

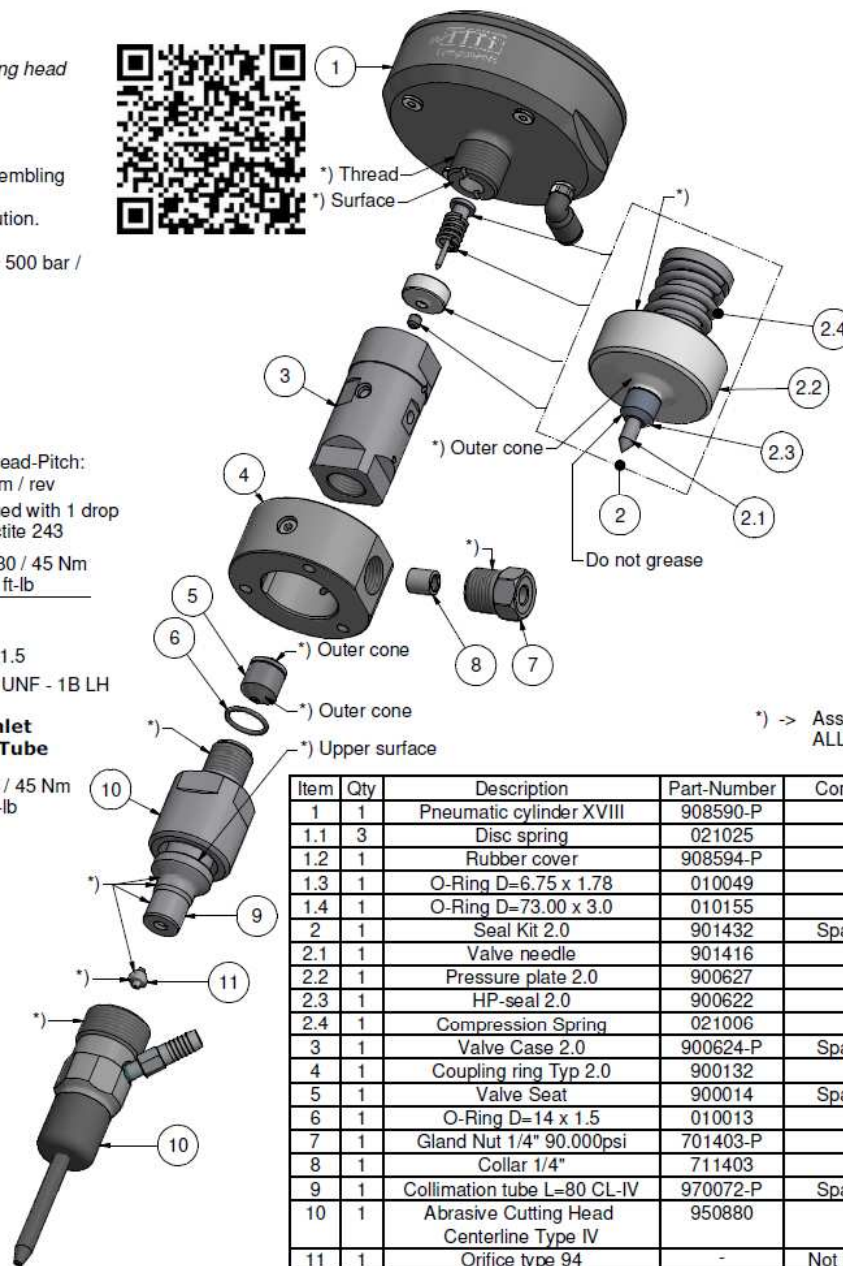
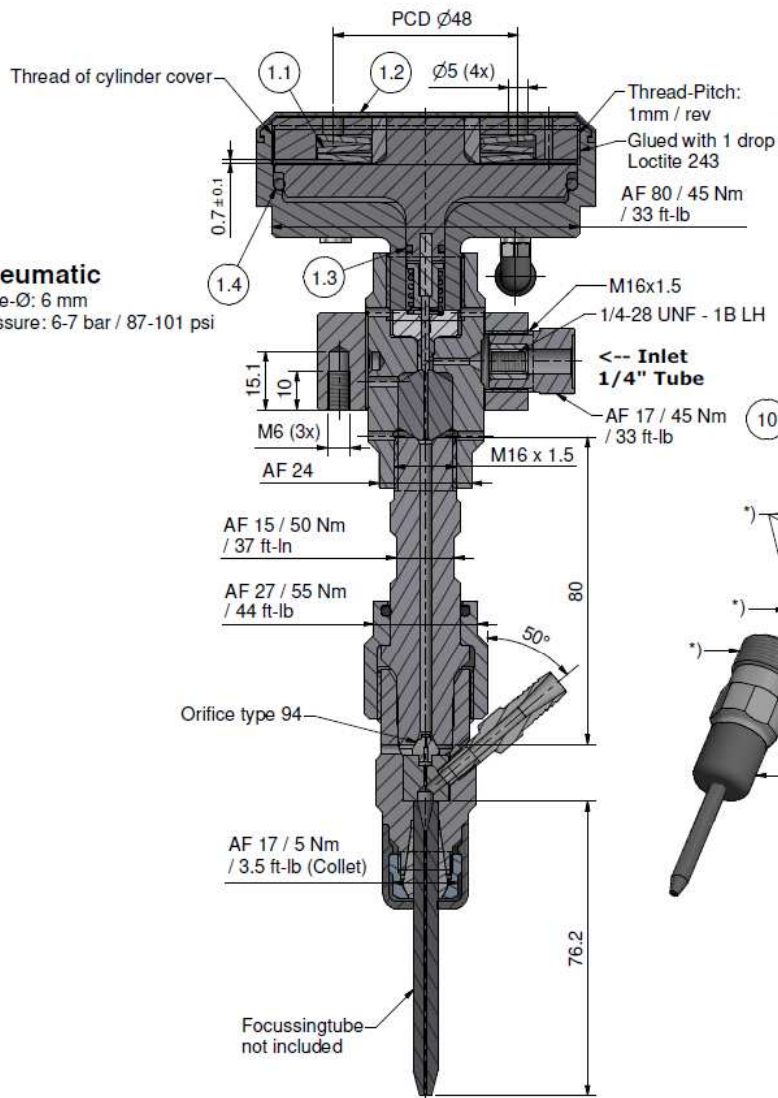
Assembling - Maintenance

