

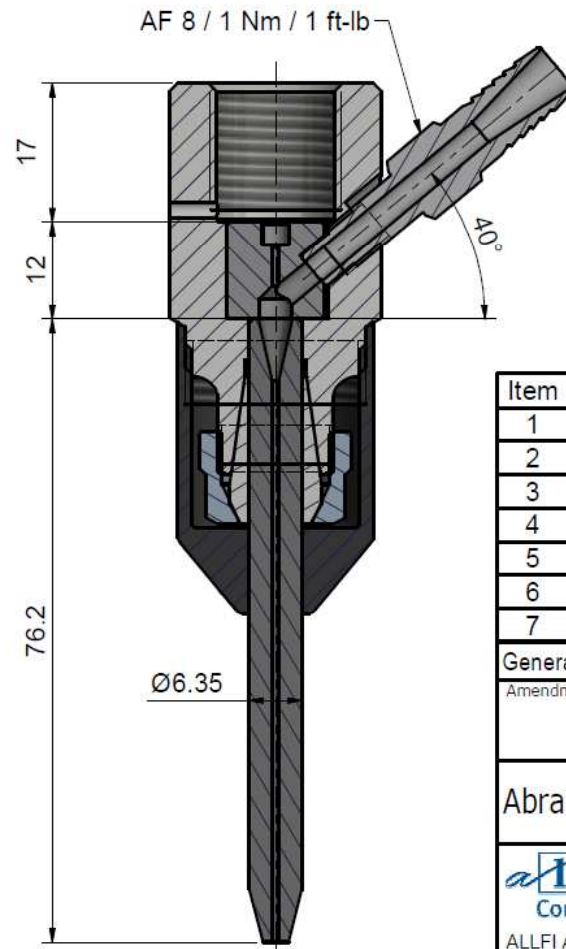
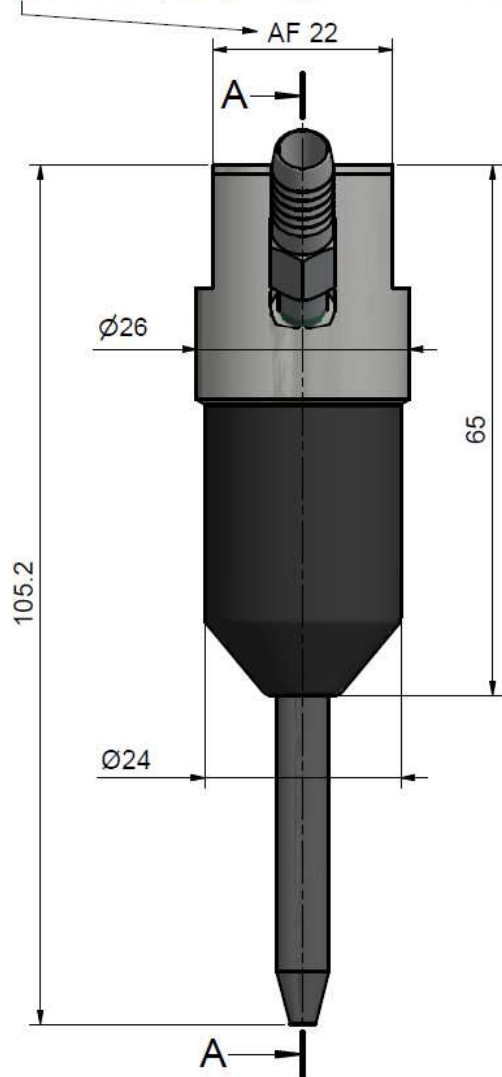
Assembling - Maintenance

This drawing is appendix A of the installation and maintenance manual "Abrasive Cutting Head".

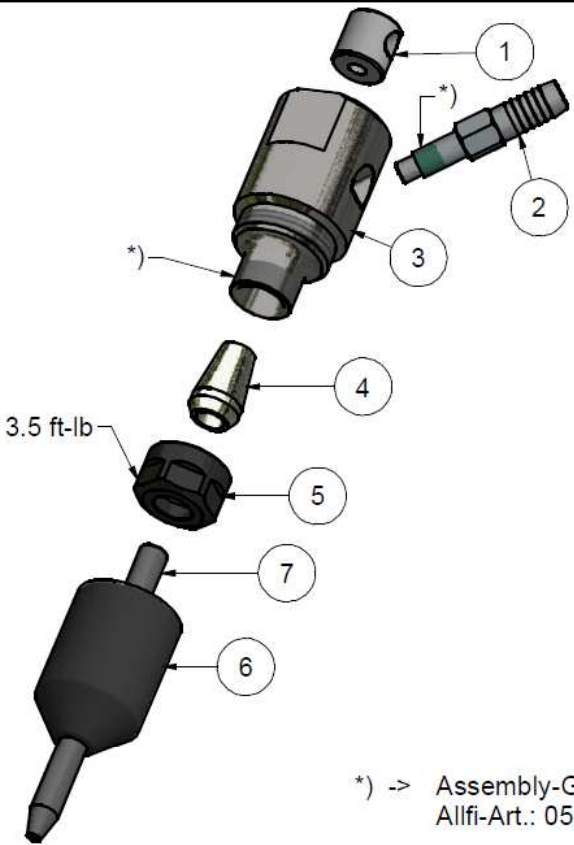
Complete installation and maintenance instruction refer to QR-Code or:
<https://www.allfi.com/en/services/downloads/product-manuals/>



- Pressure relief holes may not be covered or closed.
- Assembly tool 881610 for assembly the Mixing chamber
- Suitable orifices and associated torque:
 4150 bar / 60,000 psi - Type 91 / 30Nm / 22 ft-lb
 4150 bar / 60,000 psi - Type 94 / 20Nm / 15 ft-lb
 6200 bar / 90,000 psi - Type 94-S1 / 30Nm / 22 ft-lb



AF 17 / 5 Nm / 3.5 ft-lb



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

Item	Qty	Description	Part-Number	Comments	Weight
1	1	Mixing chamber	950813	Wear part	17 g
2	1	Pipe socket	950812	Wear part	8.4 g
3	1	Casing	950811		111.2 g
4	1	Chuck	000301		6.2 g
5	1	Clamping Nut	000090		12.1 g
6	1	Protection Cap	950204		7.4 g
7	1	Focussing tube	635-0762-XXX	Not included	17.6 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. Weight 0.18 kg

Amendment:	Replace for	950100
	Replaced by	
	Drawn	16.09.2015 AM
Abrasive Cutting Head Centerline Type III	Scale	3 : 2
	Checked	26.09.2017 RB
	Release	25.06.2018 BT
	Index-release	

allfi
 Components

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Max. 6200 bar / 90,000 psi

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			No. of sheets	2