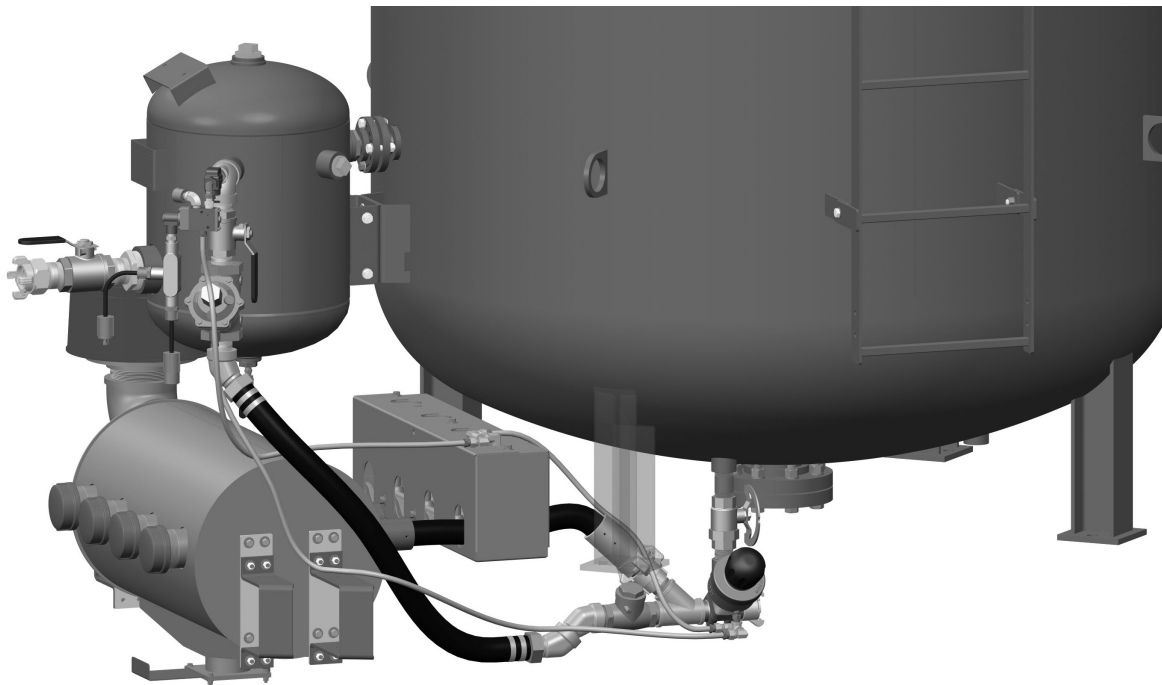


OPERATOR'S MANUAL

MARCO® KWIKSTOP DEPRESSURIZATION SYSTEM



⚠ WARNING

Before using this equipment, read, understand and follow all instructions in the Operator's Manuals provided with this equipment. If the user and/or assistants cannot read or understand the warnings and instructions, the employer of the user and/or assistants must provide adequate and necessary training to ensure proper operation and compliance with all safety procedures pertaining to this equipment. If Operator's Manuals have been lost, please visit www.allredi-us.com, or contact Allredi at 563.324.2519 for replacements. Failure to comply with the above warning could result in death or serious injury.

✓ ALLREDI™

Company Profile

Allredi was formed in the early 2020, when two of the largest distributors in the blasting, coating, safety, and environmental industry, APE Companies and Marco Group International, joined forces. While the qualities both companies are known for have not changed, a lot about our business is new. New abilities. New agilities. New ways to help you win. This calls for a new name, Allredi.

This name exemplifies what we have become. It is completely oriented to the needs of our customers. To your needs. It says that when you call us for anything – products, service, expert advice, anything – you can consider it done. Or even better, Allredi done.

We are your right-now supplier. From skills to SKUs, we deliver the goods fast. So you can be more agile every minute, every day. This is who we are. This is what our new name means. Go ahead and expect excellence, because we're bringing it.

Our Mission and Vision

To be the industry's preferred partner in surface preparation solutions through unrivaled technical expertise, customer experience, product availability, and tailored service offerings.

The Allredi Difference

- **Industry Experience** – With Allredi on your team, you have access to expertise which can only come from decades of industry leadership. We have organized our engineering department, production specialists, customer operations, and safety support into a “Center of Competence.” As an Allredi customer, you have access to hundreds of years of cumulative experience related to your operations.
- **Manufacturing Excellence** – Allredi is a U.S. based manufacturer of equipment for the Surface Preparation and Protective Coatings industries. Allredi's engineers benchmark the industry to ensure that we design and manufacture superior products that set the “Gold Standard” for performance, safety, and quality.
- **Legendary Customer Service** – Allredi's legendary customer service team is staffed by friendly, highly-trained individuals who are focused on providing the highest level of product support, order accuracy, and customer satisfaction.
- **Product Availability** – We stock over 10,000 SKU's and have over 45 shipping locations to serve North American and International markets for all major brands of blasting, coating, environmental, and safety equipment. Allredi is your right-now supplier, so you can keep your projects moving. From our foundation of strong relationships, we have built a nationwide network that puts vast inventory and ready service close to our customers. We provide advanced expertise, and we deliver the goods fast – so you can easily access the products and services you need to me more agile every minute, every day.
- **Technology Leadership** – Our website provides: Operator's Manuals, Part Numbers and Schematics Guides, SDS information, and key product features and specifications, providing access to information 24/7.

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DEFINITION OF TERMS

DANGER

This is an example of danger. This indicates an imminently hazardous situation which, if not avoided, will result in death or serious injury.

CAUTION

This is an example of a caution. This indicates a potentially hazardous situation which, if not avoided, may result in minor or moderate injury. It can also be used to alert against unsafe practices.

WARNING

This is an example of a warning. This indicates a potentially hazardous situation which, if not avoided, could result in death or serious injury.

NOTICE

This is an example of a notice. This indicates policy or practice directly related to safety of personnel or protection of property.

HAZARD IDENTIFICATIONS

WARNING

Failure to comply with ANY WARNING listed below could result in death or serious injury.

- ▶ OSHA sets exposure limits to protect workers from exposure to respirable crystalline silica, 29 CFR 1910.1053. Airborne dust could increase the exposure levels beyond permissible limits. Breathing dust containing silica could cause silicosis, a fatal lung disease. Breathing dust during abrasive blasting operations, post-blast cleaning operations, and/or servicing equipment within the abrasive blasting area may expose an individual to conditions that could cause asbestosis, lead poisoning and/or other serious or fatal diseases. Harmful dust containing toxic material from abrasives or surfaces being abrasive blasted can remain suspended in the air for long periods of time after abrasive blasting has ceased. A NIOSH-approved, well-maintained, respirator designed for the specific operation being performed must be used by anyone abrasive blasting, handling or using the abrasive, and anyone in the area of the dust.
- ▶ Contact NIOSH and OSHA offices to determine the proper respirator for your specific application. The air supplied to the respirator must be at least Grade D quality as described in Compressed Gas Association Commodity Specification G-7.1 and as specified by OSHA Regulation 1910.134. Ensure air filter and respirator system hoses are not connected to non-air sources or in-plant lines that may contain nitrogen, oxygen, acetylene or other non-breathable gases. Before removing respirator, use an air monitoring instrument to determine if the atmosphere is safe to breathe.
- ▶ You must comply with all OSHA, local, City, State, Province, Country and jurisdiction regulations, ordinances and standards, related to your particular work area and environment. Keep unprotected individuals out of the work area.
- ▶ Abrasive blasting operators must receive thorough training on the use of abrasive resistant attire which includes: supplied-air respirator, abrasive blasting suit, safety shoes, gloves, ear protection and eye protection. Protect the operator and bystanders by complying with NIOSH and OSHA Safety Standards.
- ▶ Inspect all equipment for wear or damage before and after each use. Failure to use Original Equipment Manufacturer repair parts and failure to immediately replace worn or damaged components could void warranties and cause malfunctions.
- ▶ OSHA requires abrasive blasting nozzles be equipped with an operating valve, which shall be designed to be held open only by continuous hand pressure and shall close immediately upon release of hand pressure (i.e., a “deadman” control). The valve shall not be modified in any manner that would allow it to remain open without the application of continuous hand pressure by the operator. Failure to comply with the above warning could result in release of high speed abrasive and compressed air resulting in death or serious injury. OSHA 29CFR 1910.244(b)
- ▶ Point the abrasive blasting nozzle only at the surface being abrasive blasted. Never point the abrasive blasting nozzle or abrasive stream at yourself or others.
- ▶ Unless otherwise specified, maximum working pressure of abrasive blasting pots and related components must not exceed 150 psi. Exceeding maximum working pressure of 150 psi could cause the abrasive blasting pot and components to burst. Failure to comply with the above warning could result in death or serious injury.
- ▶ Never weld, grind or drill on the abrasive blasting pot (or any pressure vessel). Doing so will void ASME certification and manufacturer’s warranty. Welding, grinding or drilling on the abrasive blasting pot (or any pressure vessel) could weaken the vessel causing it to burst. Failure to comply with the above warning could result in death or serious injury. (ASME Pressure Vessel Code, Section VIII, Division 1)
- ▶ This equipment is not intended for use in any area that might be considered a hazardous location, as described in the National Electric Code NFPA 70, Article 500. Use of this equipment in a hazardous location could cause an explosion or electrocution.
- ▶ Never attempt to move an abrasive blasting pot containing abrasive. Never attempt to manually move abrasive blasting pots greater than 6.5 cubic foot capacity. Always use at least two capable people to manually move an abrasive blasting pot on flat, smooth surfaces. A mechanical lifting device must be used if an abrasive blasting pot is moved in any other manner.

HAZARD IDENTIFICATIONS

WARNING

Failure to comply with ANY WARNING listed below could result in death or serious injury.

- ▶ This product is not for use in wet environments. Always use a Ground Fault Interrupter Circuit (GFIC) for all electrical power source connections. Use of this product in wet environments could create a shock or electrocution hazard.
- ▶ Frozen moisture could cause restrictions and obstructions in pneumatic control lines. Any restriction or obstruction in the pneumatic control lines could prevent the proper activation and deactivation of the remote control system, resulting in the release of high speed abrasive and compressed air. In conditions where moisture may freeze in the control lines an antifreeze injection system approved for this application can be installed.
- ▶ Do not cut, obstruct, restrict or pinch pneumatic control lines. Doing so could prevent the proper activation and deactivation of the remote control system, resulting in the release of high speed abrasive and compressed air.
- ▶ Use of Marco remote control switches with other manufacturer's remote control systems could cause unintended activation of remote control systems resulting in the release of high speed abrasive and compressed air. Only Marco remote control switches should be used with Marco remote control systems.
- ▶ Always be certain to have secure footing when abrasive blasting. There is a recoil hazard when abrasive blasting starts that may cause user to fall and misdirect the abrasive stream at operator or bystander.
- ▶ Never use an abrasive blasting pot or attachments as a climbing device. The person could slip and fall. The abrasive blasting pot could become unstable and tip over.
- ▶ For equipment manufactured by entities other than Allredi, you must consult the Original Equipment Manufacturer operator's manuals, information, training, instructions and warnings, for the proper and intended use of all equipment.
- ▶ Flammable fumes, such as solvent and paint fumes in the work area can present an ignition or explosion hazard if allowed to collect in adequate concentrations. To reduce conditions that could result in a fire or an explosion, provide adequate ventilation, eliminate all ignition or spark sources, keep the work area free of debris, store solvents and solvent contaminated rags in approved containers, follow proper grounding procedures, do not plug/unplug power cord or turn on/off power switches when flammable fumes are present, keep a working fire extinguisher or provide another fire suppression system in the work area. Cease all operations and correct condition if a spark or ignition source is identified during operation.
- ▶ Always depressurize the entire system, disconnect all power sources and lockout/tagout all components before any maintenance or troubleshooting is attempted. Failure to comply with the above warning could cause electrical shock and inadvertent activation of equipment resulting in death or serious injury.
- ▶ Moving parts can present an area where crushing, pinching, entanglement or amputation may occur. Do not place body parts or foreign objects in any area where there are moving parts.
- ▶ Surfaces of heated supply tanks, drums and/or lines as well as the adjoining plumbing may become hot during normal use. Do not touch these heated surfaces without proper protection. Deactivate and allow sufficient time for all surfaces to cool before attempting any maintenance.
- ▶ High-pressure fluid from gun, hose leaks, or ruptured components can pierce skin and can cause a serious injury that may result in amputation. Do not point gun or spray tip at anyone or at any part of the body. Keep clear of any leaks or ruptures. Depressurize the entire system before attempting cleaning, inspecting, or servicing equipment.
- ▶ Exposure to toxic fluids or fumes may occur during the normal operation of this system. Before attempting to fill, use, or service this system, read SDS's to know the specific hazards of the fluids you are using. Always use proper Personal Protective Equipment when attempting to fill, use, or service this system.
- ▶ The use of this product for any purpose other than originally intended or altered from its original design is prohibited.
- ▶ Never hang objects from the abrasive blasting pot handle. Doing so may cause the abrasive blasting pot to become unstable and tip over.

HAZARD IDENTIFICATIONS

⚠ CAUTION

Failure to comply with ANY CAUTION listed below may result in minor or moderate injury.

- ▶ Static electricity can be generated by abrasive moving through the abrasive blasting hose causing a shock hazard. Prior to use, ground the abrasive blasting pot and abrasive blasting nozzle to dissipate static electricity.
- ▶ High decibel noise levels are generated during the abrasive blasting process which may cause loss of hearing. Ensure appropriate Personal Protective Equipment and hearing protection is in use.

NOTICE

Failure to comply with ANY NOTICE listed below could pose a hazard to personnel or property.

