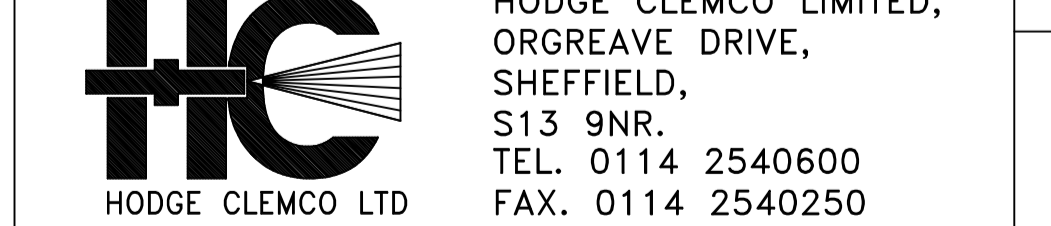
WELDING GENERALLY TO BS 5135 CAT. C & BS 4872 PT. 1 ALL JOINTS & CONNECTIONS OF R.S. SECTIONS CONTINUOUS PLATE TO R.S. SECTION INTERMITTENT 75 WELD 100 GAP

PLATE THICKNESS 1.6; 2.5; 3; 5; 6; 8; 10 12 PLATE OVER 12
WELD SIZE 3 6 10 AS SPECIFIED

| HOLE CENTRES DIAMETER ANGULAR LINEAR | TOLERANCES | |
|---|-------------|-----------|
| | FABRICATION | MACHINING |
| | ±1mm | ±0.25mm |
| | ±3mm | ±0.25mm |
| | ±1° | ±0.5° |
| | ±3mm | ±0.5mm |

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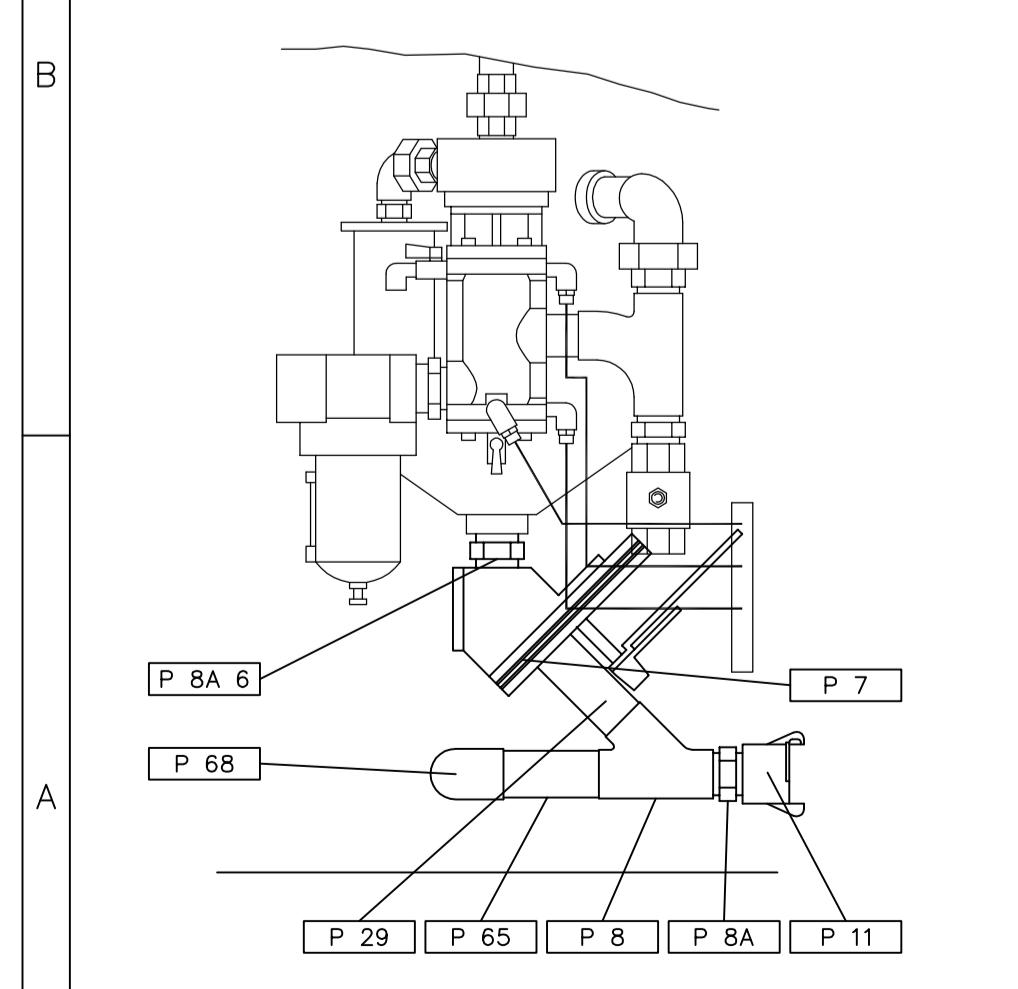
DO NOT SCALE - IF IN DOUBT ASK

