

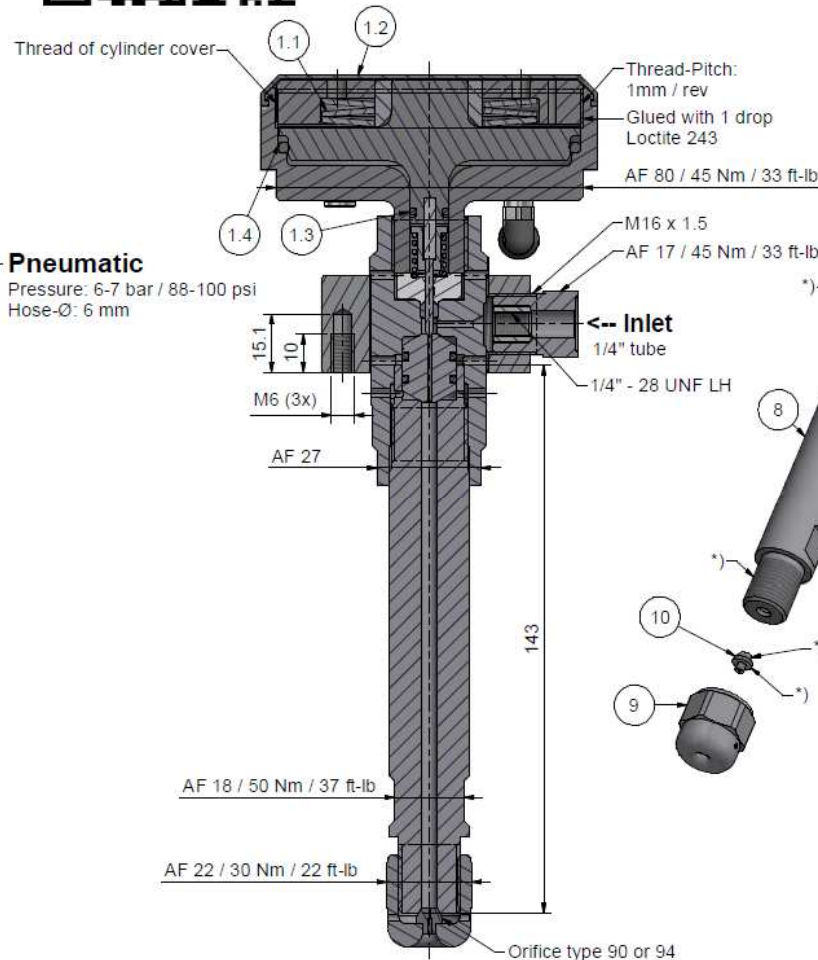
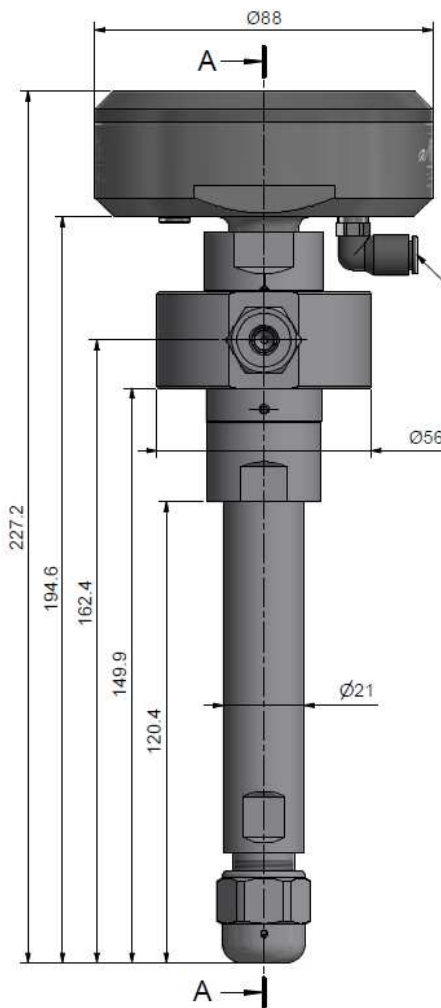
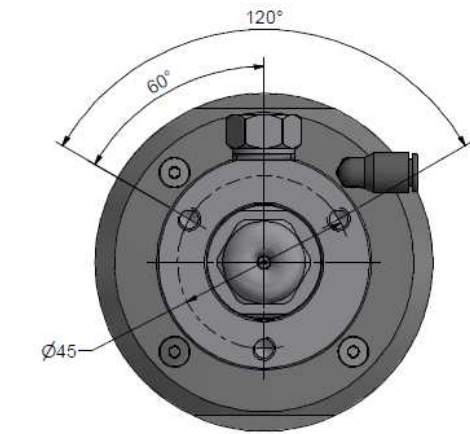
## Assembling - Maintenance