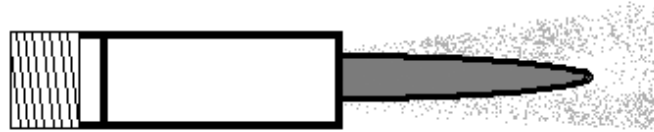
- ▶ See Air & Abrasive Consumption Chart for estimated abrasive consumption rates and required air flow (cubic feet per minute). Your system must meet these minimum requirements to ensure proper function and performance.
- ▶ Always use abrasive that is dry and properly screened. This will reduce the potential for obstructions to enter the remote control system, abrasive metering valve and abrasive blasting nozzle.
- ▶ Moisture build-up occurs when air is compressed. Any moisture within the abrasive blasting system will cause abrasive to clump, clogging metering valves, hoses and nozzles. Install an appropriately sized moisture separator at the inlet of the abrasive blasting system. Leave the moisture separator petcock slightly open to allow for constant release of water. If insufficient volume of air exists and petcock is unable to be left open (at all times) petcock should be opened frequently to release water.
- ▶ To reduce abrasive intrusion in the air supply hose, depressurize the abrasive blasting pot before shutting off air supply from compressor.
- ▶ Inspect abrasive blasting nozzle before placing into service. Damage to abrasive blasting nozzle liner or jacket may occur during shipping. If you receive a damaged abrasive blasting nozzle, contact your distributor immediately for replacement. Abrasive blasting nozzles placed into service may not be returned. Abrasive blasting nozzle liners are made of fragile materials and can be damaged by rough handling and striking against hard surfaces. Never use a damaged abrasive blasting nozzle.
- ▶ Abrasive blasting at optimal pressure for the abrasive used is critical to productivity. Example: For an abrasive with an optimal abrasive blasting pressure of 100 psi at the abrasive blasting nozzle, one pound per square inch of pressure loss will reduce abrasive blasting efficiency by 1.5%. A 10 psi reduction in air pressure will cause a 15% loss of efficiency. Use a Needle Pressure Gauge to identify pressure drops in your system. Consult with your abrasive supplier for the requirements of your abrasive.
- ▶ Replace abrasive blasting nozzle if liner or jacket is cracked or damaged. Replace abrasive blasting nozzle if original orifice size has worn 1/16" or more. Determine abrasive blasting nozzle wear by inserting a drill bit 1/16" larger than original size of abrasive blasting nozzle orifice. If the drill bit passes through abrasive blasting nozzle, replacement is needed.

AIR & ABRASIVE CONSUMPTION CHART

NOTICE

Failure to comply with ANY NOTICE listed below could pose a hazard to personnel or property.

- ▶ See Air & Abrasive Consumption Chart for estimated abrasive consumption rates and required air flow (cubic feet per minute). Your system must meet these minimum requirements to ensure proper function and performance.
- ▶ When it comes to air & abrasive mixtures, more is not necessarily better. Optimum abrasive blasting efficiency takes place when a lean air & abrasive mixture is used. To correctly set the abrasive metering valve, begin with the valve fully closed and slowly increase the amount of abrasive entering the airstream. As you increase the abrasive flow, watch for a “blue flame” at the exit of the abrasive blasting nozzle. Faster cutting, reduced abrasive consumption and lower clean up costs, are benefits of the “blue flame”.
- ▶ Abrasive blasting at optimal pressure for the abrasive used is critical to productivity. Example: For an abrasive with an optimal abrasive blasting pressure of 100 psi at the abrasive blasting nozzle, one pound per square inch of pressure loss will reduce abrasive blasting efficiency by 1.5%. A 10 psi reduction in air pressure will cause a 15% loss of efficiency. Use a Needle Pressure Gauge to identify pressure drops in your system. Consult with your abrasive supplier for the requirements of your abrasive.



NOTICE

Inspect abrasive blasting nozzle before placing into service. Damage to abrasive blasting nozzle liner or jacket may occur during shipping. If you receive a damaged abrasive blasting nozzle, contact your distributor immediately for replacement. Abrasive blasting nozzles placed into service may not be returned. Abrasive blasting nozzle liners are made of fragile materials and can be damaged by rough handling and striking against hard surfaces. Never use a damaged abrasive blasting nozzle.

Air & Abrasive Consumption Chart*

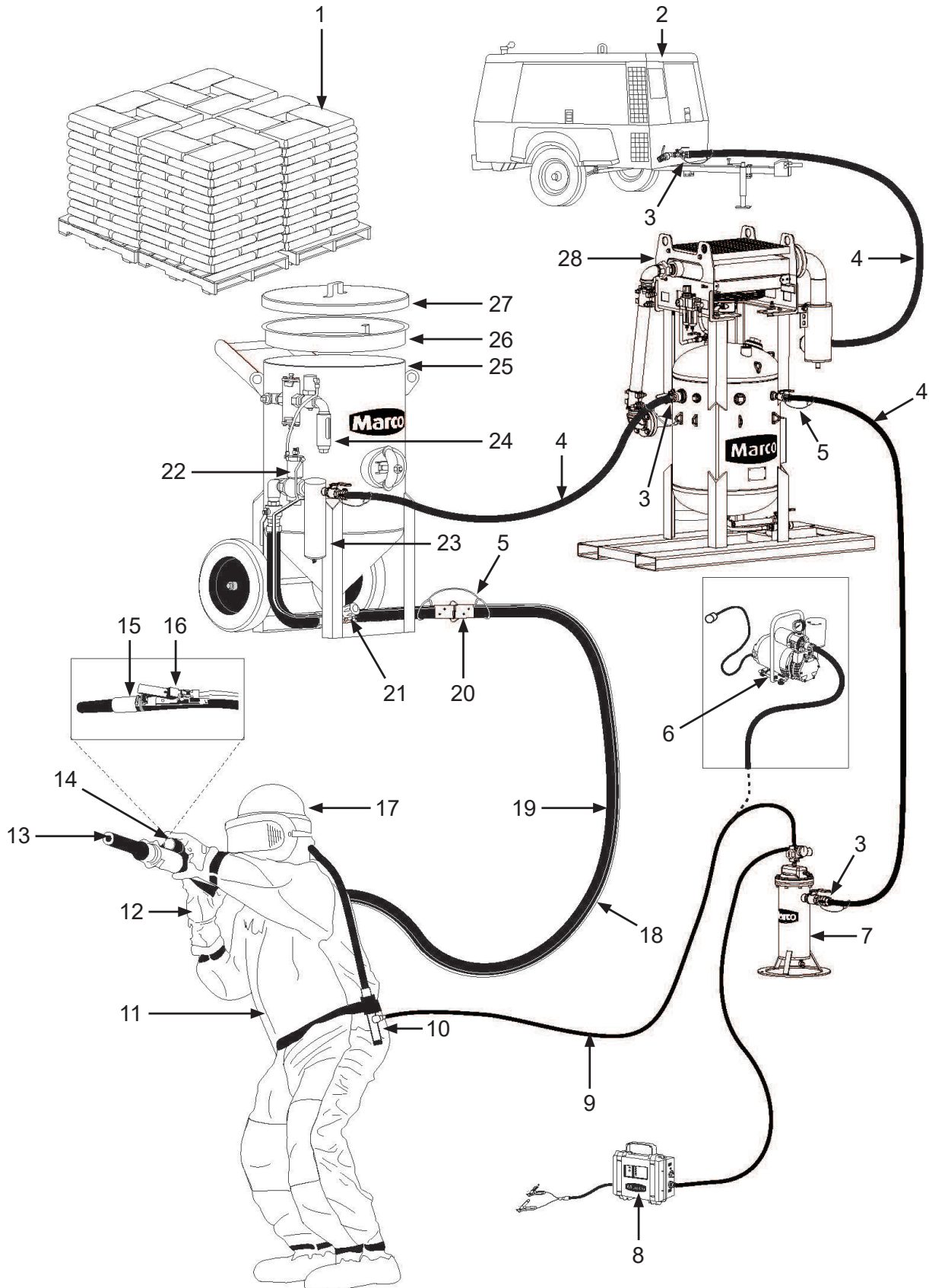
| Nozzle Orifice | Pressure at the Nozzle (PSI) | | | | | | | | Air (in cfm), Abrasive & Compressor Requirements |
|-------------------------|------------------------------|---------------------|--------------------|----------------------|--------------------|----------------------|--------------------|---------------------|---|
| | 50 | 60 | 70 | 80 | 90 | 100 | 125 | 140 | |
| No. 2 (1/8") | 11 67 2.5 | 13 77 3 | 15 88 3.5 | 17 101 4 | 18 112 4.5 | 20 123 5 | 25 152 5.5 | 28 170 6.2 | Air (cfm) Abrasive (lbs/hr) Compressor Horsepower |
| No. 3 (3/16") | 26 150 6 | 30 171 7 | 33 196 8 | 38 216 9 | 41 238 10 | 45 264 10 | 55 319 12 | 62 357 13 | Air (cfm) Abrasive (lbs/hr) Compressor Horsepower |
| No. 4 (1/4") | 47 268 11 | 54 312 12 | 61 354 14 | 68 408 16 | 74 448 17 | 81 494 18 | 98 608 22 | 110 681 25 | Air (cfm) Abrasive (lbs/hr) Compressor Horsepower |
| No. 5 (5/16") | 77 468 18 | 89 534 20 | 101 604 23 | 113 672 26 | 126 740 28 | 137 812 31 | 168 982 37 | 188 1100 41 | Air (cfm) Abrasive (lbs/hr) Compressor Horsepower |
| No. 6 (3/8") | 108 668 24 | 126 764 28 | 143 864 32 | 161 960 36 | 173 1052 39 | 196 1152 44 | 237 1393 52 | 265 1560 58 | Air (cfm) Abrasive (lbs/hr) Compressor Horsepower |
| No. 7 (7/16") | 147 896 33 | 170 1032 38 | 194 1176 44 | 217 1312 49 | 240 1448 54 | 254 1584 57 | 314 1931 69 | 352 2163 77 | Air (cfm) Abrasive (lbs/hr) Compressor Horsepower |
| No. 8 (1/2") | 195 1160 44 | 224 1336 50 | 252 1512 56 | 280 1680 63 | 309 1856 69 | 338 2024 75 | 409 2459 90 | 458 2754 101 | Air (cfm) Abrasive (lbs/hr) Compressor Horsepower |
| No. 10 (5/8") | 308 1875 68.5 | 356 2140 79.5 | 404 2422 90 | 452 2690 100.5 | 504 2973 112 | 548 3250 122 | 663 3932 146 | 742 4405 165 | Air (cfm) Abrasive (lbs/hr) Compressor Horsepower |
| No. 12 (3/4") | 432 2672 96 | 504 3056 112 | 572 3456 127 | 644 3840 143 | 692 4208 154 | 784 4608 174.5 | 948 5570 209 | 1062 6238 236 | Air (cfm) Abrasive (lbs/hr) Compressor Horsepower |

*Abrasive consumption is based on abrasive with a bulk density of 100 lbs per Cubic Foot

NOTICE

Replace abrasive blasting nozzle if liner or jacket is cracked or damaged. Replace abrasive blasting nozzle if original orifice size has worn 1/16" or more. Determine abrasive blasting nozzle wear by inserting a drill bit 1/16" larger than original size of abrasive blasting nozzle orifice. If the drill bit passes through abrasive blasting nozzle, replacement is needed.

"THE BIG PICTURE"



DAILY PRE-OPERATION CHECKLIST

Daily Pre-operation Checklist

- 1. Abrasive
- 2. Air Compressor
- 3. Air Hose Couplings & Gaskets
- 4. Air Hose
- 5. Safety Cable
- 6. Ambient Air Pump*
- 7. Breathing Air Filter
- 8. CO Monitor
- 9. Breathing Line
- 10. Climate Control Device
- 11. Abrasive Blasting Suit
- 12. Gloves
- 13. Abrasive Blasting Nozzle
- 14. Lighting System*
- 15. Abrasive Blasting Nozzle Holder
- 16. Remote Control Switch
- 17. Supplied-Air Respirator
- 18. Control Line
- 19. Abrasive Blasting Hose
- 20. Abrasive Blasting Hose Couplings & Gaskets
- 21. Abrasive Metering Valve
- 22. Remote Control System
- 23. Moisture Separator
- 24. Abrasive Blasting Pot Exhaust Muffler
- 25. Abrasive Blasting Pot
- 26. Abrasive Blasting Pot Screen
- 27. Abrasive Blasting Pot Lid
- 28. Aftercooler*

* *Optional or alternative device.
Ask your Allredi Representative
for more details.*

Abrasive – Select the correct Abrasive (1) for the application. Review the MSDS (*Material Safety Data Sheet*) to ensure the correct PPE (*Personal Protective Equipment*) and Environmental Controls have been selected and are in place.

Air Compressor – Select an Air Compressor (2) of adequate size to support all equipment requirements. Refer to “Air & Abrasive Consumption Chart” for Abrasive Blasting Nozzle (13) air consumption requirements. Before connecting Air Hose (4), sample the air being produced by the air compressor (2) to ensure it is free of petroleum contaminants.

Air Hose, and Air Hose Couplings & Gaskets – Select Air Hoses (4) of sufficient size to support all subsequent volumetric requirements and with a sufficient PSI (*pound per square inch*) rating. Inspect all Air Hoses (4), and Air Hose Couplings & Gaskets (3) for damage or wear. Repair or replace damaged or worn components.

Abrasive Blasting Hose, Abrasive Blasting Hose Couplings & Gaskets, and Abrasive Blasting Nozzle Holder – Select an Abrasive Blasting Hose (19) that has an inner diameter 3 to 4 times larger than your Abrasive Blasting Nozzle (13). Inspect Abrasive Blasting Hose (19), Abrasive Blasting Hose Couplings & Gaskets (20), and Abrasive Blasting Nozzle Holder (15) for damage or wear. Repair or replace damaged or worn components.

Safety Cables – Install a Safety Cable (5) at each Abrasive Blasting Hose (19), and Air Hose (4) connection points.

Aftercooler and Moisture Separator – Ensure Aftercooler (28) is positioned on stable ground. Keep petcock drain of Moisture Separator (23) slightly open during use. Drain both devices after each use.

