

Operating Instructions

Series SW/TWHD70000 Welding Hose Reels

Low Pressure Model Numbers:

TWHD74050 OLP	SWHD76000 OLPT	SWHD76005 OLPT
TWHD74050 OLPT	SWHD76050 OLPT	SWHD76100 OLPT



Dimensions

	1		2	
	in	mm	in	mm
A	20 1/4"	514	20 1/4"	514
B	19 3/4"	502	19 3/4"	502
C	7 13/16"	198	7 13/16"	198
D	3 7/8"	98	3 7/8"	98
E	7"	178	8 1/4"	210

IMPORTANT

Read this manual carefully before installing, operating or servicing this equipment.

SAFETY

Personal injury and/or equipment damage may result if proper safety precautions are not observed.

- Ensure that reel is properly installed before connecting input and output hoses.
- Bleed fluid/gas pressure from system before servicing reel.
- Before connecting reel to supply line, ensure that pressure does not exceed maximum working pressure rating of reel.
- Remember, even low pressure is very dangerous and can cause personal injury or death.
- Be aware of machinery and personnel in work area.
- If a leak occurs in the hose or reel, remove system pressure immediately.
- A high tension spring assembly is contained within the reel. Exercise extreme caution.
- Pull hose from reel by grasping the hose itself, not the control valve.
- Ensure that reel, hose, and equipment being serviced are properly grounded. Use an ohmmeter to check ground continuity.
- If reel ceases to unwind or rewind, remove system pressure immediately. Do not pull or jerk on hose!
- Treat and respect the hose reel as any other piece of machinery, observing all common safety practices.

Form# 1310-1019 Rev: 7/2020

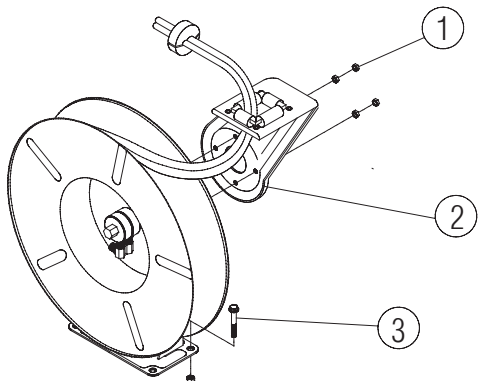
IN-SERVICE CAUTION:

- The user is cautioned not to shut off the fuel gas at the regulator or supply source first, as a flashback may result, and thereby damage the hose.
- Users are cautioned specifically to shut off the gas at the torch first, and then at the regulator or supply source, to limit permeation of gas through the hose wall. This should be done when the torch will not be used for periods in excess of 30 minutes.
- After the flame has been extinguished and the gas turned off at the supply source, it is recommended that any remaining gas be bled to minimize degradation of the rubber during long shutdowns.
- To prevent an accumulation or concentration of gas that could be explosive or otherwise harmful to personnel, adequate ventilation must be provided at all times, particularly in confined areas where fuel gas is being used.
- Additional advice for minimizing the permeation problem has been supplied by an NWSA member who states “The source of gas (fuel gas and oxygen) should be closed before leaving for the day or shift. After the cylinder or manifold valves have been closed, the torch valves (both fuel gas and oxygen) should be opened to remove all pressure from hoses.

INSTALLATION INSTRUCTIONS

MOUNTING

Caution: Unless reel was specified differently when ordering, maximum installation height is 16 feet. Do not exceed this distance. Observe all applicable NEC, OSHA & local codes when installing this equipment.



1. Unpack and inspect reel for damage. Turn by hand to check for smooth operation. Check for completeness.
2. Configure reel for top, side, or bottom-wind hose dispensing by removing bolts (or nuts) (1) securing guide arm bracket (2). **Caution:** When changing guide arm positions, the

U-bolt must be placed in the proper location as instructed in figure A below. The reel can “latch out” during use if this instruction is not adhered to.

3. Determine new guide arm bracket location and remove corresponding bolts, (or nuts). Position guide arm bracket to reel and replace bolts (or nuts).
4. Position reel on floor, wall or ceiling. Secure into place using four (customer supplied) screws or bolts (3).

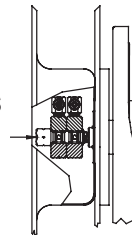
INSTALLING THE INPUT HOSES

Caution: Apply teflon tape to all input connections to insure a proper seal.