This drawing is appendix A of the installation and maintenance instruction "Cutting head type XVIII 2.0".  
Complete installation and maintenance instruction refer to QR-Code or:  
<https://www.alfi.com/en/services/downloads/product-manuals/>

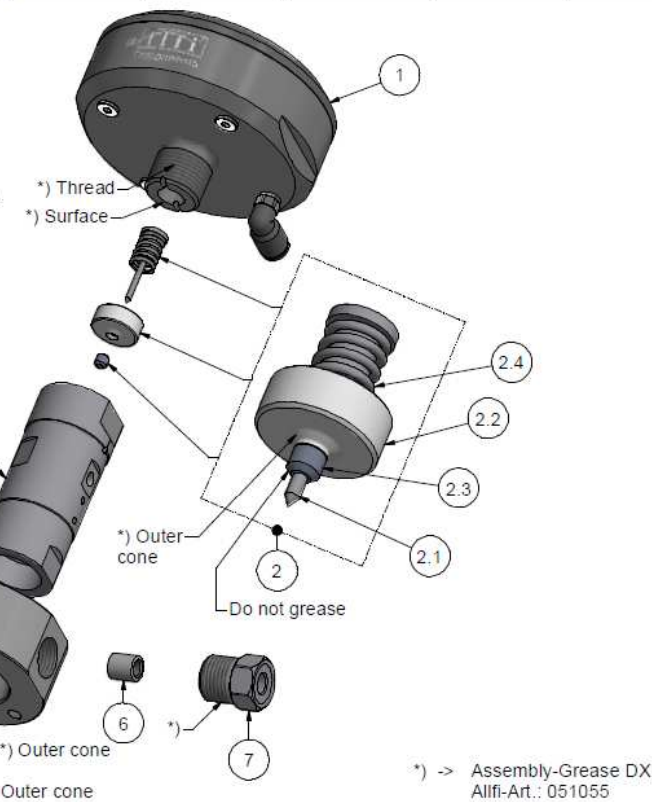
- Pneumatic-cylinder must be pressurised with air during assembling and disassembling of valve case and collimation tube.
- Stroke has to be 0.6 - 0.8 mm / 0.0235 - 0.0315", air pressure 7bar - 100 psi, adjustment range +/- 1 revolution.
- Function test with several open and closed cycles.
- After finishing maintenance flush the complete cutting head without nozzle at < 500 bar / 7200 psi.
- Pressure relief holes must not be covered or closed.



A-A (1:1)



**Pneumatic**  
Pressure: 6-7 bar / 88-100 psi  
Hose-Ø: 6 mm



Item	Qty	Description	Part-Number	Comments	Weight
1	1	Pneumatic cylinder XVIII	908590-P		534.9 g
1.1	3	Disc spring	021025		21.6 g
1.2	1	Rubber cover	908594-P		7.6 g
1.3	1	O-Ring D=6.75 x 1.78	010049		0.1 g
1.4	1	O-Ring D=73.00 x 3.0	010155		1.7 g
2	1	Seal Kit 2.0	901432	Wear part	15.6 g
2.1	1	Valve needle	901416		3.1 g
2.2	1	Pressure plate 2.0	900627		11 g
2.3	1	HP-seal 2.0	900622		0.1 g
2.4	1	Compression Spring	021006		1.4 g
3	1	Coupling Ring	900074		305.8 g
4	1	Valve case 2.0	900413-P	Wear part	247.8 g
5	1	Valve Seat	900411	Wear part	15.3 g
6	1	Collar 1/4"	711403		3.1 g
7	1	Gland Nut 1/4" 90,000psi	701403-P		27.9 g
8	1	Collimation tube L=143	970071-P	Wear part	323.8 g
9	1	Orifice Cap	900060-P		44 g
10	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 904201-P
Drawn by:	07.11.2022 AM
Checked:	09.11.2022 BT
Release:	11.11.2022 GB
Index-release:	

Cutting head type XVIII 2.0 PWJ

Scale  
1 : 1

Max. 6200 bar / 90,000 psi



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908401-P

Index Sheet No. 2  
No. of sheets 2