Supplied-Air Respirator, Breathing Line, Breathing Air Filter, Climate Control Device, CO Monitor, Ambient Air Pump – You MUST consult the Operator’s Manual supplied with your Respiratory Equipment (6, 7, 8, 9, 10, 17) for ALL applicable instructions and warnings. Inspect all Respiratory Equipment components for damage or wear. Repair or replace damaged or worn components.

Abrasive Blasting Suit and Gloves – Select an abrasive-resistant Abrasive Blasting Suit (11) that is slightly oversized to allow ease of movement and allows air to flow around your body. Select abrasive-resistant Gloves (12) with a tight fit and a long cuff that overlaps the sleeve of the Abrasive Blasting Suit (11).

Abrasive Metering Valve and Abrasive Blasting Pot – Confirm Abrasive Blasting Pot (25) is positioned on stable ground. Inspect Abrasive Blasting Pot (25) and Abrasive Metering Valve (21) for damage or wear. Repair or replace damaged or worn components.

Abrasive Blasting Pot Screen and Abrasive Blasting Pot Lid – Always use an Abrasive Blasting Pot Screen (26) when filling Abrasive Blasting Pot (25) with Abrasive (1) to prevent debris from entering the Abrasive Blasting Pot (25). Remove Abrasive Blasting Pot Lid (27) before operating the Abrasive Blasting Pot (25). Install Abrasive Blasting Pot Lid (27) after use to protect the Abrasive Blasting Pot’s (25) interior.

Remote Control System, Remote Control Switch, Control Line, – Inspect Remote Control System (22) and Control Line (18) for damage or wear. Repair or replace damaged or worn components. Ensure Control Line (18) fittings connected to the Remote Control System (22) are tight and free of leaks. Ensure Remote Control Switch (16) is functioning properly. Consult Remote Control Switch Operator’s Manual for applicable instructions.

Abrasive Blasting Pot Exhaust Muffler – Inspect Abrasive Blasting Pot Exhaust Muffler (24) at start and end of daily use. Replace element of Abrasive Blasting Pot Exhaust Muffler (24) per Operator’s Manual instructions.

Lighting System – Ensure the Lighting System (14) is connected to a proper power supply before use.

OPERATING INSTRUCTIONS

WARNING

W-562

Always depressurize the entire system, disconnect all power sources and lockout/tagout all components before any maintenance or troubleshooting is attempted. Failure to comply with the above warning could cause electrical shock and inadvertent activation of equipment resulting in death or serious injury.

WARNING

W-506

OSHA requires blast cleaning nozzles be equipped with an operating valve, which shall be designed to be held open only by continuous hand pressure and shall close immediately upon release of hand pressure (i.e., a “deadman” control). The valve shall not be modified in any manner that would allow it to remain open without the application of continuous hand pressure by the operator. Failure to comply with the above warning could result in release of high speed abrasive and compressed air resulting in death or serious injury. OSHA 29CFR 1910.244(b)

WARNING

W-511

For equipment manufactured by entities other than Marco, you must consult the Original Equipment Manufacturer operator’s manuals, information, training, instructions and warnings, for the proper and intended use of all equipment. Failure to comply with the above warning could result in death or serious injury.

Description

The Marco® KwikStop Depressurization System, manufactured by Allredi™ decreases the time to completely exhaust all pressure from the blast hose after releasing the remote control switch. This allows the operator to reposition more quickly by eliminating the time required to wait for the hose to depressurize. This is particularly important as hose lengths increase creating a larger volume of air to exhaust. Typical applications include blast rooms, blast yards, bridges, offshore oil refineries, pipelines, shipyards, storage tanks, and water treatment plants.

Operational Requirements

- Compressed air, 150 psi maximum working pressure.

The following may cause safety hazards or reduced performance:

- Improper installation and/or maintenance of components
- Improper air supply pressure (operating pressure: 50–150 PSI)
- Improper electric power supply for PV400 cover sensors. Cover must be installed for system to operate.

Operating Instructions

Operating Instructions are limited to the instructions found in the Original Equipment Manufacturer’s Operator’s Manuals. Please refer to all literature included with your Marco® KwikStop Depressurization System at time of delivery. If this literature is unavailable, please contact Marco for a replacement set before use.

Before using:

- Ensure blast pot is depressurized. (See blast pot Operator's Manual for instructions.)
- Inspect all control lines ensuring they are free of obstructions or damage. Remove obstructions or replace control lines before use.
- Inspect components of Marco® KwikStop Depressurization System for damage and air leaks. Repair or replace damaged components before use.

During use:

- Monitor all components of the Marco® KwikStop Depressurization System for proper functioning.

After use:

- Inspect Marco® KwikStop Depressurization System components for damage. Repair or replace damaged components.
- Remove any spent abrasive from Chamber Assembly.

OPERATING INSTRUCTIONS

WARNING

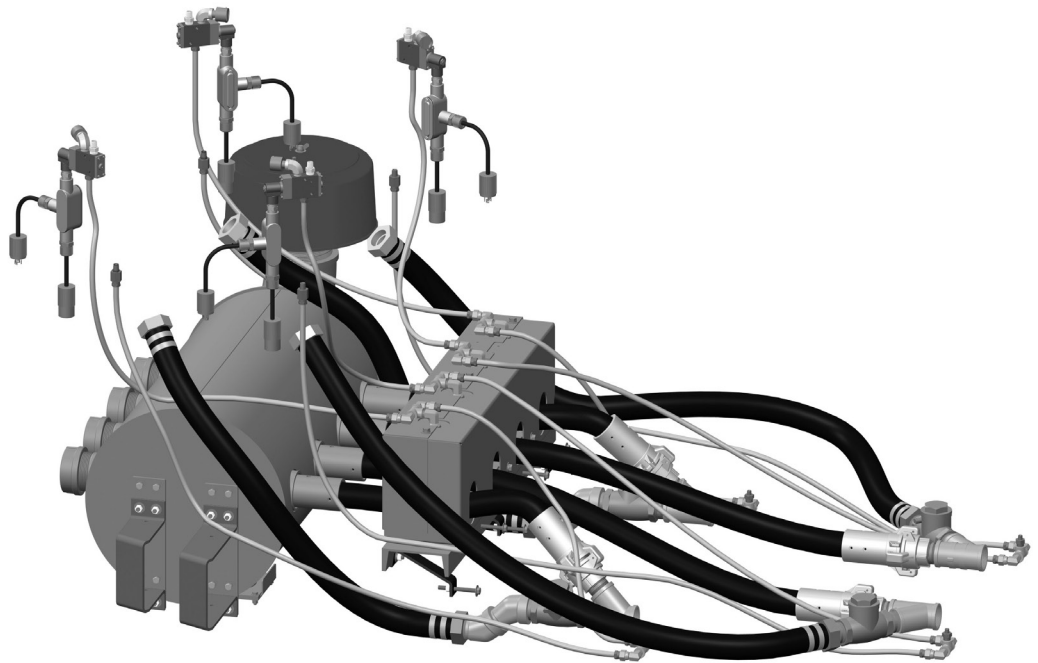
W-505

Inspect all equipment for wear or damage before and after each use. Failure to use Original Equipment Manufacturer repair parts and failure to immediately replace worn or damaged components could void warranties and cause malfunctions. Failure to comply with the above warning could result in death or serious injury.

WARNING

W-577

Before using this equipment, read, understand and follow all instructions in the Operator's Manuals with this equipment. If the user and/or assistants cannot read or understand the warnings and instructions, the employer of the user and/or assistants must provide adequate and necessary training to ensure proper operation and compliance with all safety procedures pertaining to this equipment. If Operator's Manuals have been lost, visit www.marco.us or call (563) 324-2519 for replacements. Failure to comply with the above warning could result in death or serious injury.



Four Outlet Trailer Model Shown

CAUTION

C-517

Muffler exhausts automatically. Ensure appropriate Personal Protective Equipment is in use. Failure to comply with the above caution may result in minor or moderate injury.

INSTALLATION

KwikStop Depressurization System Assembly - Mounting Bracket — Trailer

Note: Additional components may be required to install the Marco® KwikStop Depressurization System.

WARNING

W-562

Always depressurize the entire system, disconnect all power sources and lockout/tagout all components before any maintenance or troubleshooting is attempted. Failure to comply with the above warning could cause electrical shock and inadvertent activation of equipment resulting in death or serious injury.

WARNING

W-511

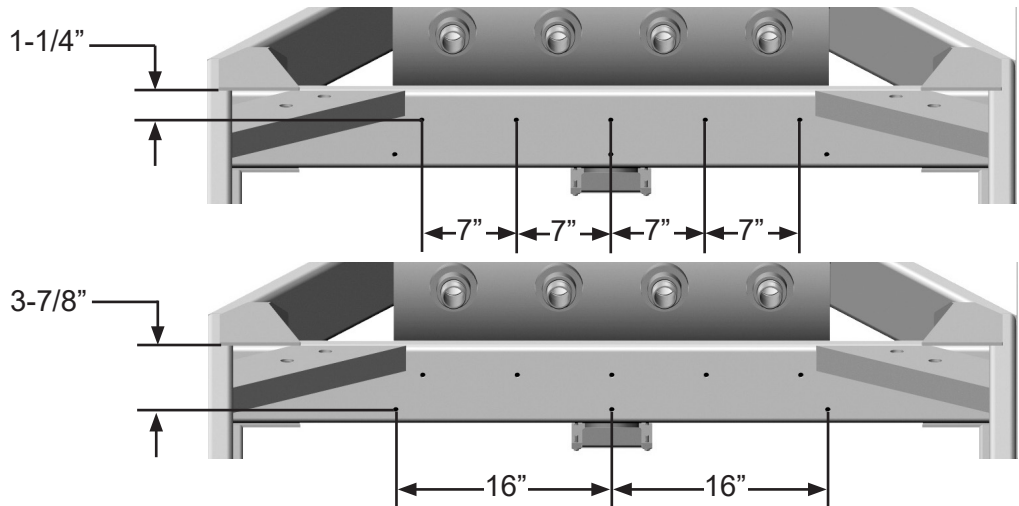
For equipment manufactured by entities other than Marco, you must consult the Original Equipment Manufacturer operator's manuals, information, training, instructions and warnings, for the proper and intended use of all equipment. Failure to comply with the above warning could result in death or serious injury.

WARNING

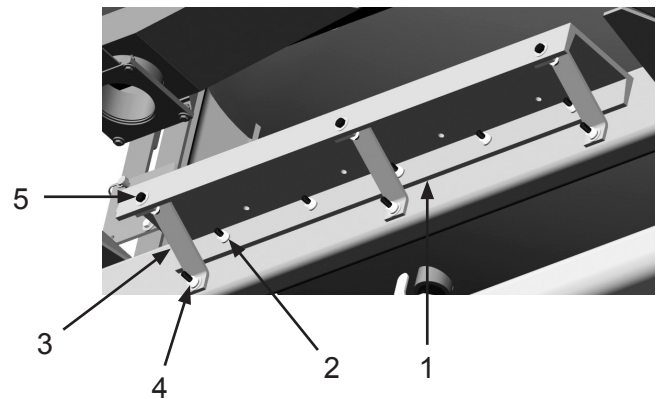
W-563

Moving parts can present an area where crushing, pinching, entanglement or amputation may occur. Do not place body parts or foreign objects in any area where there are moving parts. Failure to comply with the above warning could result in death or serious injury.

- 1) Drill eight 7/16" through holes through trailer tube as shown.



- 2) Install Base (1) using five Bolts, Washers, Lock Washers, and Nuts (2).
- 3) Install Support Brackets (3) to trailer using three Bolts, Washers, Lock Washers and Nuts (4).
- 4) Install support brackets (3) to Base (1) using three Bolts, Washers, Lock Washers, and Nuts (5).
- 5) Tighten all hardware.



INSTALLATION

KwikStop Depressurization System Assembly - Mounting Bracket — Trailer (Cont.)

⚠ WARNING

W-562

Always depressurize the entire system, disconnect all power sources and lockout/tagout all components before any maintenance or troubleshooting is attempted. Failure to comply with the above warning could cause electrical shock and inadvertent activation of equipment resulting in death or serious injury.

⚠ WARNING

W-511

For equipment manufactured by entities other than Marco, you must consult the Original Equipment Manufacturer operator's manuals, information, training, instructions and warnings, for the proper and intended use of all equipment. Failure to comply with the above warning could result in death or serious injury.

⚠ WARNING

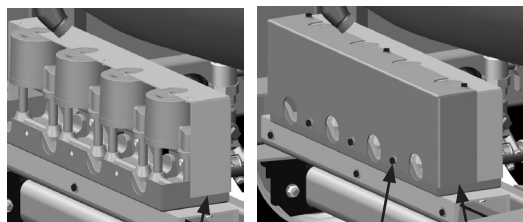
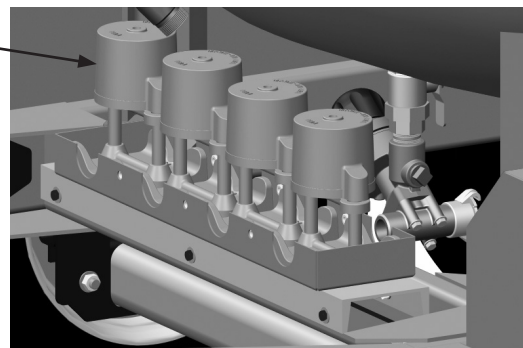
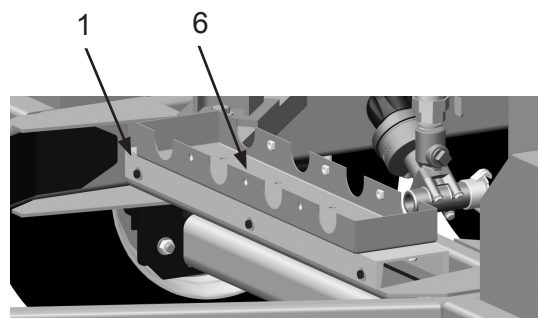
W-563

Moving parts can present an area where crushing, pinching, entanglement or amputation may occur. Do not place body parts or foreign objects in any area where there are moving parts. Failure to comply with the above warning could result in death or serious injury.

