

XI. Maintenance (Contd.)

- Wipe off the old compound and replace it with new compound frequently. Apply more pressure to speed the cutting action of the compound.
- To check the seating surfaces, remove all compound from the seat and the lap. Then, shine the seat with the same lap using the lapping method as described above. Low sections on the seating surface show up as shadow in contrast to the shiny portion.
- If shadows are present, further lapping is necessary. Only laps known to be flat can be used. It should take only a few minutes to remove the shadows.
- When lapping is complete, any lines appearing as cross-scratches can be removed by rotating the lap on its axis (which has been wiped clean of compound) on the seat.
- Thoroughly clean the lapped seat using a lintfree cloth and a cleansing fluid.

ATTENTION!

Before assembly, lap the contact surfaces of the nozzle, soft-seat disc (JM DA) and O-ring retainer to provide metal-to-metal seat tightness in the event of O-ring or Teflon seal (JM DA) failure.

Lapping O-Ring Seating Surfaces

Refer to Figure 10 and assemble the O-ring retainer to the disc holder (8) (D through J orifice) or disc (6) (K through U orifice) using the retainer lock screw(s) as follows:

1. Apply 3A lapping compound to the retainer seating surface.
2. Place the retainer on the nozzle seat (see Figure 26) and lap the retainer to the nozzle (2).
3. Once uniform contact is established, clean the nozzle (2) and O-ring retainer.
4. Repeat the procedure with 1000-grit compound.
5. Remove the retainer lock screw(s) and O-ring retainer, and thoroughly clean the O-ring retainer, retainer lock screws, and disc holder (8) or disc (6).

Reconditioning of Laps

Ring laps are reconditioned by lapping them on a flat lapping plate in a figure-eight motion (see Figure 29). To ensure the best results, recondition the ring laps after each use. Use an optical flat to check the quality of the lap.

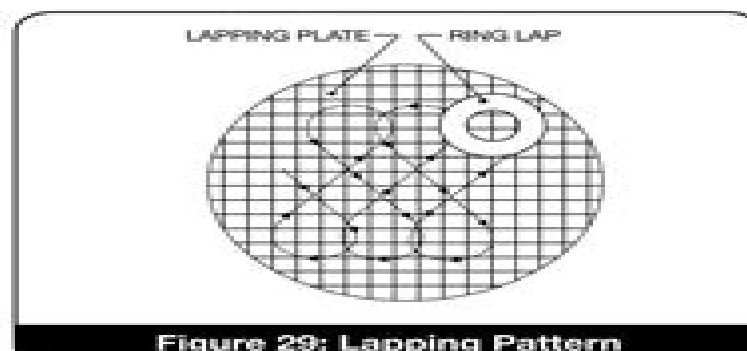


Figure 29: Lapping Pattern

Nozzle laps (see Figure 27) must be re-machined to recondition the lapping surfaces. Place the nozzle lap in a lathe between centers (see Figure 30). The surfaces marked A and B must be running concentrically.

One lapping surface is 90° and the other is 85°. The angle of each surface is marked on the lap. Machine surfaces C and D by taking light cuts at the proper angle until the lapping surfaces are reconditioned.



Figure 30: Nozzle Lap in a Lathe

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