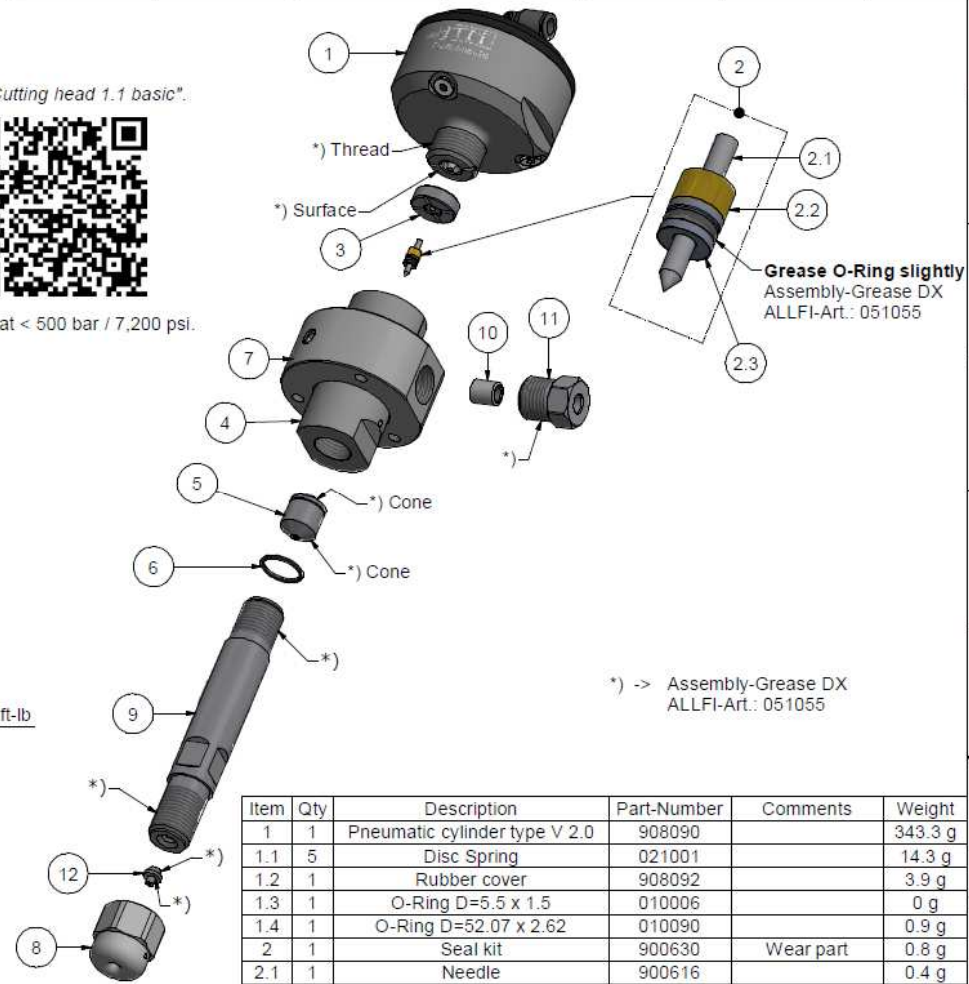
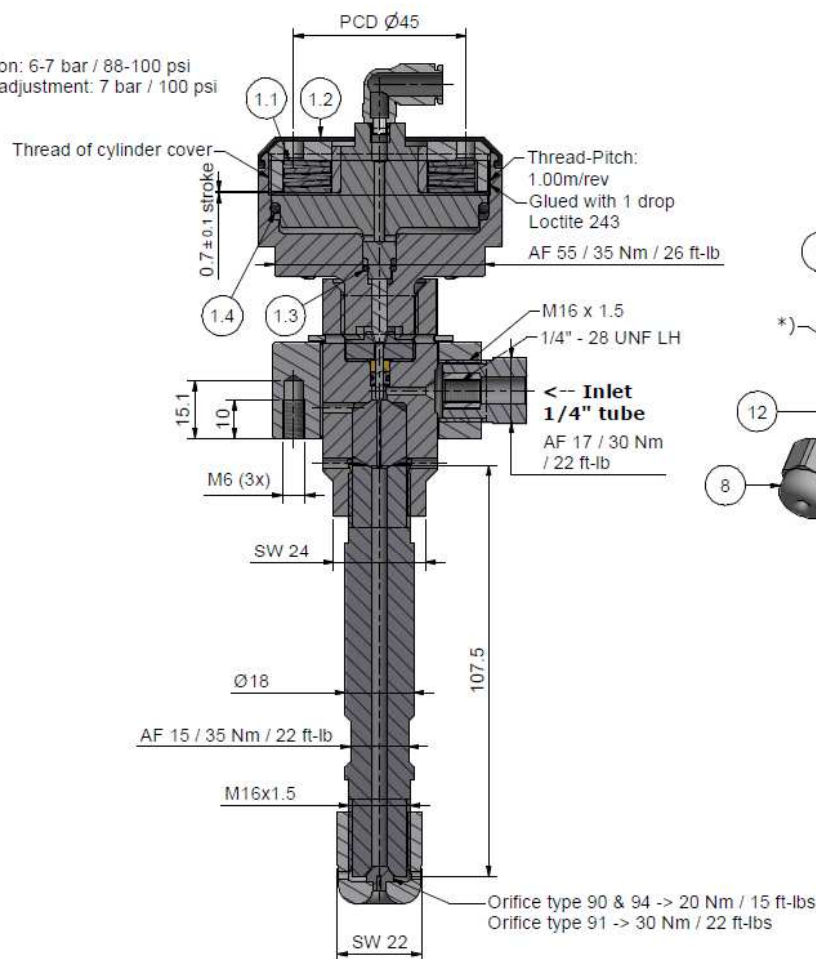
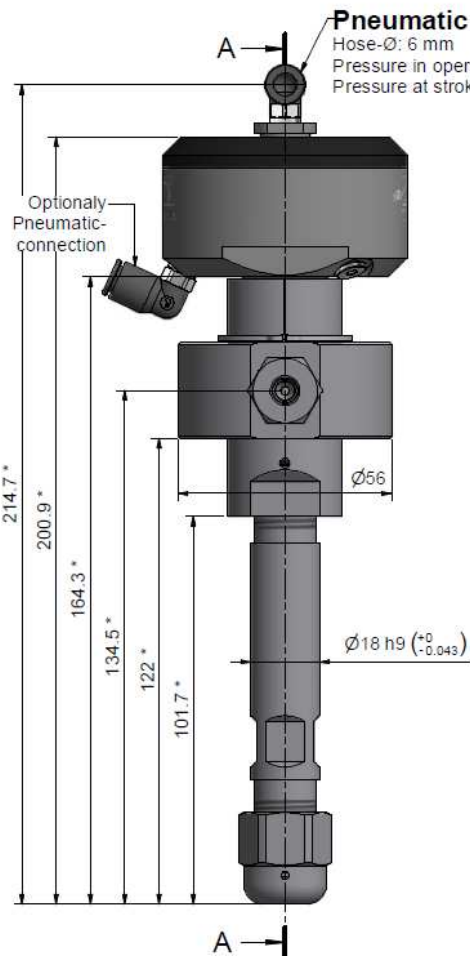


