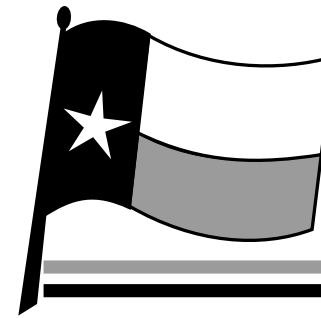


## TX-JF24 - REASSEMBLE

1. FOR BEST RESULTS, USE JET FAN REPAIR KIT (TX-JFRK) TO ENSURE ORIGINAL REPLACEMENT PARTS AND ALL COMPONENTS MEET ORIGINAL STANDARDS.
2. MAKE SURE END CAP AND FAN HUB GASKETS (TX-JF2023) ARE SMOOTH AND FREE FROM NICKS AND TEARS.
3. PRESS ONE BEARING (TX-JF2005) ON THE SIDE OF THE SHAFT OPPOSITE THE THREADED END.  
**DO NOT PRESS BEARING ON THREADED END AT THIS POINT.**
4. POSITION THE LARGE FLANGE OF THE SPEEDY SLEEVE (TX-JF2007) TOWARD THE BEARING AND PLACE SPEEDY SLEEVE OVER THE SHAFT BEHIND THE FIRST BEARING. USE THE SLEEVE TOOL (SUPPLIED) TO PRESS THE SPEEDY SLEEVE INTO PLACE. **THE SPEEDY SLEEVE SHOULD NOT TOUCH THE BEARING.** ALLOW APPROXIMATELY 1/8" TO 1/4" BETWEEN THE SLEEVE AND THE BEARING AND MAKE SURE THE SLEEVE IS SMOOTH TO THE SHAFT. ANY NICKS IN THE SLEEVE COULD CAUSE DAMAGE TO THE AIR SEAL.
5. INSERT ONE TOLERANCE RING (TX-JF2020) INTO INNER MOST GROOVE OF BEARING HOUSING. **DO NOT INSERT BOTH TOLERANCE RINGS AT THIS POINT.**
6. DROP SHAFT CONTAINING ONE BEARING AND SPEEDY SLEEVE INTO HOUSING UNTIL IT RESTS AGAINST THE ONE INSTALLED TOLERANCE RING.
7. THE OUTER MOST TOLERANCE RING CAN NOW BE INSTALLED.
8. DROP SECOND BEARING OVER THE SHAFT AND START PRESSING INTO HOUSING. BOTH BEARINGS ARE PRESSED INTO PLACE ALMOST SIMULTANEOUSLY. **(TOLERANCE RINGS ARE DESIGNED FOR ONE PRESSING ONLY. NEVER ATTEMPT TO PRESS INNER BEARING THROUGH OUTER TOLERANCE RING)**
9. SECURE SHAFT ASSEMBLY IN HOUSING WITH LARGE SNAP RING (TX-JF2008).
10. ON THE OPPOSITE SIDE, INSERT AIR SEAL (TX-JF2006) INTO GROOVE AND SEAT FIRMLY.
11. PLACE LOCK SAFETY SHIELD (TX-JF2014) OVER SHAFT.
12. INSTALL SMALL LOCK RING (TX-JF2009).
13. PLACE GASKET (TX-JF2023) AND END CAP (TX-JF2003) ONTO HOUSING AND SECURE. ALTERNATE TIGHTENING OF BOLTS TO INSURE PROPER AIR SEAL.
14. PLACE SHAFT KEY (TX-JF2013) INTO SLOT AND SLIDE FAN BLADE OVER SHAFT.
15. USE RUBBER Mallet TO ENSURE THAT FAN BLADE SEATS AGAINST BEARING HUB.
16. **CLEAN SHAFT THREADS BEFORE INSTALLING BEAR HUG NUT.** THIS IS IMPORTANT BECAUSE ALUMINUM FROM THE FAN BLADE WILL USUALLY BE CAUGHT BETWEEN THE THREADS WHILE PLACING FAN BLADE ONTO SHAFT. IF THIS MATERIAL IS NOT REMOVED PRIOR TO INSTALLING THE BEAR HUG NUT, IT MAY CAUSE GALLING OF THE NUT AND NOT ALLOW FOR PROPER TIGHTENING. IN ADDITION, IT MAY BE NECESSARY TO CUT THE NUT FROM THE SHAFT WHICH MAY ALSO DAMAGE THE SHAFT. SECURE HOUSING TO ASSEMBLY TABLE WITH CLAMPS TO KEEP HOUSING FROM TURNING DURING BEAR HUG TIGHTENING PROCESS.
17. TIGHTEN BEAR HUG NUT (TX-JF2010) ONTO SHAFT. PLACE A WOOD BLOCK BETWEEN THE FAN BLADE AND STATIONARY HOUSING TO KEEP BLADE FROM ROTATING DURING THIS PROCESS. MAKE SURE THE NUT IS TIGHT AGAINST THE BLADE.
18. INSTALL GASKET (TX-JF2023) AND END CAP (TX-JF2003) ONTO BLADE. ALTERNATE TIGHTENING OF BOLTS TO INSURE PROPER AIR SEAL.
19. REMOVE WOOD BLOCK AND CHECK TO SEE THAT FAN BLADE TURNS FREELY.
20. INSTALL BOTH FAN GUARD SCREENS (TX-JF2404) AND TEST.
21. MAKE SURE GROUNDING LUG (AM7) IS AFFIXED TO ONE OF THE FAN GUARD SCREEN BOLTS. THE GROUNDING LUG IS USED WITH AM29 (GROUNDING CLAMP WITH 6' WIRE) TO DISCHARGE STATIC DURING HAZARDOUS OR EXPLOSIVE ATMOSPHERE USE.