Series TW

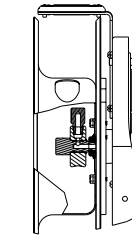
Acetylene/fuel gas inlet 1/4" FPT (Red)

Oxygen inlet 1/4" FPT (Green)



Series SW

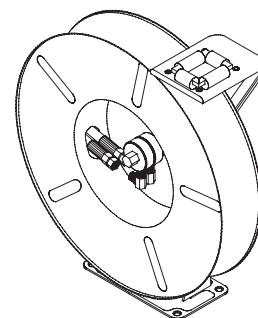
Acetylene/fuel gas inlet 1/4" FPT



INSTALLING THE OUTPUT HOSES

Caution: Use extreme caution; reel under tension, avoid releasing latch mechanism. Apply teflon tape to outlet connections.

1. Manually turn spool assembly until spring is tight, back off three turns, then latch.
2. Route output hoses through guide bracket.
3. Using a wrench, firmly hold on to output fittings on swivel while tightening the hose connector.



SERVICE INSTRUCTIONS

User servicing of the reel is limited to replacing the input/output hoses or swivel only. Refer all other repairs to an authorized service person or directly to Reelcraft Industries, Inc. Failure to do so can result in personal injury and/or equipment damage and may void the warranty.

Caution: Rewind hose on reel, then bleed pressure from system before performing the following procedures.

1. Replace hoses in accordance with procedures given in "Installation Instructions" section of this manual.

REPLACING THE SWIVEL

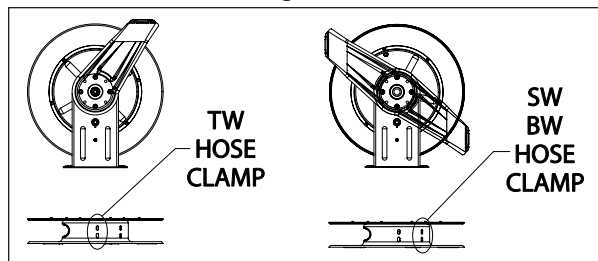
Caution: Remove supply line pressure before performing the following procedure.

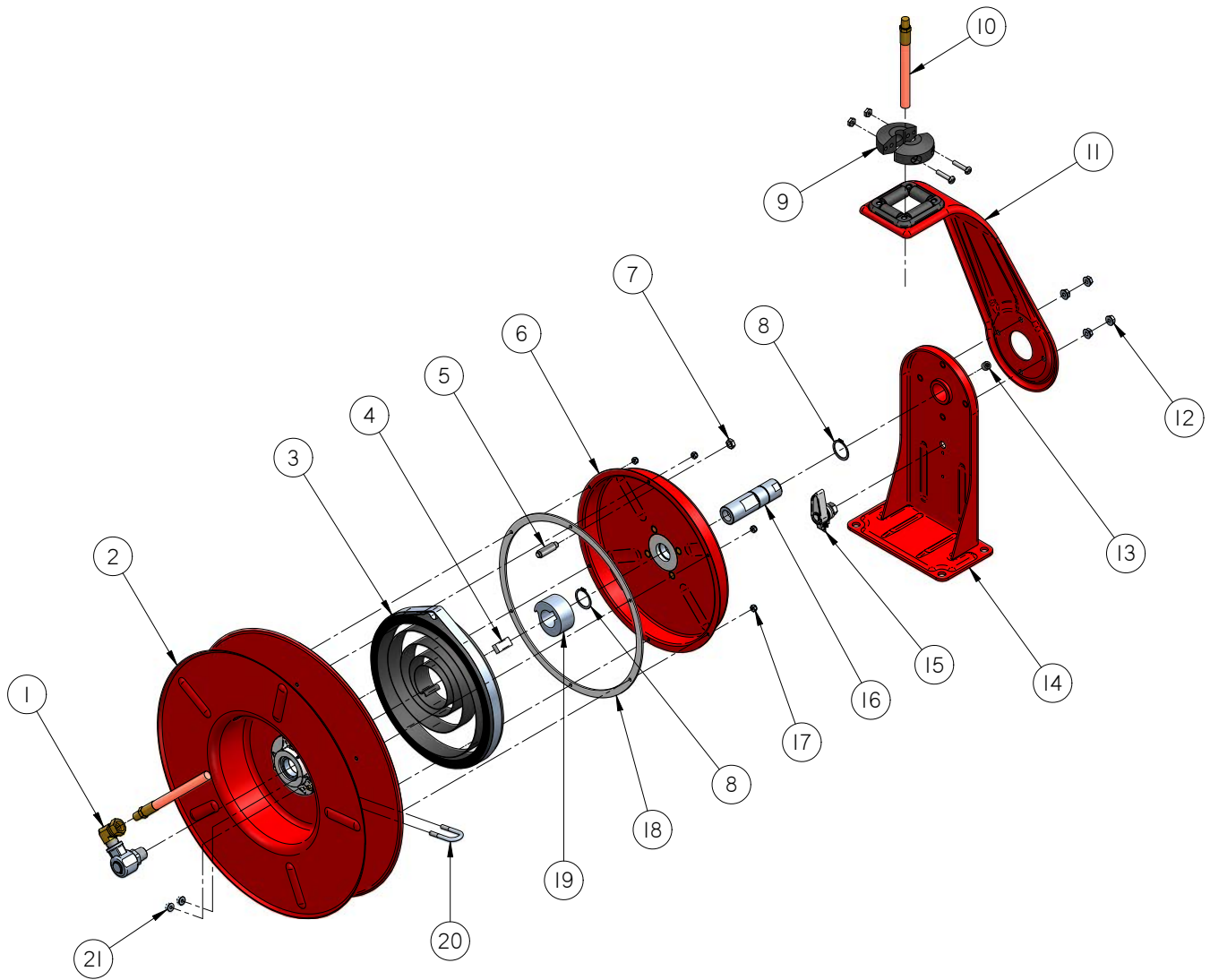
1. Remove supply line from swivel.
2. Remove swivel assembly from inlet shaft.
3. Apply thread sealant to threaded connection and re-install swivel assembly to inlet shaft by reversing steps 1 & 2.