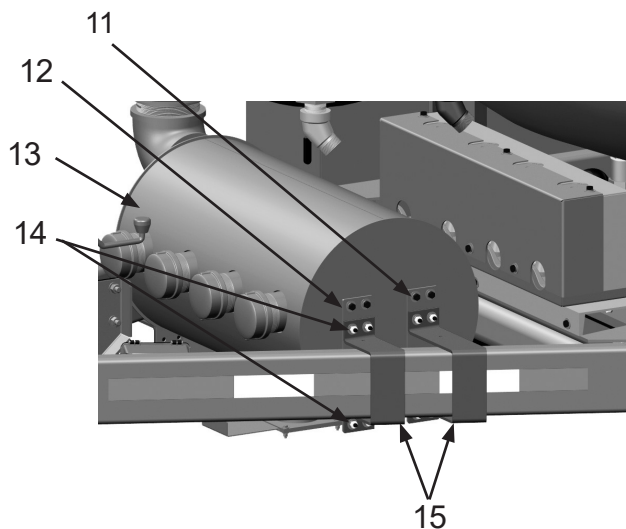
- 6) Place base of Cover (6) on top of Base (1) and align holes.
- 7) Install PV400's (7) to Base. Secure from underneath base using attaching hardware (not shown).
- 8) Place back of Cover (8) using attaching hardware (not shown).
- 9) Place front of Cover (10) using Bolts, Washer, and Lock Washer (9).

Note: Approximate weight of Chamber Assembly is 300 lbs. Use suitable lifting devices to support or maneuver Chamber Assembly.

- 10) Install Plates (12) onto Chamber Assembly (13) using attaching Hardware (11).
- 11) Install Chamber Assembly (13) onto trailer using Brackets (15) and attaching Hardware (14).



8 9 10



INSTALLATION

KwikStop Depressurization System Assembly - Mounting Bracket – Skid

⚠ WARNING

W-562

Always depressurize the entire system, disconnect all power sources and lockout/tagout all components before any maintenance or troubleshooting is attempted. Failure to comply with the above warning could cause electrical shock and inadvertent activation of equipment resulting in death or serious injury.

⚠ WARNING

W-511

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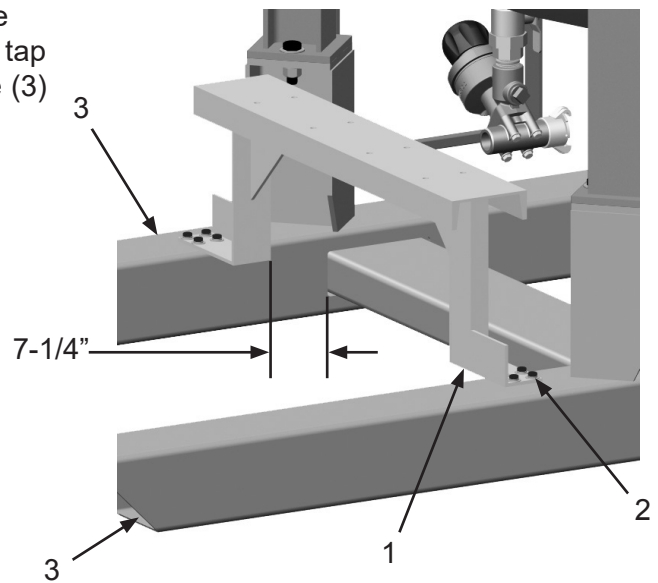
⚠ WARNING

W-563

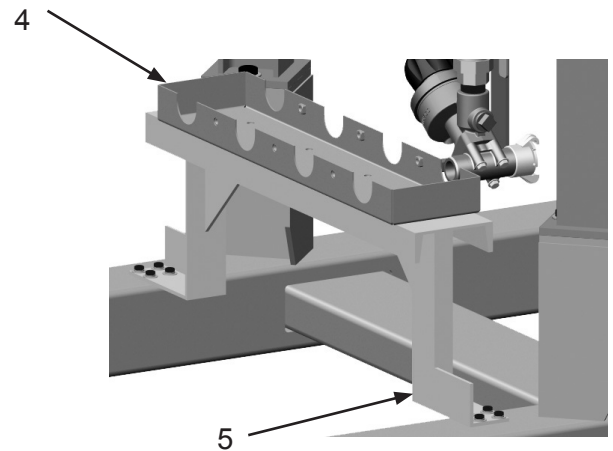
Moving parts can present an area where crushing, pinching, entanglement or amputation may occur. Do not place body parts or foreign objects in any area where there are moving parts. Failure to comply with the above warning could result in death or serious injury.

Note: Additional components may be required to install the Marco® KwikStop Depressurization System.

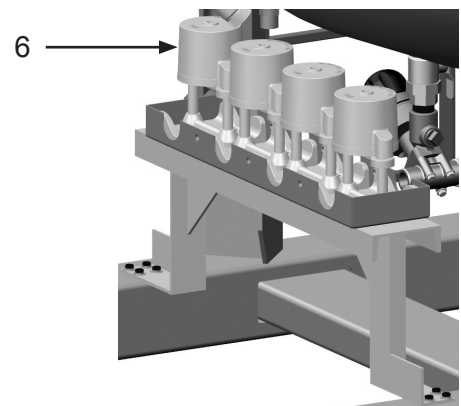
- 1) Position Base (1) centered on frame as shown and mark holes. Drill and tap eight .332" holes through Skid Tube (3) as shown.
- 2) Install Base (1) using eight Bolts, Washers, and Lock Washers (2).



- 3) Place base of Cover (4) on top of Base (5) and align holes.



- 4) Install PV400's (6) to Base. Secure from underneath base using attaching hardware (not shown).



INSTALLATION

KwikStop Depressurization System Assembly - Mounting Bracket — Skid (Cont.)

WARNING

W-562

Always depressurize the entire system, disconnect all power sources and lockout/tagout all components before any maintenance or troubleshooting is attempted. Failure to comply with the above warning could cause electrical shock and inadvertent activation of equipment resulting in death or serious injury.

WARNING

W-511

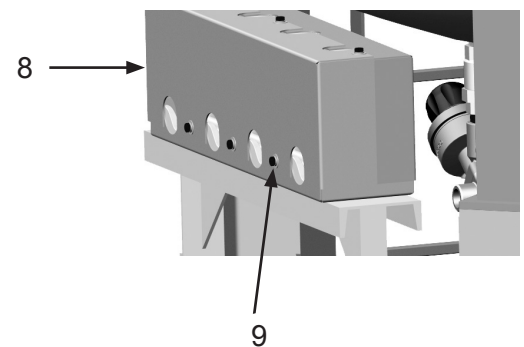
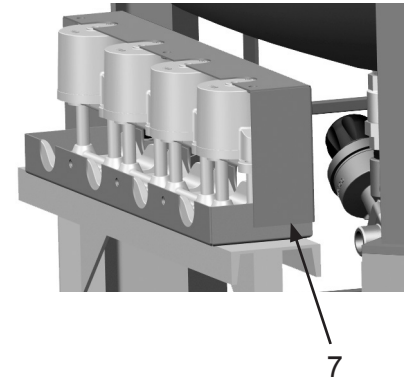
For equipment manufactured by entities other than Marco, you must consult the Original Equipment Manufacturer operator's manuals, information, training, instructions and warnings, for the proper and intended use of all equipment. Failure to comply with the above warning could result in death or serious injury.

WARNING

W-563

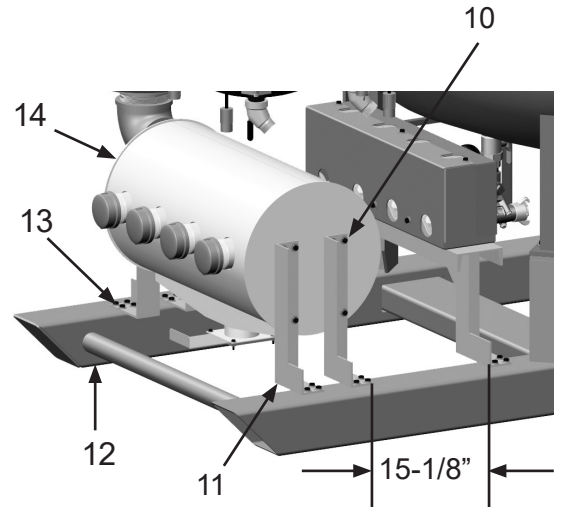
Moving parts can present an area where crushing, pinching, entanglement or amputation may occur. Do not place body parts or foreign objects in any area where there are moving parts. Failure to comply with the above warning could result in death or serious injury.

- 5) Place back of Cover (7) using attaching hardware (not shown).
- 6) Place front of Cover (8) using Bolts, Washer, and Lock Washer (9).



Note: Approximate weight of Chamber Assembly is 300 lbs. Use suitable lifting devices to support or maneuver Chamber Assembly.

- 7) Install four Mounting Weldments (11) onto Chamber Assembly (14) using attaching hardware (10).
- 8) Position Chamber Assembly (14) centered on frame as shown and mark holes. Drill and tap 16 .332" holes through Skid Tube (12) as shown.
- 9) Install Chamber Assembly (14) onto Skid (12) using attaching Hardware (13).



INSTALLATION

KwikStop Depressurization System Assembly - 12-Volt DC 190 Electric Control Assembly

WARNING

W-562

Always depressurize the entire system, disconnect all power sources and lockout/tagout all components before any maintenance or troubleshooting is attempted. Failure to comply with the above warning could cause electrical shock and inadvertent activation of equipment resulting in death or serious injury.

WARNING

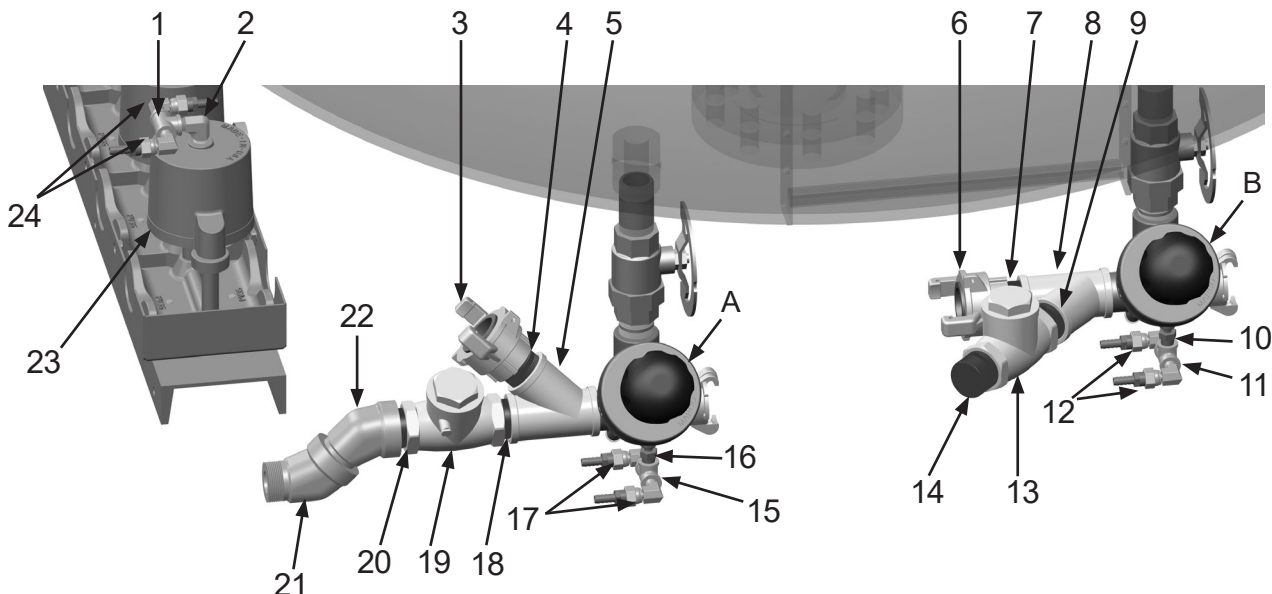
W-511

For equipment manufactured by entities other than Marco, you must consult the Original Equipment Manufacturer operator's manuals, information, training, instructions and warnings, for the proper and intended use of all equipment. Failure to comply with the above warning could result in death or serious injury.

WARNING

W-563

Moving parts can present an area where crushing, pinching, entanglement or amputation may occur. Do not place body parts or foreign objects in any area where there are moving parts. Failure to comply with the above warning could result in death or serious injury.



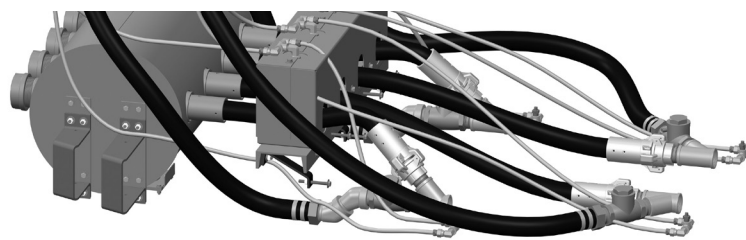
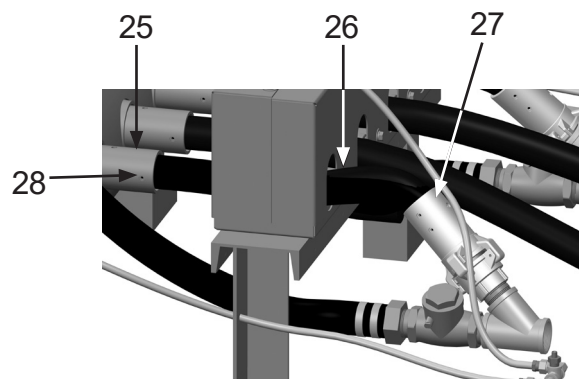
PV400 cover hidden for clarity.

Marco® Maxum III Abrasive Metering Valves shown.