# TEXAS PNEUMATIC TOOLS, INC.

Service, Operation AND Parts Manual

## TX-JF24



## JET FAN

SPECIFICATIONS	Model#	TXJF24
	Weight	122 lbs
	Hose Size	1"
	Air Inlet	1"
	Working Pressure	40/100 psi
	Max Pressure	110 psi
	Mounting Slot Diameter	1"
	Bolt Circle Diameter	27.5" - 30.25"

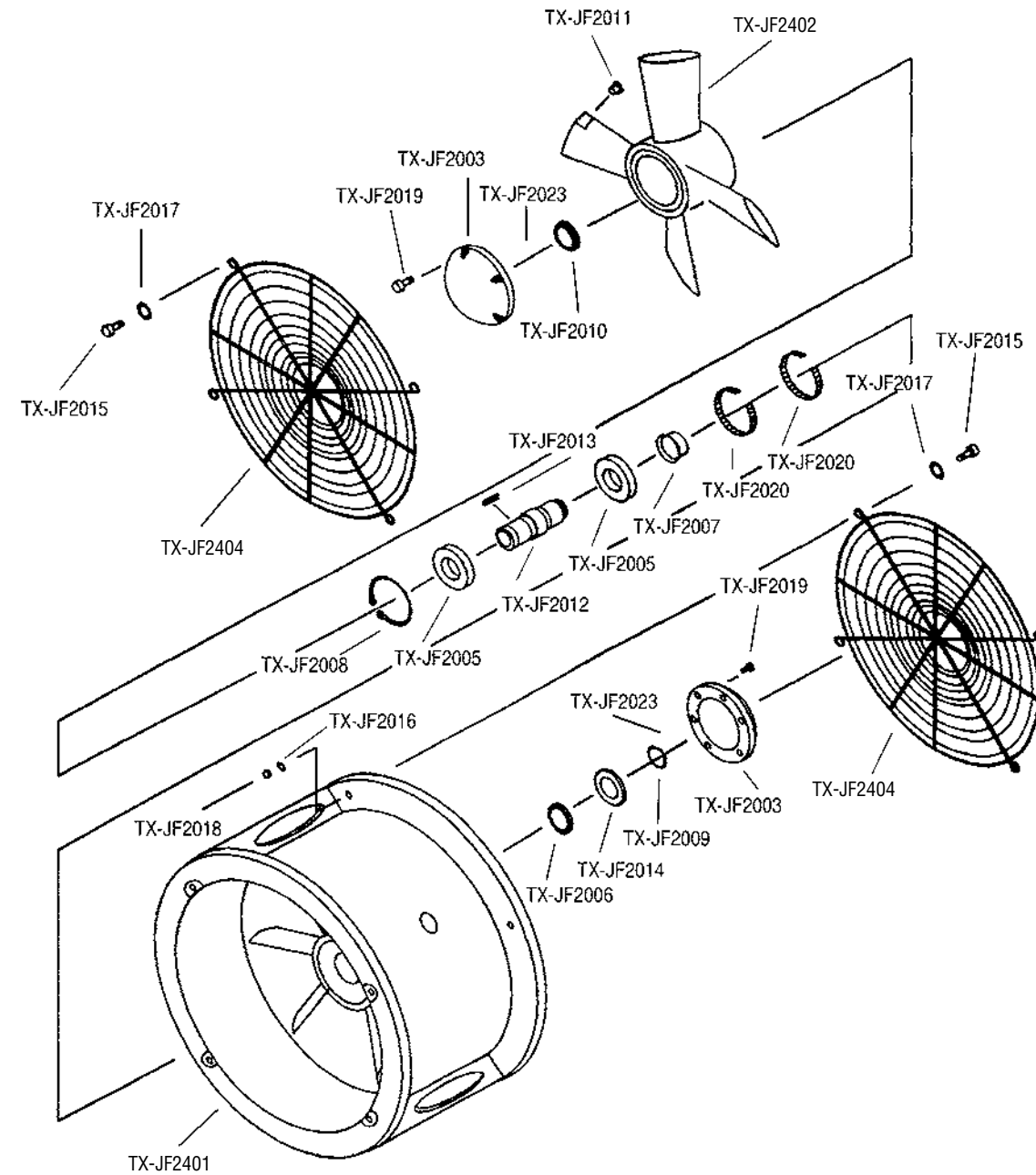
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## TX-JF24 - DISASSEMBLE