TITLE "NC" BLAST MACHINE ASSEMBLIES

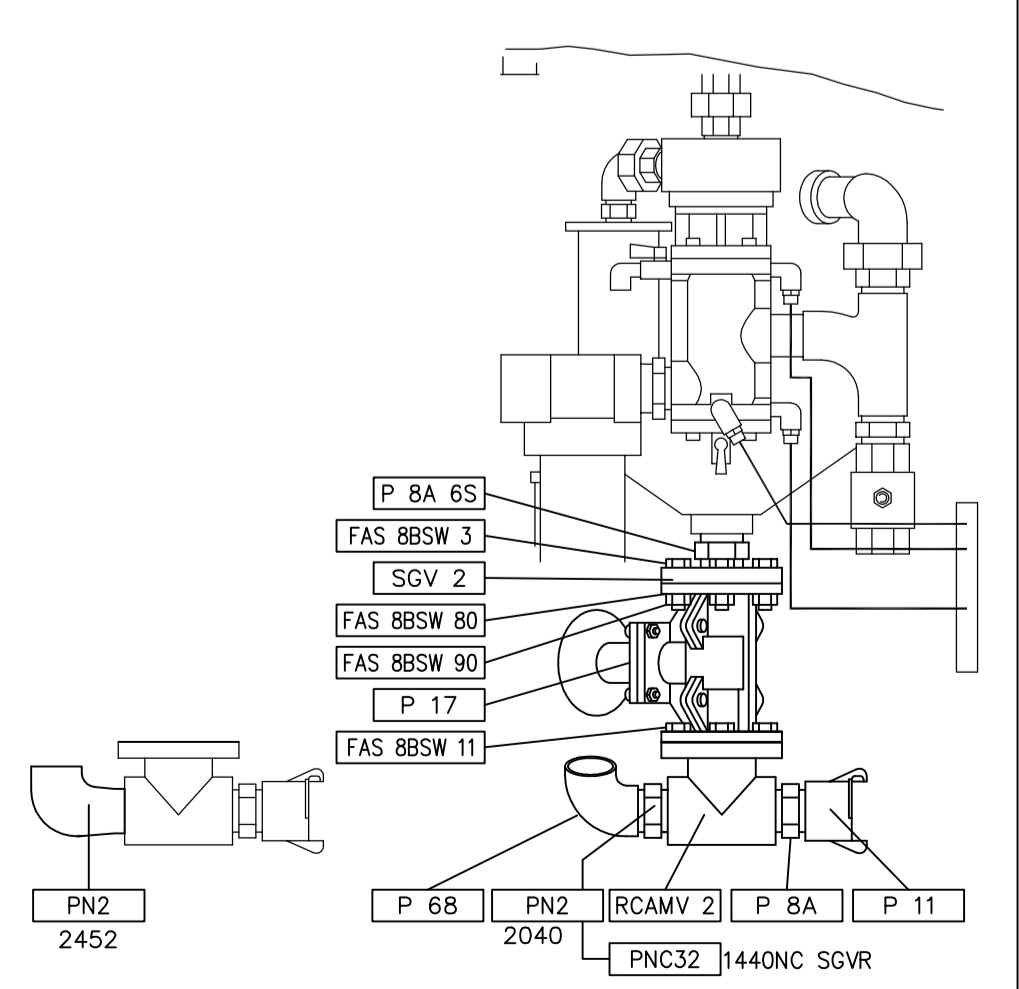
CUSTOMER STOCK

| | | | |
|----------|--------------|--------------|-------------|
| DRAWN ML | DATE 1.11.00 | DIMENSION MM | SCALE 1:7.5 |
|----------|--------------|--------------|-------------|