- 1) On PV400 (23), attach Elbow (2), Tee Fitting (1) and 90° Swivel Unions (24). Repeat for all PV400's.
- 2) On left front metering valve (A), attach Hex Nipple (16), Tee (15), and 90° Swivel Unions (17). Attach Wye Fitting (5), Close Nipples (4,18), Tank Coupling (3), Check Valve (19), Close Nipple (20) and 45° Elbows (21,22). Repeat on right front metering valve.
- 3) On left rear metering valve (B), attach Hex Nipple (10), Tee (11), and 90° Swivel Unions (12). Attach Wye Fitting (8), Close Nipples (7,9), Tank Coupling (6), Check Valve (13), and Close Nipple (14). Repeat on right rear metering valve.

- 4) Attach Coupling (27) to Hose (26).
- 5) Install Hose (26) through PV400 and in to corresponding Inlet (25) on chamber. Secure Hose with Screws (28). Repeat for all PV400's.

Note: Start with inner ports and assemble outward.



INSTALLATION

KwikStop Depressurization System Assembly - 12-Volt DC 190 Electric Control Assembly (Cont.)

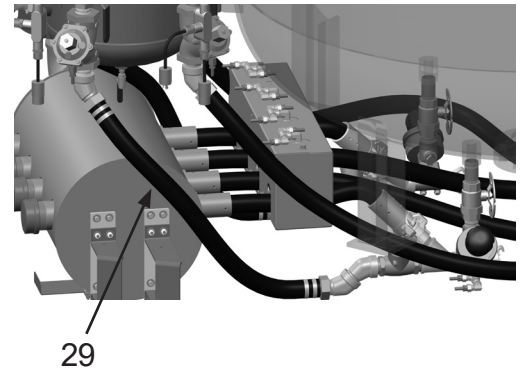
WARNING

W-562

Always depressurize the entire system, disconnect all power sources and lockout/tagout all components before any maintenance or troubleshooting is attempted. Failure to comply with the above warning could cause electrical shock and inadvertent activation of equipment resulting in death or serious injury.

Note: Start with inner Ports and assemble outward.

- 6) Assemble Pusher Lines (29) and install as shown. Repeat for each port.



WARNING

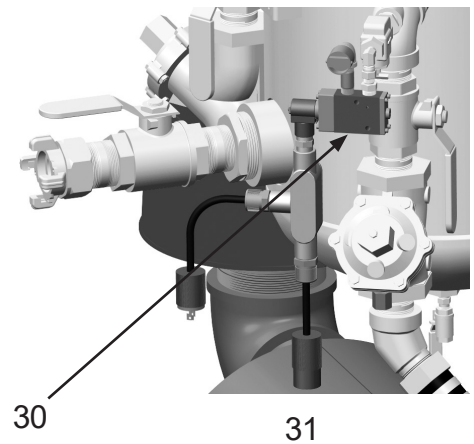
W-511

For equipment manufactured by entities other than Marco, you must consult the Original Equipment Manufacturer operator's manuals, information, training, instructions and warnings, for the proper and intended use of all equipment. Failure to comply with the above warning could result in death or serious injury.

- 7) Attach 190 12-Volt DC Assembly (30). Repeat for each port.

Note: Start with inner ports and assemble outward.

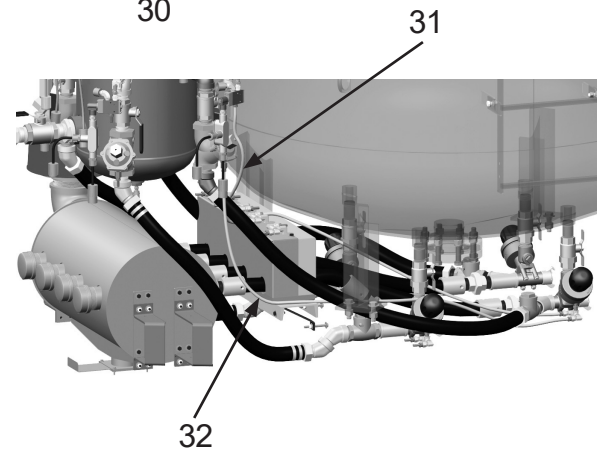
- 8) Install Control Lines (31,32). Repeat for each port.



WARNING

W-563

Moving parts can present an area where crushing, pinching, entanglement or amputation may occur. Do not place body parts or foreign objects in any area where there are moving parts. Failure to comply with the above warning could result in death or serious injury.



INSTALLATION

KwikStop Depressurization System Assembly - 190 Pneumatic Control Valve

WARNING

W-562

Always depressurize the entire system, disconnect all power sources and lockout/tagout all components before any maintenance or troubleshooting is attempted. Failure to comply with the above warning could cause electrical shock and inadvertent activation of equipment resulting in death or serious injury.

WARNING

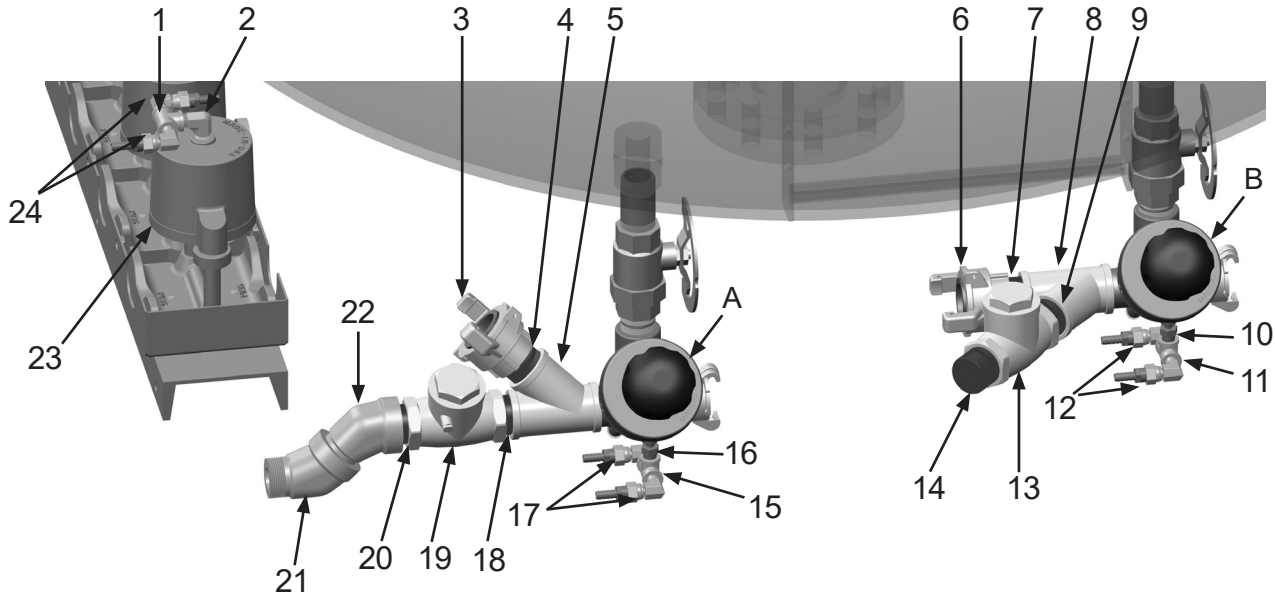
W-511

For equipment manufactured by entities other than Marco, you must consult the Original Equipment Manufacturer operator's manuals, information, training, instructions and warnings, for the proper and intended use of all equipment. Failure to comply with the above warning could result in death or serious injury.

WARNING

W-563

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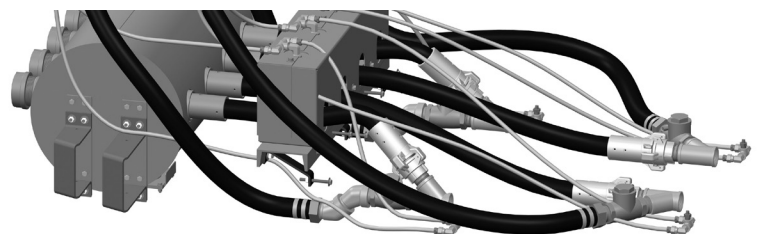
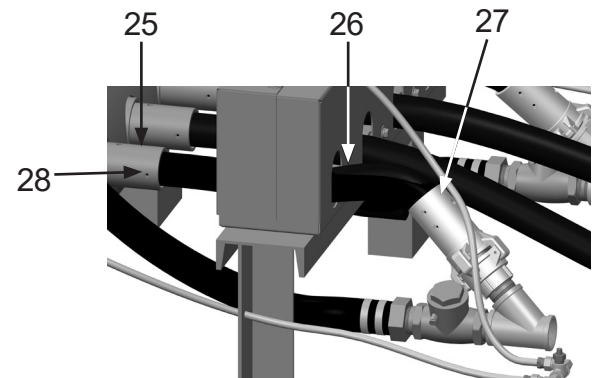
PV400 cover hidden for clarity.

Marco® Maxum III Abrasive Metering Valves shown.

- 1) On PV400 (23), attach Elbow (2), Tee Fitting (1) and 90° Swivel Unions (24). Repeat for all PV400's.
- 2) On left front metering valve (A), attach Hex Nipple (16), Tee (15) and 90° Swivel Unions (17). Attach Wye Fitting (5), Close Nipples (4, 18), Tank Coupling (3), Check Valve (19), Close Nipple (20) and 45° Elbows (21, 22). Repeat on right front metering valve.
- 3) On left rear metering valve (B), attach Hex Nipple (10), Tee (11), and 90° Swivel Unions (12). Attach Wye Fitting (8), Close Nipples (7, 9), Tank Coupling (6), Check Valve (13), and Close Nipple (14). Repeat on right rear metering valve.

- 4) Attach Coupling (27) to Hose (26).
- 5) Install Hose (26) through PV400 and in to corresponding Inlet (25) on chamber. Secure Hose with Screws (28). Repeat for all PV400's.

Note: Start with inner ports and assemble outward.



INSTALLATION

KwikStop Depressurization System Assembly - 190 Pneumatic Control Valve (Cont.)

WARNING

W-562

Always depressurize the entire system, disconnect all power sources and lockout/tagout all components before any maintenance or troubleshooting is attempted. Failure to comply with the above warning could cause electrical shock and inadvertent activation of equipment resulting in death or serious injury.

WARNING

W-511

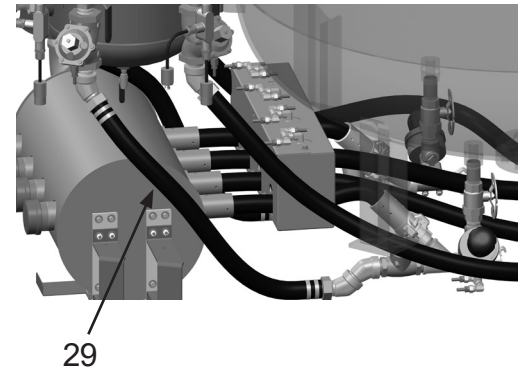
For equipment manufactured by entities other than Marco, you must consult the Original Equipment Manufacturer operator's manuals, information, training, instructions and warnings, for the proper and intended use of all equipment. Failure to comply with the above warning could result in death or serious injury.

WARNING

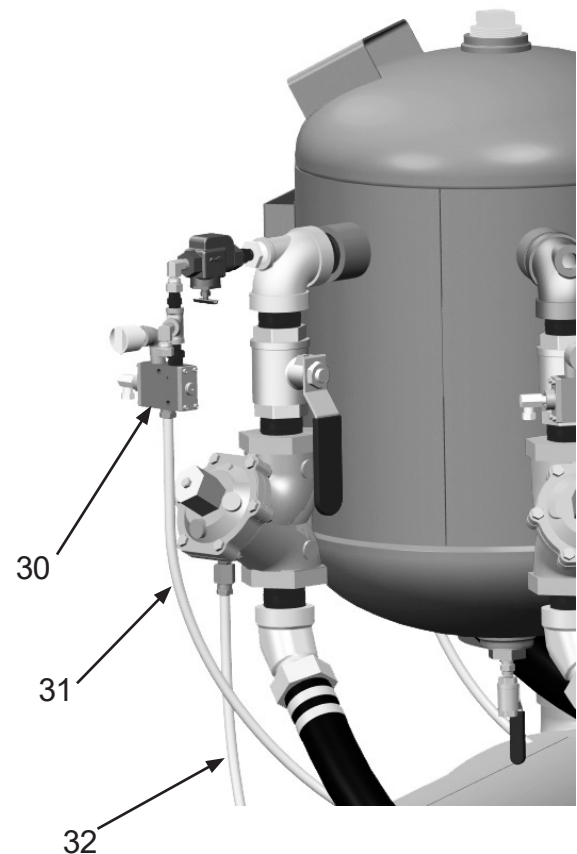
W-563

Moving parts can present an area where crushing, pinching, entanglement or amputation may occur. Do not place body parts or foreign objects in any area where there are moving parts. Failure to comply with the above warning could result in death or serious injury.

- 6) Assemble Pusher Lines (29) and install as shown. Repeat for each port.



- 7) Attach 190 Pneumatic Control Valve Assembly (30). Repeat for each port.
Note: Start with inner ports and assemble outward.
- 8) Install Control Lines (31,32). Repeat for each port.



MAINTENANCE

Remove and Install Chamber Assembly – Trailer

WARNING

W-562

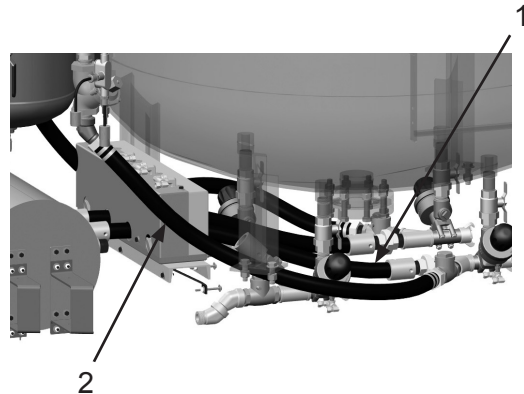
Always depressurize the entire system, disconnect all power sources and lockout/tagout all components before any maintenance or troubleshooting is attempted. Failure to comply with the above warning could cause electrical shock and inadvertent activation of equipment resulting in death or serious injury.