1. REMOVE BOTH SCREENS FROM HOUSING (TX-JF2404)
2. REMOVE FAN BLADE END CAP AND STATIONARY HOUSING END CAP. (TX-JF2003)
3. USE PART NO. TX-JF2022 (BEAR HUG SOCKET) TO REMOVE PART NO. TX-JF2010 (BEAR HUG NUT). USE WOOD BLOCK TO WEDGE BETWEEN FAN BLADE AND GUIDE VANE STRUT OF STATIONARY HOUSING IN ORDER TO KEEP THE FAN BLADE FROM TURNING WHILE REMOVING BEAR HUG NUT.
4. AFTER THE BEAR HUG NUT HAS BEEN REMOVED, MAKE SURE THE SHAFT THREADS ARE CLEAN AND THAT NO BURRS OR EXTRUSIONS EXIST ON THE SHAFT. THIS WILL EASE IN THE REMOVAL OF THE FAN BLADE.
5. REMOVE FAN BLADE FROM SHAFT USING A BEARING PULLER. IF A BEARING PULLER IS NOT AVAILABLE, A RUBBER Mallet MAY BE REQUIRED TO HELP EXTRACT FAN BLADE FROM SHAFT. (FROM THE REVERSE SIDE, USE A FLAT PUNCH AND RUBBER Mallet WITH ALTERNATING BLOWS)
6. ONCE THE FAN BLADE HAS BEEN REMOVED, THE LARGE SNAP RING (TX-JF2008) IS EXPOSED. USE LARGE SNAP RING PLIERS TO REMOVE SNAP RING.
7. ON THE OPPOSITE SIDE, USE A SMALLER SET OF SNAP RING PLIERS TO REMOVE SMALL SNAP RING (TX-JF2009).
8. ONCE THE SMALL SNAP RING HAS BEEN REMOVED, THE LOCKING SAFETY SHIELD (TX-JF2014) CAN BE REMOVED.
9. THE SHAFT AND BEARINGS ASSEMBLY CAN NOW BE PRESSED OUT OF THE HOUSING. DO NOT APPLY EXTREME PRESSURE WHEN PRESSING OR STATIONARY HUB GUIDE VANES MAY FRACTURE.
10. USE A SMALL PUNCH TO REMOVE THE AIR SEAL (TX-JF2006) FROM THE STATIONARY HOUSING.
11. REMOVE BEARING TOLERANCE RINGS (TX-JF2020) FROM INSIDE BEARING HOUSING AND DISPOSE. **TOLERANCE RINGS CANNOT BE REUSED**
12. REMOVE SPEEDY SLEEVE (TX-JF2007) FROM SHAFT. ONCE REMOVED, THIS PART CAN NOT BE REUSED.
13. USE BEARING PULLER TO REMOVE BEARINGS FROM SHAFT.
14. CLEAN ALL NECESSARY PARTS FOR REASSEMBLY.

PART#	DESCRIPTION	PART#	DESCRIPTION
TX-JF2401	20" Jet Fan Housing	TX-JF2013	Key
TX-JF2402	Nozzle Jet Prop	TX-JF2014	Lock Safety Shield
TX-JF2003	Inlet / Outlet Cap	TX-JF2015	1/4" - 20 x 1 1/4" Hex Cap Screw
TX-JF2404	20" Stainless Steel Fan Guard	TX-JF2016	1/4" - Lock Washer
TX-JF2005	Bearing	TX-JF2017	1/4" - Flat Washer
TX-JF2006	Air Seal	TX-JF2018	1/4" - 20 Hex Nut
TX-JF2007	Speedy Sleeve	TX-JF2019	5/16" - 18 x 3/4" Hex Socket Screw
TX-JF2008	Large Snap Ring	TX-JF2020	Tolerance Ring
TX-JF2009	Small Snap Ring	AM29	6' Grounding Clamp
TX-JF2010	Locking Bear Hug	TX-JF2022 (NS)	Bear Hug Socket ( <i>removal tool</i> )
TX-JF2011	Nozzle Jet	TX-JF2023	Inlet / Outlet Cap Gasket
TX-JF2012	Shaft		

## COMPONENT DESIGN

**FAN BLADE AND HOUSING:** Spark resistant 356 aluminum heat treated to T6 aircraft aluminum specification.

**FAN GUARDS:** Stainless steel; meets OSHA requirements.

**SHAFT:** Stainless steel.

**LOCKING MECHANISMS:** Stainless steel lock shield, bear hug retainer.

**BEARINGS:** Premium ball bearings sealed with a high performance synthetic grease.

**FLANGES:** Matches 24" American Petroleum Institute tank opening.