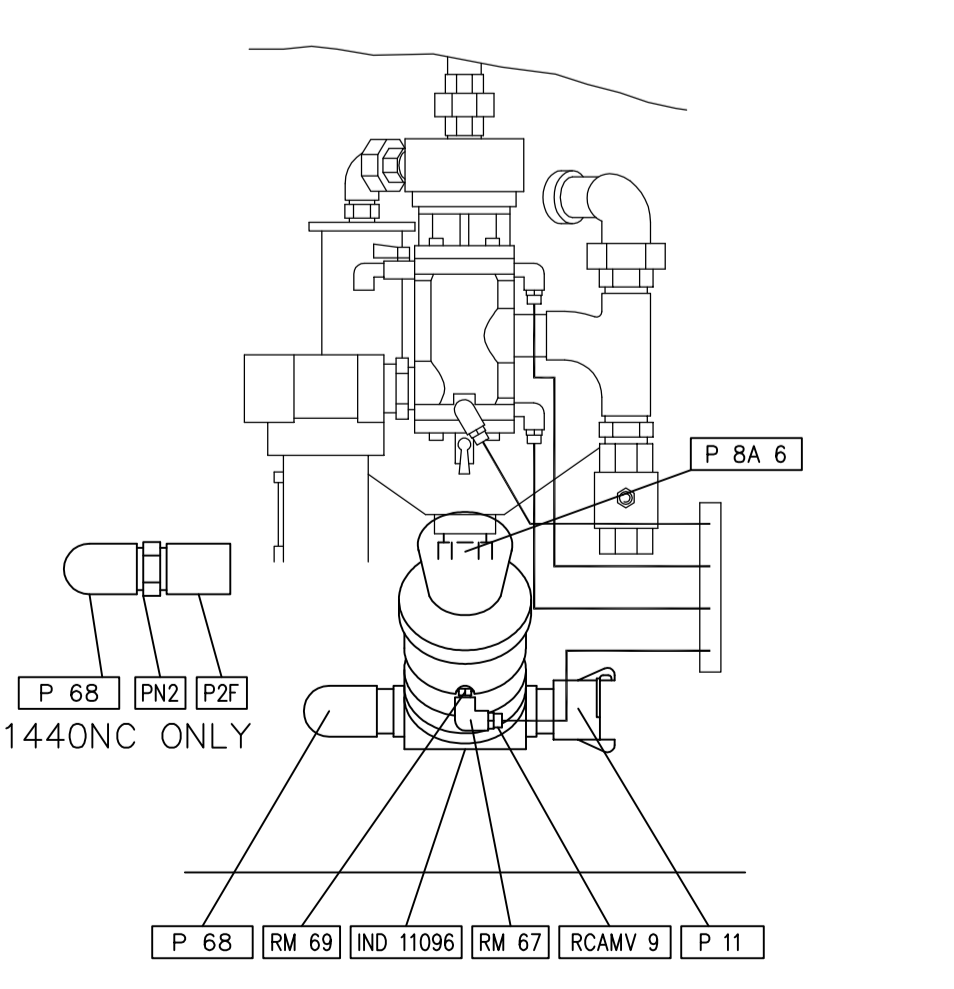
DRAWING No HC-7086 SIZE A1



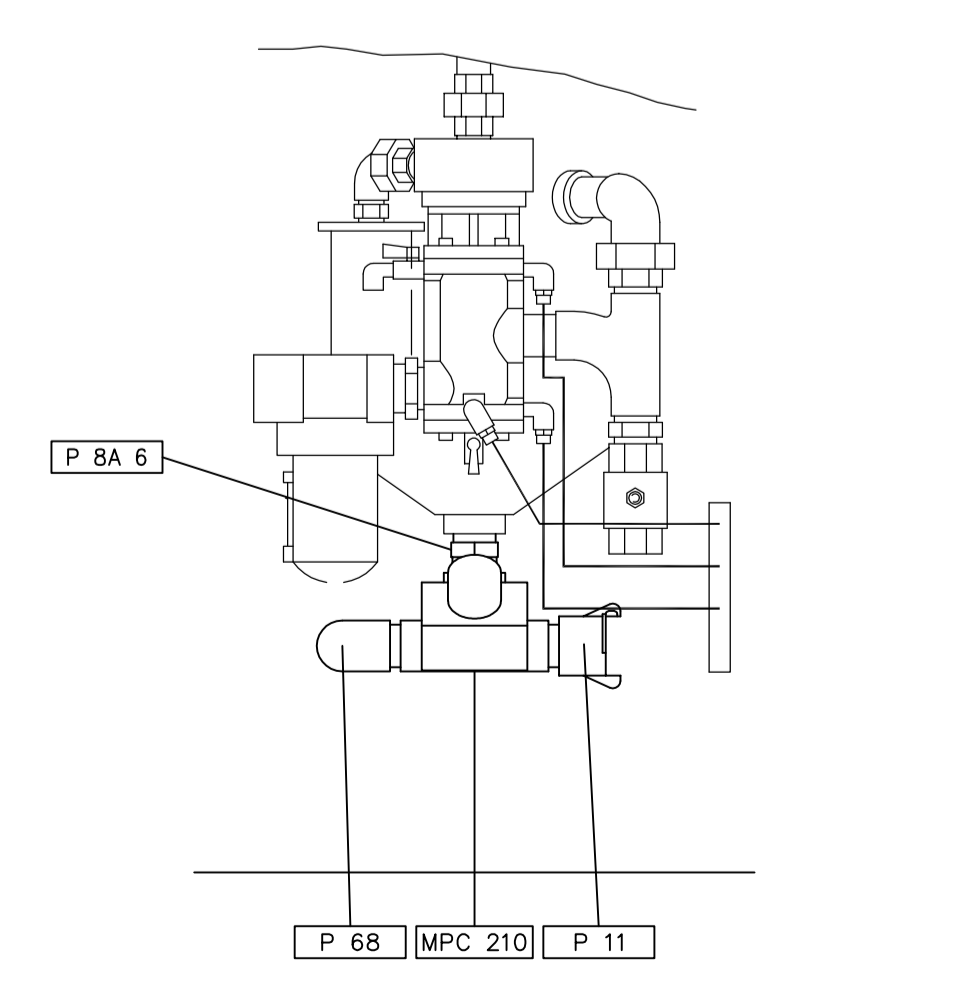
PIPING DETAILS - FLAT SAND VALVE
PART VIEW ON ARROW 'A'