WARNING

W-605

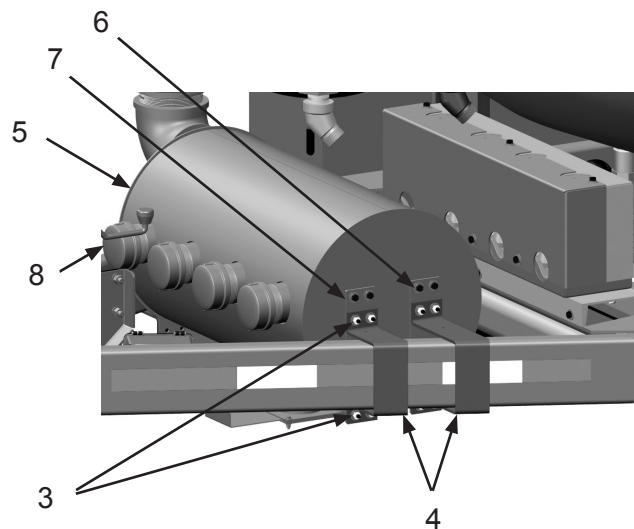
For proper operation, maintenance should be performed with the assistance of a qualified technician. Failure to comply with the above warning could result in death or serious injury.

- 1) Remove Pusher Lines (1,2). Repeat for each port.



Note: Approximate weight of Chamber Assembly is 300 lbs. Use suitable lifting devices to support or maneuver Chamber Assembly.

- 2) Remove Attaching Hardware (3) and Brackets (5). Remove Chamber Assembly (5).
- 3) Remove Attaching Hardware (6) and Plates (7).
- 4) Remove Plugs (8) and inspect tubes for damage.
- 5) Install parts in reverse order.



MAINTENANCE

Remove and Install Chamber Assembly – Skid

WARNING

W-562

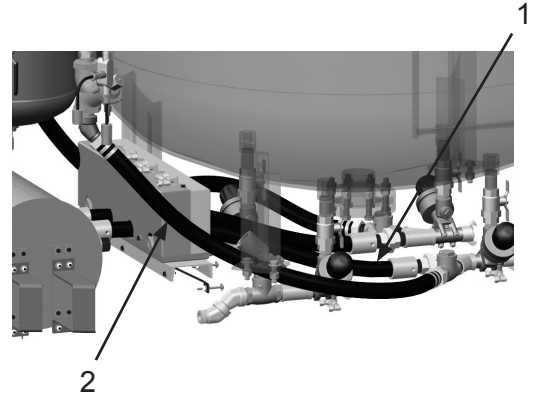
Always depressurize the entire system, disconnect all power sources and lockout/tagout all components before any maintenance or troubleshooting is attempted. Failure to comply with the above warning could cause electrical shock and inadvertent activation of equipment resulting in death or serious injury.

WARNING

W-605

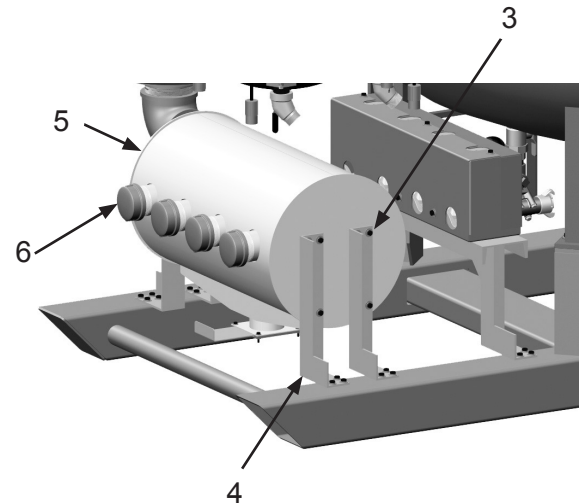
For proper operation, maintenance should be performed with the assistance of a qualified technician. Failure to comply with the above warning could result in death or serious injury.

- 1) Remove Pusher Lines (1,2). Repeat for each port.



Note: Approximate weight of Chamber Assembly is 300 lbs. Use suitable lifting devices to support or maneuver Chamber Assembly.

- 2) Remove Attaching Hardware (3) and Mounting Weldments (4). Remove Chamber Assembly (5).
- 3) Remove Plugs (6) and inspect tubes for damage.
- 4) Install parts in reverse order.



MAINTENANCE

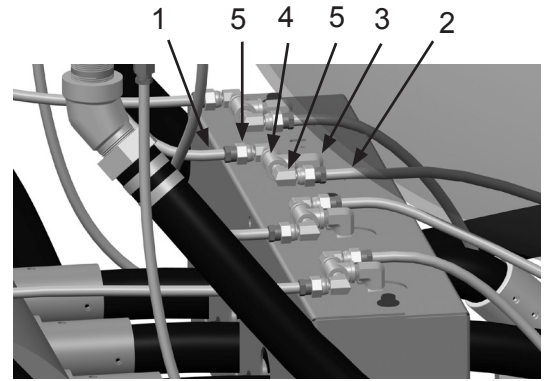
Remove and Install PV400

WARNING

W-562

Always depressurize the entire system, disconnect all power sources and lockout/tagout all components before any maintenance or troubleshooting is attempted. Failure to comply with the above warning could cause electrical shock and inadvertent activation of equipment resulting in death or serious injury.

- 1) Remove Control Lines (1,2). Repeat for each port.
- 2) Remove Elbow (3), Tee Fitting (4), and 90° Swivel Unions (5). Repeat for all PV400's.

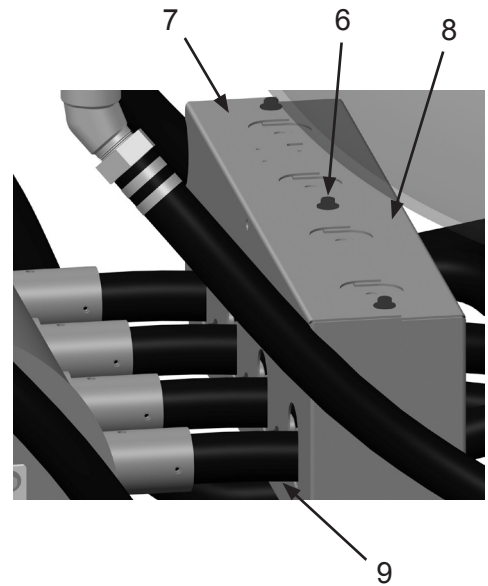


WARNING

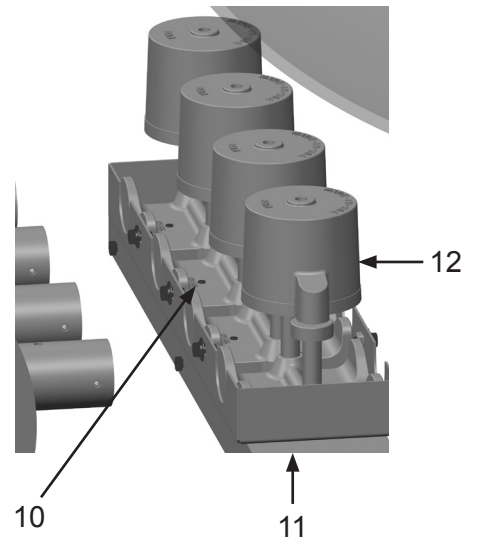
W-605

For proper operation, maintenance should be performed with the assistance of a qualified technician. Failure to comply with the above warning could result in death or serious injury.

- 3) Remove nine Bolts, Washers, and Lock Washers (6); and Covers (7,8).
- 4) Remove screws to remove four Pusher Lines (9).



- 5) Remove eight Bolts, Washers, and Lock Washers (10) from underneath Base (11). Remove PV400's (12).
- 6) Install parts in reverse order.



MAINTENANCE

Remove and Install Chamber Intake Filter

WARNING

W-562

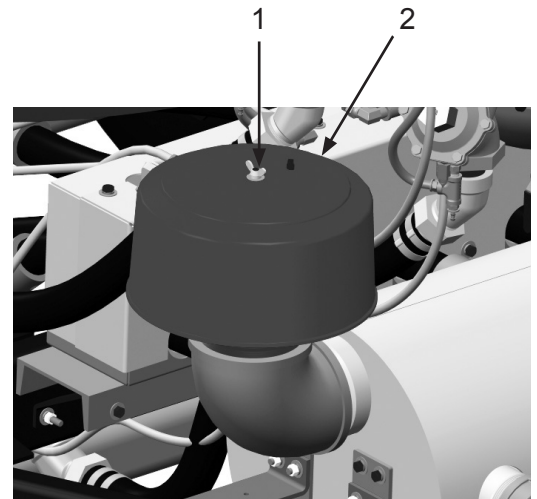
Always depressurize the entire system, disconnect all power sources and lockout/tagout all components before any maintenance or troubleshooting is attempted. Failure to comply with the above warning could cause electrical shock and inadvertent activation of equipment resulting in death or serious injury.

WARNING

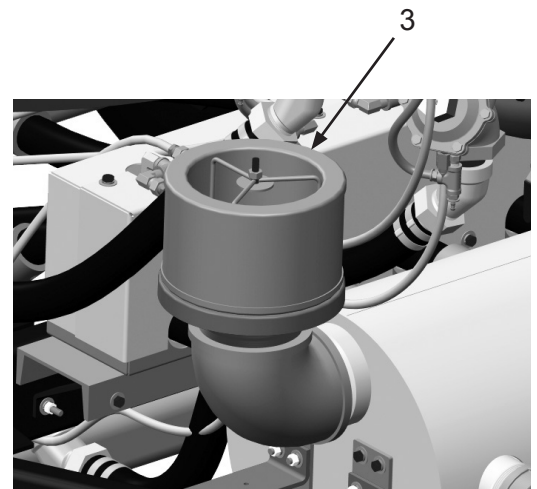
W-605

For proper operation, maintenance should be performed with the assistance of a qualified technician. Failure to comply with the above warning could result in death or serious injury.

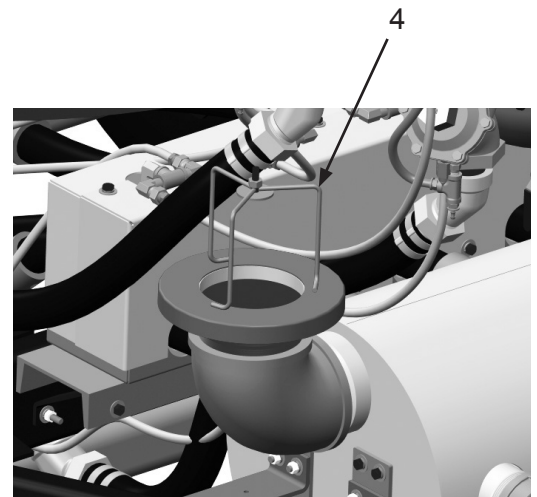
- 1) Remove Wing Nut and Washer (1).
- 2) Remove Hood (2) and inspect for damage. Replace as needed.



- 3) Remove Intake Filter (3) and inspect for damage. Replace as needed.



- 4) Remove Filter Housing Assembly (4) and inspect for damage. Replace as needed.
- 5) Install parts in reverse order.



MAINTENANCE

Remove and Install Slide Assembly

WARNING

W-562

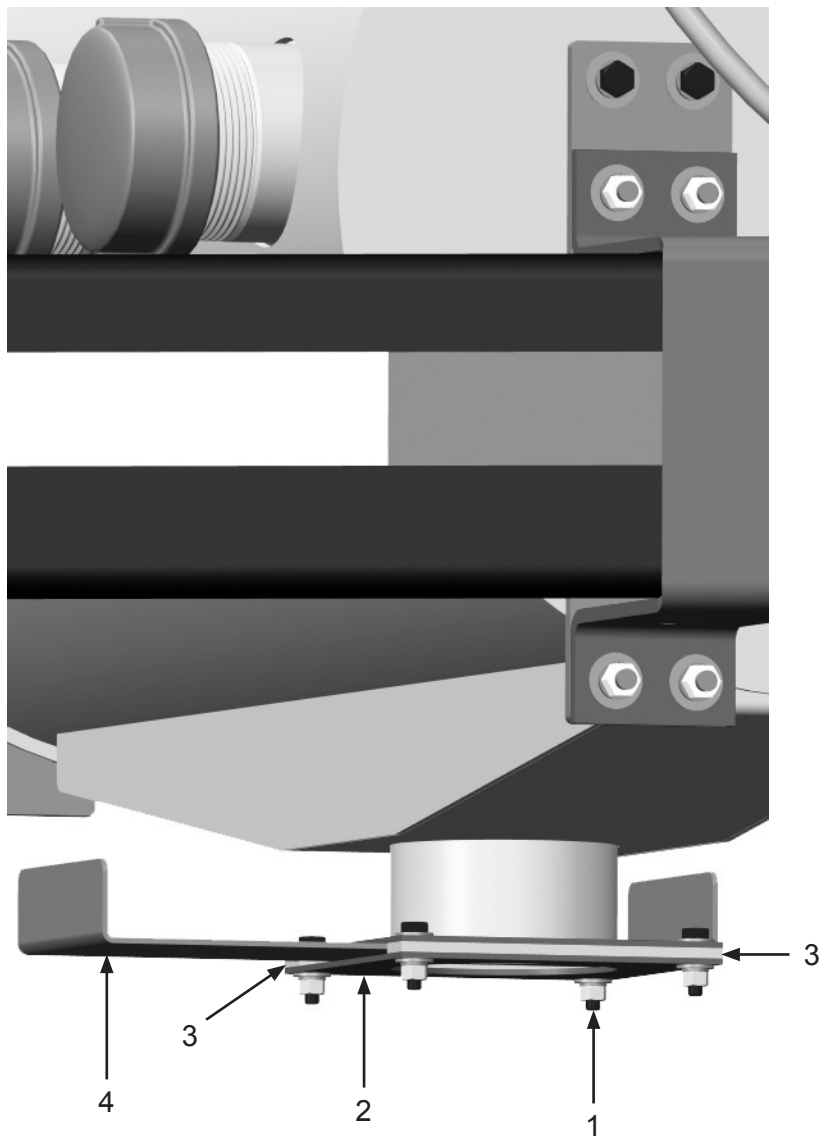
Always depressurize the entire system, disconnect all power sources and lockout/tagout all components before any maintenance or troubleshooting is attempted. Failure to comply with the above warning could cause electrical shock and inadvertent activation of equipment resulting in death or serious injury.

