

ABRASIVE DIAMOND HEAD ASSEMBLY 90K

Overview

The following procedure is recommended for the assembly and installation of the abrasive diamond head assembly 90k.

Assembly

1. Install the o-ring (11154) on the abrasive feed adapter (10964).

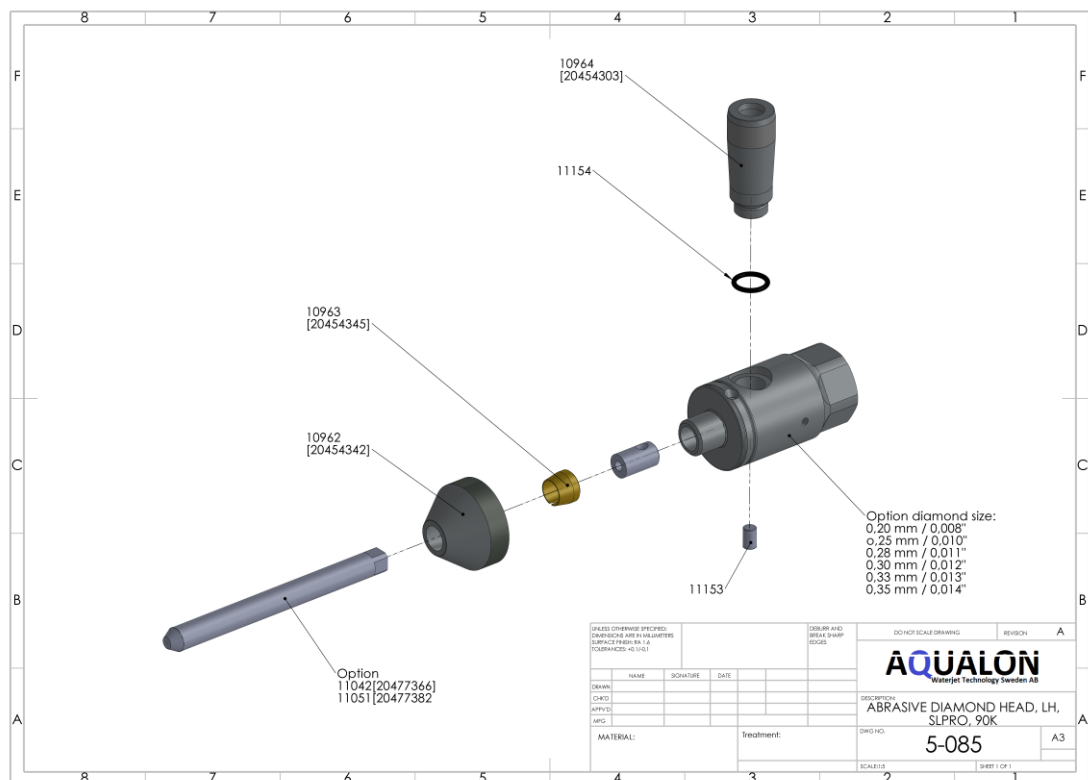


Figure 1: Abrasive diamond head

2. Thread the adapter into the body assembly and hand tighten.
3. Remove the retainer nut (10962) and collet (10963) from the body.
4. Slide the focusing tube into the body assembly until it bottoms out on the wear insert.
5. Position the collet on the focusing tube ensuring the smaller end of the collet faces the retainer.
6. Push the focusing tube into the body assembly until it bottoms out on the wear insert.

Note

Align the index flats on the focusing tube to ensure the focusing tube seats against the wear insert. The focusing tube will not turn when properly positioned.

7. Thread the retainer nut (10962) onto the body and hand tighten.
8. Apply Pure goop (10196) to the thread and the sealing surface on the nozzle tube and the body assembly. Torque the components to 10 ft-lbs (14 Nm).



Do not tighten the nozzle tube and body assembly when the unit is pressurized. Ensure all system pressure has been relieved.



When installing the body assembly onto a nozzle tube, inspect the tapered end of the tube for any defects such as pits or marring and replace if necessary. Always apply goop in the sealing surfaces!

Note

Repeated removal and installation of the body assembly may wear the sealing surfaces, Higher torque may be required to reseal the components. Increase the torque in 5 ft-lbs (7 Nm) increasements until the components have sealed. DO NOT EXCEED 50 ft-lbs (68 Nm)

If the components still do not seal properly, replace the nozzle tube.



Over tightening can damage the high-pressure conical sealing surfaces on the orifice housing, the diamond orifice and nozzle tube.