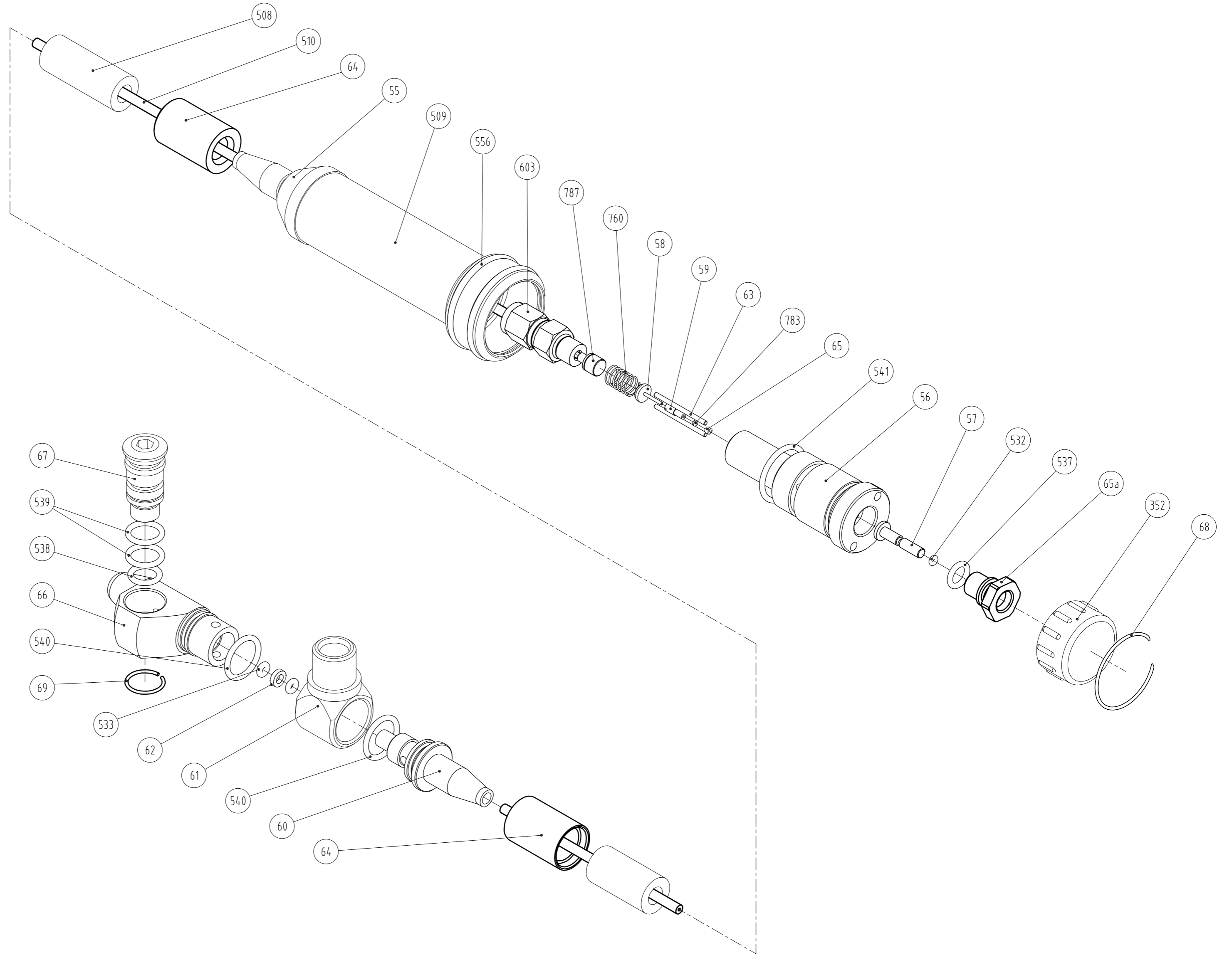


ASSEMBLING INSTRUCTIONS

- n1. Screw SHELLS pos.64 onto ends of the hose pos. 508.
- n2. Screw NIPPEL pos.60 into one of the SHELLS, using dowel pin $\varnothing 3 \times 40$ as a tool and CLAMPING TOOL 16. Fix NIPPEL with dowel pin in vices if necessary.
- n3. Screw DOSING UNIT BODY pos.55 into other SHELL, using CLAMPING TOOL 24 and CLAMPING TOOL 16.
- n4. Put the Heat Shrink pos.509 on the DOSING UNIT BODY and cure it with heat gun.
- n5. Put SPACER pos.65 and RING pos.783, into DOSING VALVE pos.56 and screw BUSH pos.59.
- n6. Tape 4mm of the thread M3 in the hole $\varnothing 2.5$ in fitting pos.603. Screw Silencer pos.787 into fitting.
- n7. Put 2 PUSHERS pos.63 into holes in the DOSING VALVE, then put STEM pos.58, Spring pos.760 and screw Fitting pos.603 into DOSING VALVE. Check the drive of the valve by pushing the ends of the PUSHERS – they should be easily returned by the Spring.
- n8. Put O-Ring pos.532 onto PLUNGER pos.57, O-Ring pos.537 onto GUIDE pos.65a and O-Ring pos.543 onto DOSING VALVE. Push the PLUNGER into the GUIDE and screw the Guide into DOSING VALVE as far as it goes.
- n9. Fix the Tube pos.510 in the tube fitting and tighten the nut of the fitting. Screw the assembled DOSING VALVE into the DOSING UNIT BODY, aligning the tube through the hose.
- n10. Put the BUTTON pos.352 into the DOSING UNIT BODY and fix it with RING 26 pos.68.
- n11. Pull O-Rings pos'ns 538, 539 onto PIVOT pos.67. Put PIVOT into hole in the ANGLE pos.66 and fix with RING 12 pos.69.
- n12. Pull 2 O-Rings pos.540 onto NIPPLE and ANGLE.
- n13. Put SWIVEL pos.61 on NIPPEL, then pull 2 O-Rings pos.533 and WASHER pos.62 on the end of the Kynar Tube.
- n14. Screw together NIPPLE and ANGLE, using CLAMP 16 tool.



Units of measurement		Mass	Format	ISO A2	Designed by	A.KUDRIASHOV	Changed by	-	Approved by - date	-	Filename	ORM6600A.dwg	Date	08.10.07	Scale	2:1			
Material			Projection		DEEP LIFE LTD			Title/Name		MANUAL INJECTOR ASSY									
Quantity			Strictly Commercial-in-Confidence, copyright © 2004. Copying prohibited except as provided for under written contract with Deep Life Ltd.					Drawing number		ORM6600		Edition		A		Sheet(s)		2(2)	
Tolerances																			
Surface roughness																			
Surface treatment																			