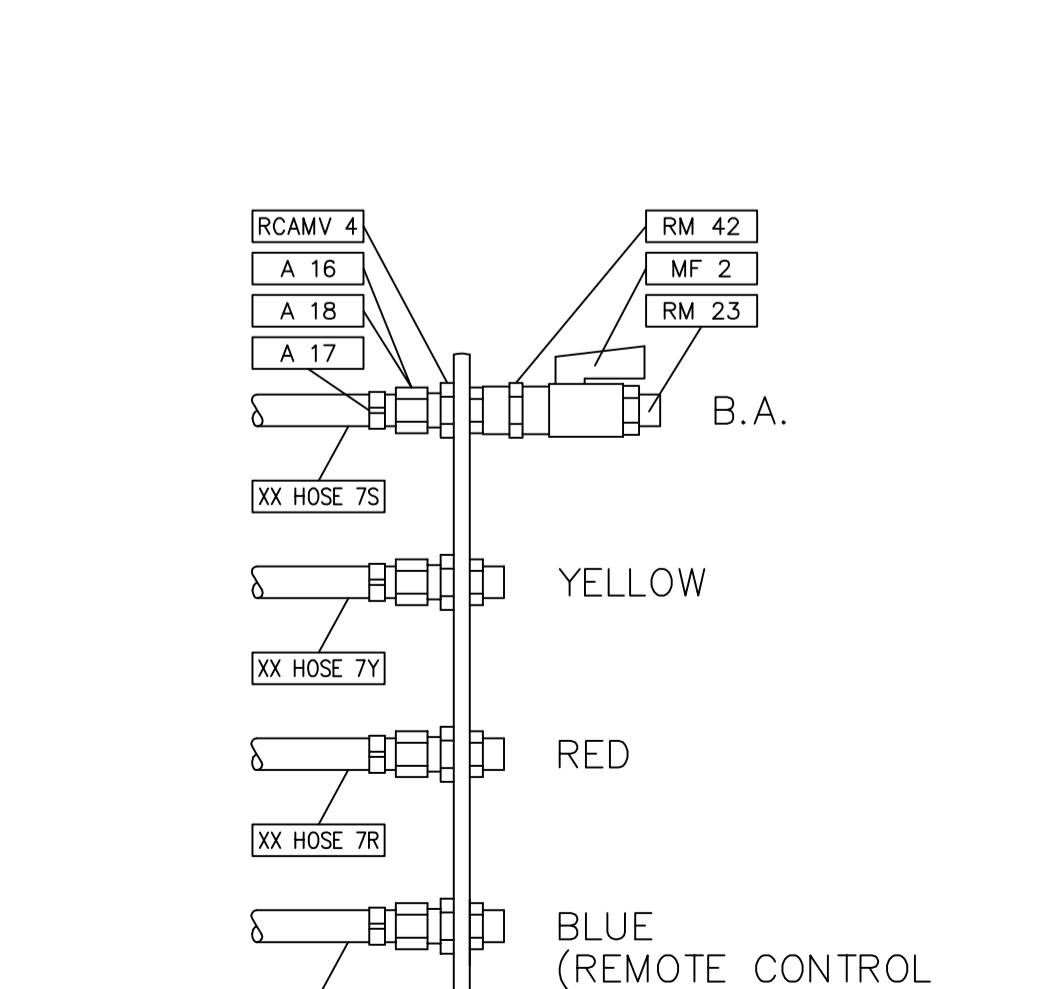
PIPING DETAILS - STEEL GRIT VALVE
PART VIEW ON ARROW 'A'



PIPING DETAILS - REMOTE CONTROL VALVE
PART VIEW ON ARROW 'A'



PIPING DETAILS - MINOR GRIT VALVE
PART VIEW ON ARROW 'A'



ENLARGED LEG MANIFOLD DETAILS