WARNING

W-605

For proper operation, maintenance should be performed with the assistance of a qualified technician. Failure to comply with the above warning could result in death or serious injury.

- 1) Remove four Bolts, Lock Washers, Nuts, and eight Washers (1). Remove Bolt Plate (2), Side Bars (3), and Slide Plate (4).
- 2) Inspect all parts for damage. Replace as needed.
- 3) Install parts in reverse order.



MAINTENANCE

Clean out Chamber

Clean out Chamber daily after use.

WARNING

W-562

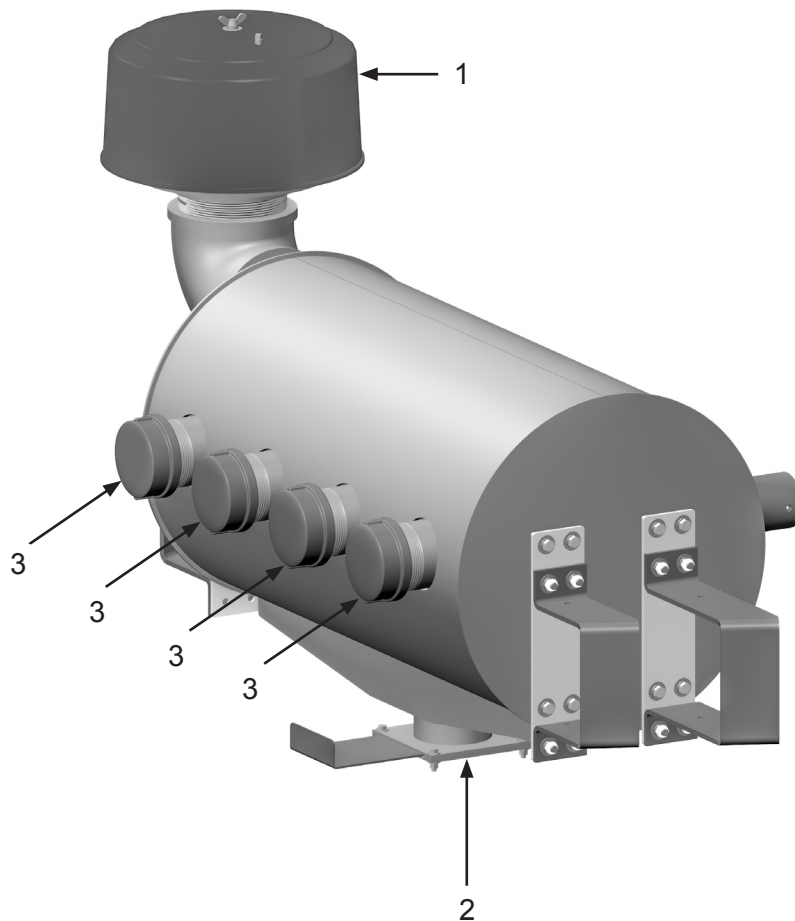
Always depressurize the entire system, disconnect all power sources and lockout/tagout all components before any maintenance or troubleshooting is attempted. Failure to comply with the above warning could cause electrical shock and inadvertent activation of equipment resulting in death or serious injury.

- 1) Remove Chamber Intake Filter (1). See Remove and Install Chamber Intake Filter. Inspect all parts for damage. Replace as needed.
- 2) Slide OPEN Slide Assembly (2). Inspect all parts for damage. Replace as needed.
- 3) Remove all four Plugs (3). Inspect all parts for damage. Replace as needed.
- 4) Use brush or hand to push excess abrasive and debris through Slide Assembly port in bottom of Chamber. Use air hose to clean inside of Chamber of remaining debris.
- 5) Install parts in reverse order.

WARNING

W-605

For proper operation, maintenance should be performed with the assistance of a qualified technician. Failure to comply with the above warning could result in death or serious injury.



MAINTENANCE

Maintenance Schedules Quick Reference Charts

| MARCO® KWIKSTOP MAINTENANCE SCHEDULE | | | | |
|--|--|------------------|---------------|----------------|
| Perform inspections at the intervals specified. Repair or replace damaged parts as needed. | | | | |
| Item | Maintenance Required | Daily | Weekly | Monthly |
| Clean Out System Chamber | Clean out system Chamber daily to ensure inside is free of collected debris and abrasive. | X | | |
| Chamber Intake Filter | Ensure wing nut on top of Chamber Intake Filter is tight and Hood is secure. Tighten if loose. | X | | |
| PV400 Valves | Visually inspect each PV400 Valve for proper function to ensure they are completely opening and closing. Replace as needed. | X | | |
| PV400 Hoses | Visually inspect all hoses passing through PV400 Valves thoroughly for wear and thinning before each use. Replace as needed. | Before every use | | |
| Hose Connections | Check all blast hose and air hose connections to ensure they are secure. Tighten as needed. | X | | |
| Identification Tags and Decals | Visually inspect for presence and condition of identification decal. Replace as needed | | X | |
| Mount Bolts | Tighten to specified torque. | | | X |

MAINTENANCE

Disassemble and Assemble Electric Control Valve

WARNING

W-562

Always depressurize the entire system, disconnect all power sources and lockout/tagout all components before any maintenance or troubleshooting is attempted. Failure to comply with the above warning could cause electrical shock and inadvertent activation of equipment resulting in death or serious injury.

WARNING

W-520

The use of this product for any purpose other than originally intended or altered from its original design is prohibited. Failure to comply with the above warning could result in death or serious injury.

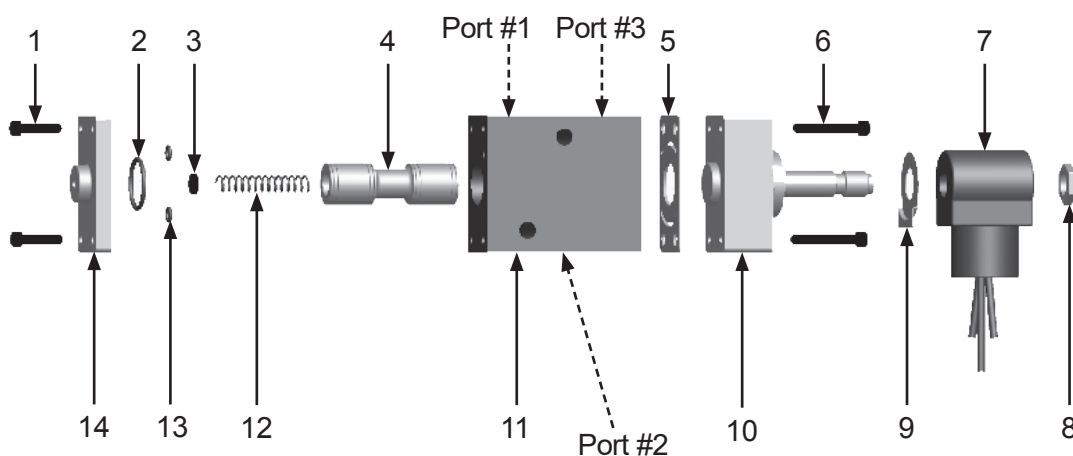
Maintenance of the Electric Control Valve is limited to the daily cleaning and the immediate replacement of damaged or worn parts.

Disassemble:

- 1) Remove four Screws (1) from End Cap (14). Remove Spring (12) from Valve Body (11).
- 2) Remove large O-ring (2) and two small O-rings (13) from End Cap (14).
- 3) Remove Felt (3) from End Cap (14).
- 4) Remove Nut (8) Slide Coil and Coil Housing (7) from Pilot (10). Remove Coil Washer (9).
- 5) Remove four Screws (6) from Pilot (10). Remove Gasket (5).
- 6) Ease Plunger (4) from Valve Body (11) by pushing Plunger (12) from Pilot (10) end.

Assemble:

- 1) Orient the Valve Body (11) so Port #1 and Port #3 are facing away. Insert Plunger (4) in Valve Body (11) from the left.
- 2) Place Gasket (5) on Valve Body (11) on the right. Place Pilot (10) on Gasket (5).
- 3) Ensure port in side of Pilot (10) is on the same side as Port #2 of Valve Body (11).
- 4) Install four Screws (6) to secure Pilot (10) to Valve Body (11). Do not overtighten.
- 5) Place Coil Washer (9) over stem of Pilot (10). Slide Coil and Coil Housing (7) onto stem of Pilot (10). Install Nut (8) on stem of Pilot (10). Do not overtighten.
- 6) Place two small O-rings (13), large O-ring (2), and Felt (3) in End Cap (14).
- 7) Insert Spring (12) in Valve Body (11). Place End Cap (14) on Spring (12) and compress Spring (12) until End Cap (14) meets Valve Body (11).
- 8) Install four Screws (1) in End Cap (14). Do not overtighten.



MAINTENANCE

Disassemble and Assemble Electric Control Assembly

WARNING

W-562

Always depressurize the entire system, disconnect all power sources and lockout/tagout all components before any maintenance or troubleshooting is attempted. Failure to comply with the above warning could cause electrical shock and inadvertent activation of equipment resulting in death or serious injury.

WARNING

W-520

The use of this product for any purpose other than originally intended or altered from its original design is prohibited. Failure to comply with the above warning could result in death or serious injury.

Maintenance of the Electric Control Assembly is limited to the daily cleaning and the immediate replacement of damaged or worn parts.

Disassemble:

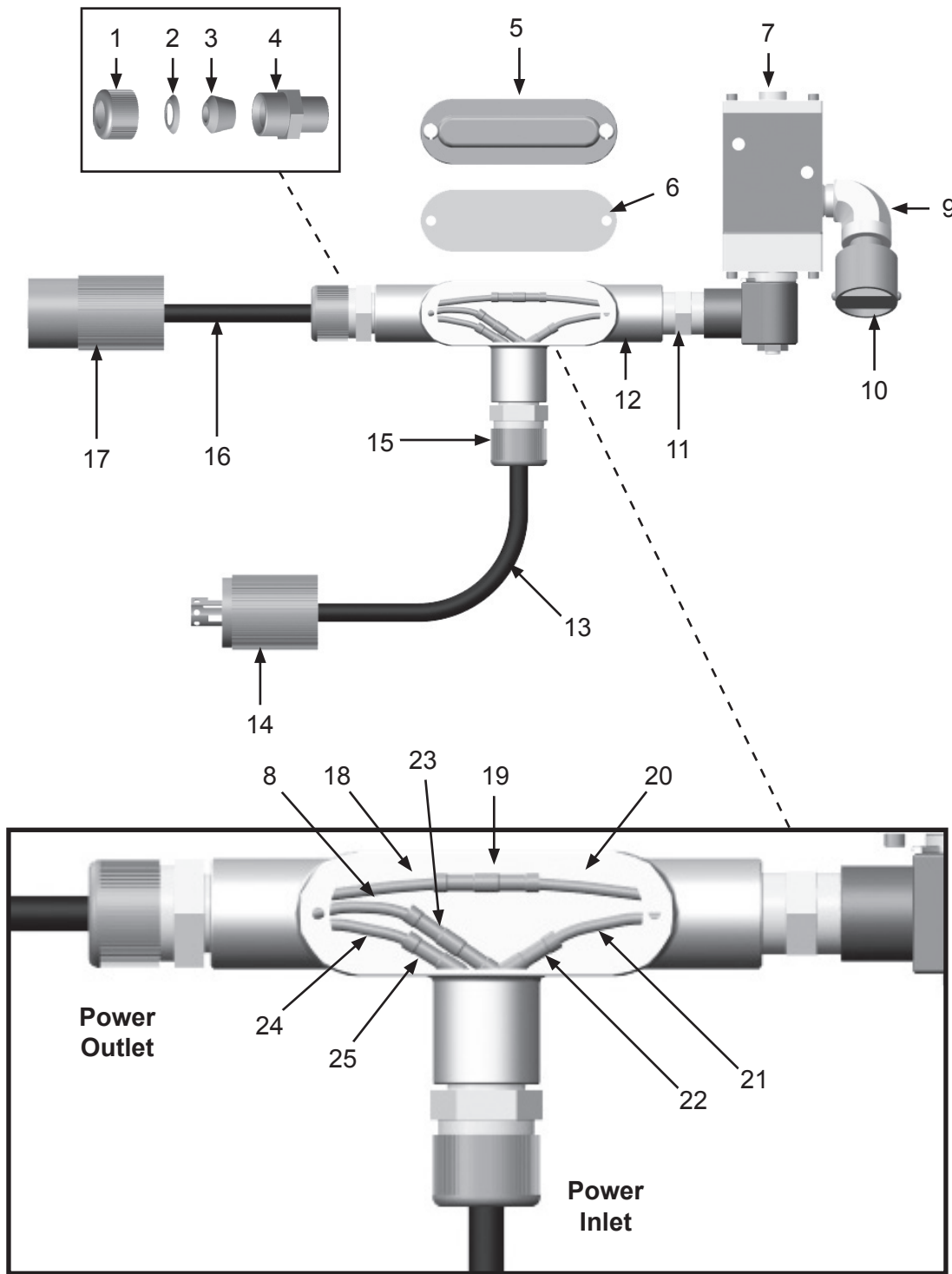
- 1) Remove Female Twist-Lock Plug (17), and Male Twist-Lock Plug (14).
- 2) Remove Dust Eliminator (10), and Pipe Elbow (9) from Electric Control Valve (7).
- 3) Remove Cover (5) and Gasket (6).
- 4) Cut Wire (18) and Wire (20) and remove Butt Splicer (19).
- 5) Cut Wire (8), Wire (21), and remove two Butt Splicers (22,23) from Power Inlet Power Cord (13).
- 6) Cut Wire (24) and remove Butt Splicer (25).
- 7) Remove Threaded Cap (1), Washer (2), Grommet (3), and 1/2" Hex Nipple (4), then remove Power Cord (16) from Conduit Box (12). Repeat for Cord Grip (15) and Power Cord (13).
- 8) Remove Electric Control Valve (7) from 1/2" Hex Nipple (11).
- 9) Remove 1/2" Hex Nipple (11) from Conduit Box (12).