## Assembling - Maintenance

This drawing is appendix A of the installation and maintenance instruction "Cutting head 1.1 basic".  
The complete installation and maintenance instruction is hosted at:  
<https://www.alfi.com/en/services/downloads/product-manuals/>



- Pneumatic-cylinder must be pressurised with air during assembling and disassembling of valve case and collimation tube.
- Stroke adjustment: Stroke 0.6 - 0.8 mm / 0.0235 - 0.0315", air pressure 7 bar - 100 psi, adjustment range +/- 1 revolution. (Attention: Thread of cylinder cover must not be visible)
- Function test with several open and closed cycles.
- After finishing maintenance flush the complete cutting head without nozzle at < 500 bar / 7,200 psi.
- Pressure relief holes must not be covered or closed.



\*) -> Assembly-Grease DX  
ALLFI-Art.: 051055

Item	Qty	Description	Part-Number	Comments	Weight
1	1	Pneumatic cylinder type V 2.0	908090		343.3 g
1.1	5	Disc Spring	021001		14.3 g
1.2	1	Rubber cover	908092		3.9 g
1.3	1	O-Ring D=5.5 x 1.5	010006		0 g
1.4	1	O-Ring D=52.07 x 2.62	010090		0.9 g
2	1	Seal kit	900630	Wear part	0.8 g
2.1	1	Needle	900616		0.4 g
2.2	1	Supporting ring	900614		0.4 g
2.3	1	HD-seal	900618		0 g
3	1	Supporting Disc basic 1:1	906102		10.5 g
4	1	Valve case	900610	Wear part	245.8 g
5	1	Valve seat	900014	Wear part	17.2 g
6	1	O-Ring D=14 x 1.5	010013		0.1 g
7	1	Coupling Ring	900074		305.8 g
8	1	Orifice Cap M16 x 1.5	900060		47.1 g
9	1	Collimation tube L=107.5	900052	Wear part	178 g
10	1	Collar 1/4"	711403		3.1 g
11	1	Gland Nut 1/4"	701403		29.1 g
12	1	Orifice Type 94	0094xx	Not included	1.1 g

General tolerances ISO 2768-1 mK. Designs and drawings created and produced by the contractor are the contractor's intellectual property and may only be used for the purposes of the order.

Amendment:	Replace for -
	Replaced by -
Drawn: 29.08.2022 AM	Checked: 29.08.2022 BT
Release: 14.12.2022 GB	Index-release: -

## Cutting head basic 1.1

Scale  
1 : 1

Max. 4150 bar / 60,000 psi



ALLFI AG - RIEDENMATT 1 - CH-8370 STANS  
PHONE +41(0)41-818 05 05  
E-MAIL: sales@alfi.com

http://www.alfi.com

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No. of sheets 2