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.allfi.com/en/services/downloads/product-manuals/>

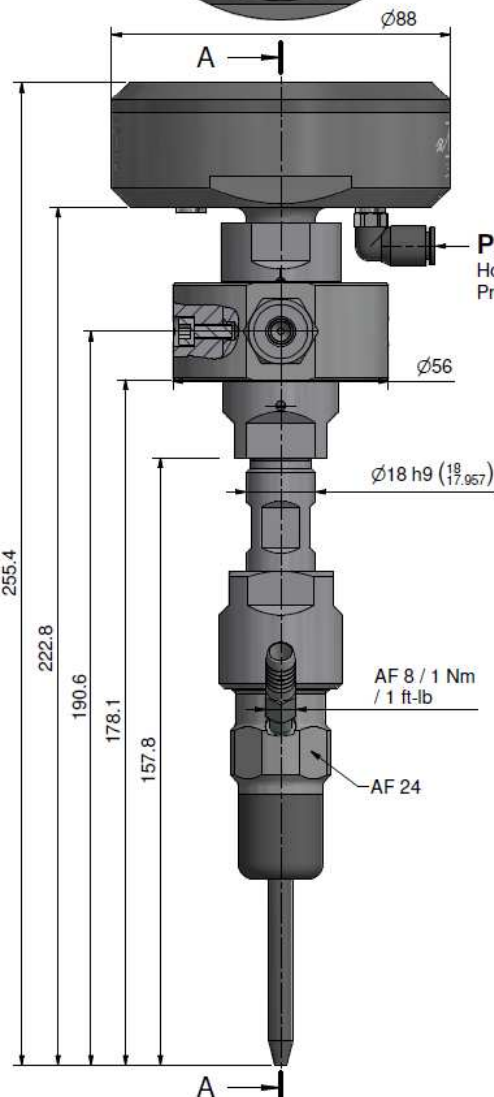
- Pneumatic-cylinder must be pressurised with air during assembling and disassembling of valve case and collimation tube.
- Stroke has to be 0.6 - 0.8 mm / 0.0235 - 0.0315", adjustment range +/- 1 revolution.
- Function test with several open and closed cycles.
- After finishing maintenance flush the complete cutting head without nozzle at < 500 bar / 7200 psi.
- Pressure relief holes must not be covered or closed.
- Use only orifice Typ 94.



Schnitt A-A



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



Pneumatic
Hose- \varnothing : 6 mm
Pressure: 6-7 bar / 87-101 psi

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	Spare 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	Valve Case 2.0	900624-P	Spare part	236.1 g
4	1	Coupling ring Typ 2.0	900132		306.8 g
5	1	Valve Seat	900014	Spare part	17.2 g
6	1	O-Ring D=14 x 1.5	010013		0.1 g
7	1	Gland Nut 1/4" 90.000psi	701403-P		27.9 g
8	1	Collar 1/4"	711403		3.1 g
9	1	Collimation tube L=80 CL-IV	970072-P	Spare part	135.2 g
10	1	Abrasive Cutting Head Centerline Type IV	950880		269.4 g
11	1	Orifice type 94	-	Not included	1.1 g

General tolerances ISO 2768-1 m

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: A) 0159, 900132 was 900074, 17.11.2023 AM

Replace for: -

Replaced by: -

Drawn: 10.02.2021 AM

Checked: 08.11.2021 RB

Release: 08.11.2021 RB

Index-release: -

Cutting Head Type XVIII 2.0 AWJ

Scale 1 : 1

Max. 6200 bar / 90,000 psi

908500-P

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