ADJUSTMENTS

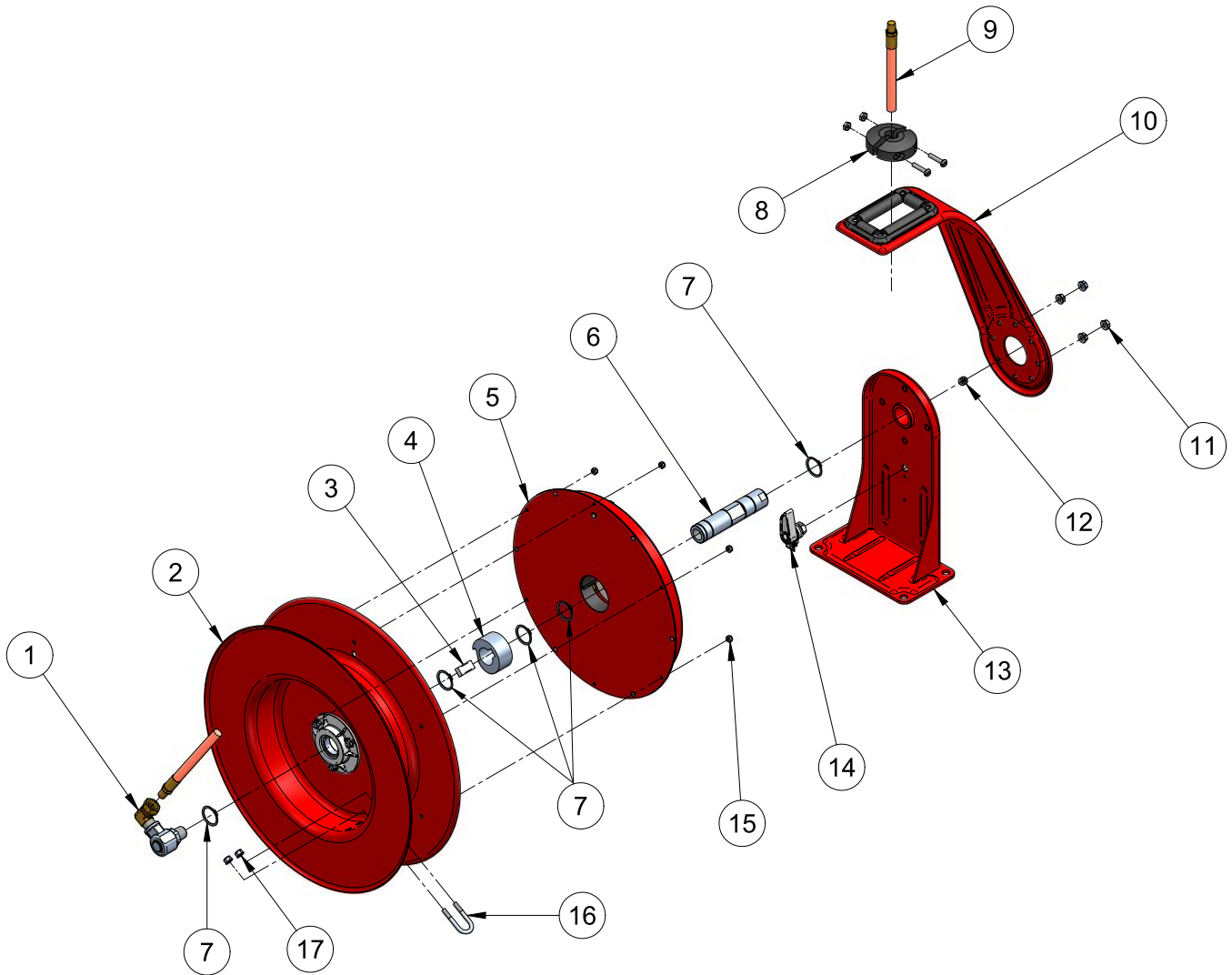
Caution: Use extreme caution; reel under tension. Avoid releasing latch mechanism. If necessary, adjust spring tension of reel by adding or removing wraps of hose from spool, one wrap at a time, until desired tension is obtained. Add wraps to increase tension. Remove wraps to decrease tension. When adding wraps of hose, be careful not to exceed the winding mechanisms spring capacity. Add just enough wraps of hose to achieve the desired tension. Damage to the winding mechanism will result if spring is over-tensioned.