Assemble:

- 1) Cut the green ground wire, of the Electric Control Valve (7), at the base of the Coil Housing and install a Butt Splicer on the wire.
- 2) Insert wires of Control Valve Assembly (7), into 1/2" Hex Nipple (11), and tighten Electric Control Valve (7) onto 1/2" Hex Nipple (12).
- 3) Insert two wires through end of Conduit Box (12). Install Conduit Box on 1/2" Hex Nipple (11) and tighten.
- 4) Install Cord Grip Hex Nipple (4) in Conduit Box (12) opposite Electric Control Valve (7).
- 5) Install Grommet (3), Washer (2), and Threaded Cap (1) on Power Cord (16).
- 6) Remove three inches of cover from Power Cord (16) to expose wires. Insert exposed wires through Cord Grip Hex Nipple (4). Repeat for Cord Grip (15) and Power Cord (13).
- 7) Install Butt Splicer (19) on Black Power Outlet Wire (18). Install Control Valve Wire (20) in Butt Splicer (19), and crimp wires in place.
- 8) Install Butt Splicer (23) on White Power Outlet Wire (8). Install White Power Inlet Wire in Butt Splicer (23) and crimp wires in place.
- 9) Install Butt Splicer (22) on Pilot Valve Wire (21). Install Black Power Inlet Wire in Butt Splicer (22), and crimp wires in place.
- 10) Install Butt Splicer (25) on remaining Power Outlet Wire (24). Install remaining Power Inlet Wire in Butt Splicer (25) and crimp wires in place.
- 11) Install Male Twist-Lock Plug (14) on Power Cord (13).
- 12) Install Female Twist-Lock Plug (17) on Power Cord (16).
- 13) Install Gasket (6), and Cover (5) on Conduit Box (12). Do not overtighten screws.
- 14) Install Pipe Elbow (9), and Dust Eliminator (10) on Electric Control Valve (7). Do not overtighten.

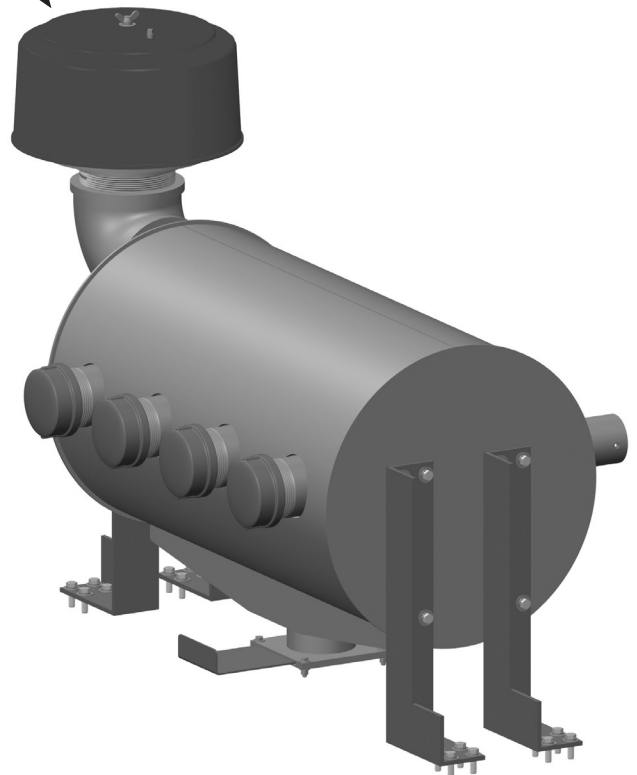
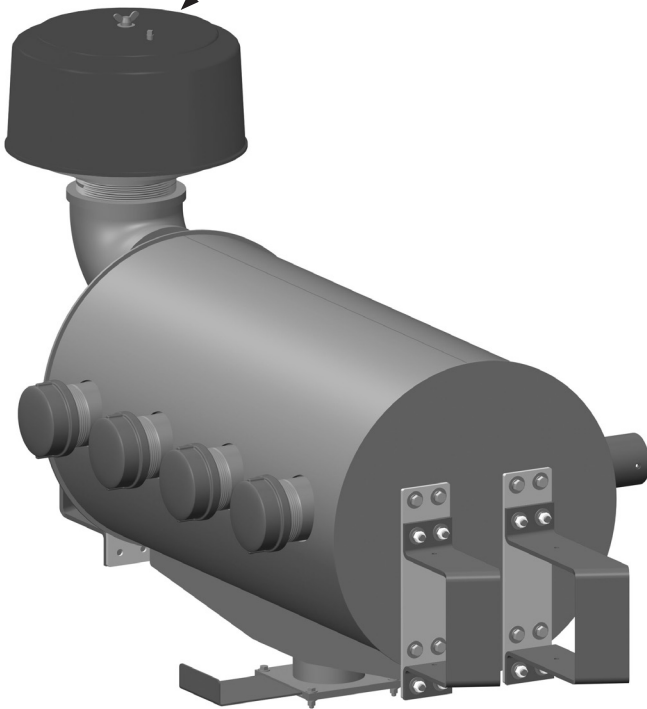
MAINTENANCE

Disassemble and Assemble Electric Control Assembly (Cont.)



MAINTENANCE

Hazard Identification Decals



TROUBLESHOOTING

If the Marco® KwikStop Depressurization System does not function properly, check the following:

WARNING

Always depressurize the entire system, disconnect all power sources and lockout/tagout all components before any maintenance or troubleshooting is attempted. Failure to comply with the above warning could cause electrical shock and inadvertent activation of equipment resulting in death or serious injury.

WARNING

Do not cut, obstruct, restrict or pinch pneumatic twinline or single line hoses. Doing so could prevent the proper activation and deactivation of the remote control system, resulting in the release of high speed abrasive and compressed air. Failure to comply with the above warning could result in death or serious injury.

WARNING

Frozen moisture could cause restrictions and obstructions in pneumatic control lines. Any restriction or obstruction in the pneumatic twinline or single line hoses could prevent the proper activation and deactivation of the remote control system, resulting in the release of high speed abrasive and compressed air. In conditions where moisture may freeze in the pneumatic twinline or single line hoses an antifreeze injection system approved for this application can be installed. Failure to comply with the above warning could result in death or serious injury.

SYMPTOM (Cause)

Pinch Valve Fails to Actuate
(Improper Air Supply, Damaged “U” Cup Gasket or Seal, Malfunctioning Remote Controls, Obstruction in Pinch Area)

ACTION

Inspect for restrictions and increase air pressure. Always use PSI gauge to ensure air pressure is between 80 PSI and 125 PSI.
Replace gasket or seal.
Ensure cover is installed over PV400's on electric systems.
See remote control switch Operator's Manual.
Remove debris.

Pinch Valve Fails to Fully Pinch Blast Hose
(Improper Air Supply, Damaged “U” Cup Gasket or Seal, Malfunctioning Remote Controls, Obstruction in Pinch Area, Frozen Blast Hose)

Inspect for restrictions and increase air pressure. Always use PSI gauge to ensure air pressure is between 80 PSI and 125 PSI.
Replace gasket or seal.
See remote control switch Operator's Manual.
Remove debris.
Temperatures too cold to allow hose to be pliable.

ADDITIONAL TECHNICAL DATA

The associations listed below offer information, materials and videos pertaining to abrasive blasting and safe operating practices.

- **American Society for Testing and Materials (ASTM)**

100 Barr Harbor Drive
West Conshohocken,
PA 19428-2959

Phone: (610) 832-9585

FAX: (610) 832-9555

www.astm.org

- **Occupational Safety & Health Administration (OSHA)**

United States
Department of Labor
200 Constitution Avenue
Washington, DC 20210

Phone: (800) 321-OSHA

(800) 321-6742

www.osha.gov

- **The National Board of Boiler & Pressure Vessel Inspectors**

1055 Crupper Avenue
Columbus, Ohio 4322

Phone: (614) 888-8320

FAX: (614) 888-0750

www.nationalboard.org

- **The Association for Materials Protection and Performance (AMPP)**

800 Trumbull Drive
Pittsburgh, PA 15205

Phone: (277) 281-7772

15835 Park Ten Place
Houston, TX 77084

Phone: (800) 797-6223

4501 Mission Bay Drive
Suite 2G

San Diego, CA 92109

Phone: (858) 768-0828

www.ampp.org

- **American National Standards Institute (ANSI)**

1899 L Street, NW, 11th Floor
Washington, DC 20036

Phone: (202) 293-8020

FAX: (202) 293-9287

www.ansi.org

LIMITED WARRANTY

Seller warrants to the original purchaser that the Product covered by this Limited Warranty will remain free from defects in workmanship or material under normal commercial use and service for a period of one year from the date of shipment to the original Purchaser. This Warranty shall not apply to defects arising, in whole or in part, from any accident, negligence, alteration, misuse or abuse of the Product, operation of the Product which is not in accordance with applicable instructions or manuals or under conditions more severe than, or otherwise exceeding, those set forth in the written specifications for the Product, nor shall this Warranty extend to repairs or alterations of the Product and/or any maintenance part by persons other than Seller or Seller's authorized representatives. This warranty does not apply to accessory items. Further, this Warranty does not apply to damage or wear to the surface finish or appearance of the Product or normal wear and tear to the Product. This Warranty is limited to a purchaser who purchases the Product either directly from the Seller or from one of Seller's "Authorized Distributors". An Authorized Distributor is a Seller approved distributor that purchases the Product directly from the Seller for the sole purpose of re-selling the Product at retail, without any use or modifications whatsoever, to an end-purchaser. This warranty is specifically non-assignable and non-transferable.

DISCLAIMER OF WARRANTY

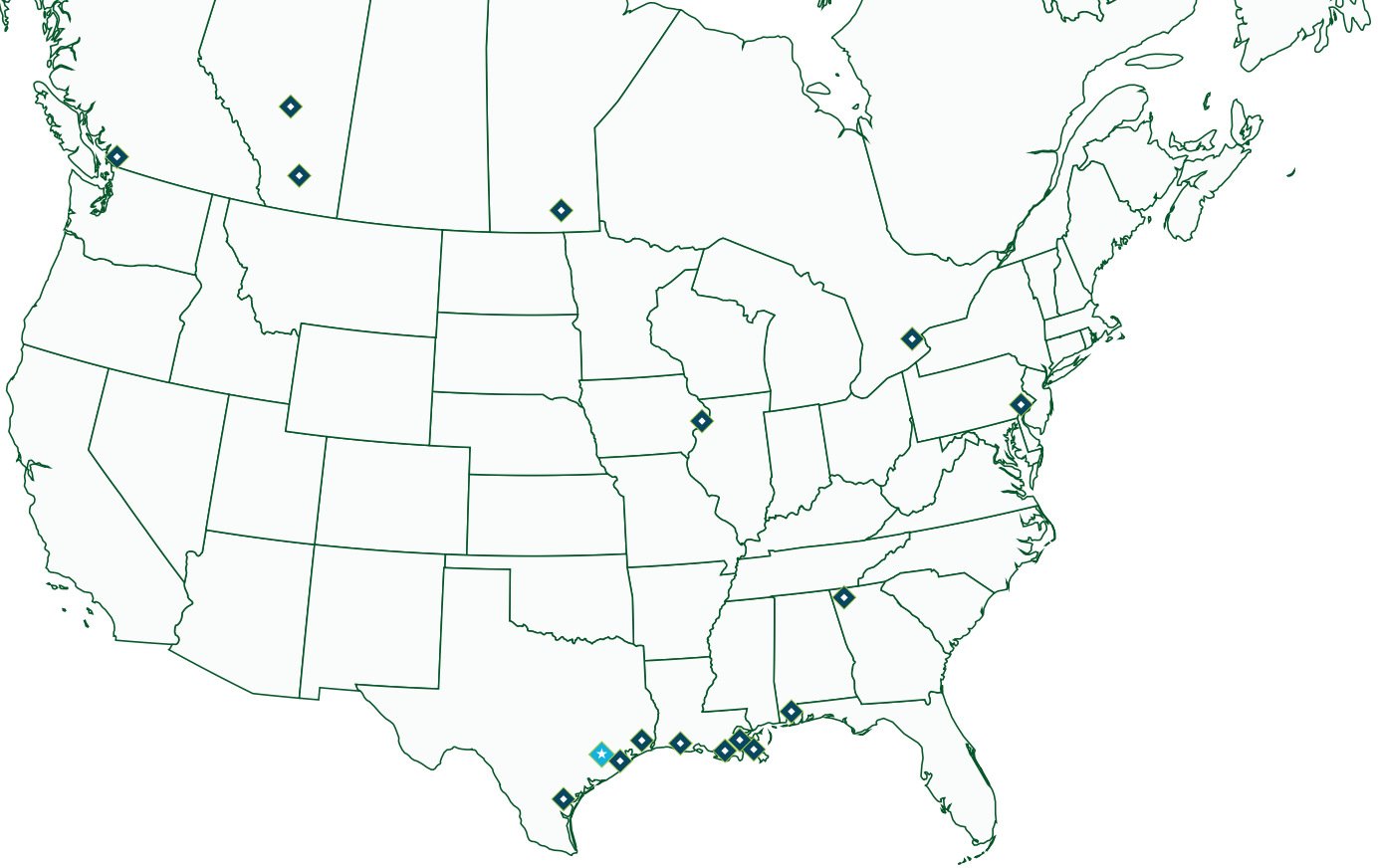
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