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Orifice user guide

In order to service the orifice correctly and protect your investment, we made a guide on how to change the orifice.

Changing the orifice in 10 steps:

Step 1: Pull firmly on the abrasive feed line to remove it from the head.

Note: If the line is hard to remove, apply a very small amount of silicone lubricant or food-grade lubricant to the 45° port to allow easier removal next time.

Step 2: Thoroughly rinse the outside of the cutting head and nozzle body with your system's spray hose. Rinse the inside by spraying water into the abrasive inlet port with the jet running at high or low pressure. This will remove external and internal abrasive particles and assure proper seating.

Step 3: Turn the intensifier pump off and bleed all pressure from the system.

Step 4: Using a 1 1/16-in. wrench on the cutting head body and a 3/4-in. wrench on the nozzle nut, loosen the cutting head body and remove it from the nozzle body.

Step 5: Tap the body upside down on a table to remove the Orifice Assembly. If necessary, lightly pry on the mount with a screwdriver.

Step 6: Inspect again to make sure all parts, including the orifice and the seating surface in the body, are clean of any debris or garnet. If needed, flush the Mixing Chamber by spraying water through the abrasive inlet port again.

Step 7: Apply a very small amount of Blue Lubricant at the top of the Orifice Assembly. (This should be just a thin layer)

Step 8: Drop the Orifice Assembly into the body, shaking the body until the assembly drops into the taper. Ensure that the Orifice Assembly is properly seated in the body before reattaching the Mixing Chamber to the Nozzle Body. An improperly seated orifice can damage your components and cause poor cut quality.

Step 9: Attach the Mixing Chamber to the Nozzle Body and tighten with 35–50 ft-lb of torque.

CAUTION: DO NOT EXCEED 50 FT LBS.

Over-tightening the cutting head will damage mating surfaces, such as the Nozzle Body. It can also damage the orifice mount, either by forcing the mount out of round, or by flattening it. Such damage is not covered by warranty.

Step 10: Reattach the abrasive feed line. If there is leakage, disassemble the Mixing Chamber from the Nozzle Body, make sure there is no grit or debris in the chamber, ensure that the orifice is properly seated and reattach the chamber to the body. If leakage continues, it may be due to a worn Mixing Chamber or Nozzle Body.