Figure A





Item #	Description	# Req.	TWHD74050 OLP	TWHD74050 OLPT
1	Swivel Assembly	1	S260057-3	260057-1
2	Spool & Hub Assembly	1	602726	602726
3	Drive Spring Assembly	1	260028	260028
4	Spring Arbor Kit	1	600621	600621
5	Spring Case Stud	1	260031	260031
6	Spring Case Assembly	1	602727	602727
7	3/8-24 Jam Nut	1	S76-106	S76-106
8	Snap Ring	2	300007	300007
9	Bumper Stop Assembly	1	8-HR1004-3	8-HR1004-3
10	Hose Assembly	1	601032-50	601031-50
11	Guide Arm Assembly	1	600017	600017
12	5/16-18 Lock Nut	4	300107	300107
13	1/2-13 Set Screw	1	S35-84	S35-84
14	Base Assembly	1	602686	602686
15	Latch Pawl Assembly	1	602694	602694
16	Main Shaft	1	602241	602241
17	10-32 Hex Lock Nut	6	S82-15	S82-15
18	Gasket	1	260069	260069
20	U-Bolt	1	5-117440	5-117440
21	1/4-20 Nyloc Nut	2	261650-1	261650-1
Hose I.D. x Length			1/4" x 50'	1/4" x 50'
Reel Inlet Connection			1/4-18 NPTF	1/4-18 NPTF
Max. Operating Pressure			200 PSI	200 PSI
Max. Operating Temperature			200 °F	200 °F
Dimension Size Index			1	1



Item #	Description	# Req.	SWHD76000 OLPT	SWHD76050 OLPT	SWHD76005 OLPT	SWHD76100 OLPT
1	Swivel Assembly	1	602844-1	602844-1	602844-1	602844-1
2	Spool & Hub Assembly	1	602726	602726	602704	602704
3	Drive Spring Assembly	1	260028-1	260028-1	None	None
4	Spring Arbor Kit	1	600621	600621	600621	600621
5	Spring Case Stud	1	260031	260031	None	None
6	Spring Case Assembly	1	602727	602727	602697	602697
7	3/8-24 Jam Nut	1	S76-106	S76-106	None	None
8	Snap Ring	2	300007	300007	300007	300007
9	Bumper Stop Assembly	1	None	1-HR1004-3	None	1-HR1004-3
10	Hose Assembly	1	None	601163-50	None	602263-100
11	Guide Arm Assembly	1	600017	600017	602697	602697
12	5/16-18 Lock Nut	4	3000107	3000107	3000107	3000107
13	1/2-13 Set Screw	1	S35-84	S35-84	S35-84	S35-84
14	Base Assembly	1	602686	602686	602686	602686
15	Latch Pawl Assembly	1	602694	602694	602694	602694
16	Main Shaft	1	602231-2	602231-2	262948	262948
17	10-32 Hex Lock Nut	6	S82-15	S82-15	S82-15	S82-15
18	Gasket	1	260069	260069	None	None
20	U-Bolt	1	3-117440	3-117440	3-117440	3-117440
21	1/4-20 Nyloc Nut	2	261650-1	261650-1	261650-1	261650-1
Hose I.D. x Length			None	3/8" x 50'	None	3/8" x 100'
Reel Inlet Connection			3/8-18 NPTF	3/8-18 NPTF	1/2-14 NPT	1/2-14 NPT
Max. Operating Pressure			200 PSI	200 PSI	200 PSI	200 PSI
Max. Operating Temperature			120 °F	120 °F	120 °F	120 °F
Dimension Size Index			2	2	2	2