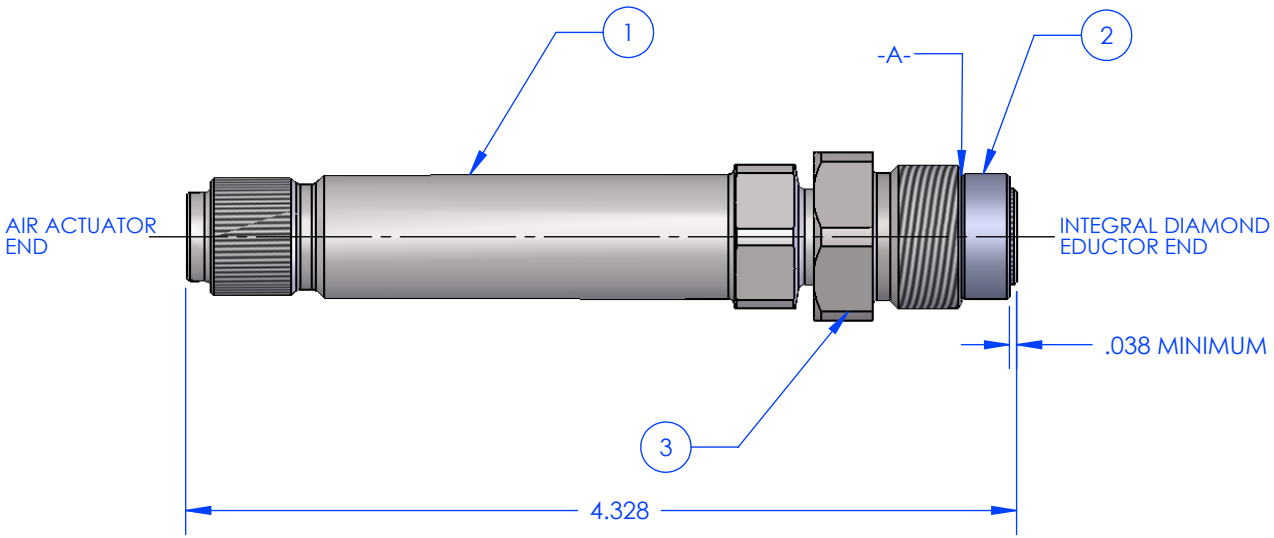
ASSEMBLY PROCEDURE:

1. APPLY BLUE GOOP TO ALL THREADED SURFACES AND TO MATING SURFACE BETWEEN COLLAR (100027-2) AND GLAND NUT (100027-3).
2. INSERT GLAND NUT ONTO ADJ. BODY NOZZLE (100027-1) AS SHOWN IN FIGURE.
3. THREAD COLLAR ONTO ADJ. BODY NOZZLE (NOTE - COLLAR HAS LEFT HAND THREADS) UNTIL ADJ. BODY NOZZLE EXTENDS PAST THE COLLAR A MINIMUM OF .030". ENSURE THAT THE GLAND IS ABLE TO FREELY ROTATE.
4. THREAD, BY HAND, ADJ. NOZZLE BODY INTO AIR ACTUATOR VALVE BODY ASSEMBLY UNTIL SLIGHT CONTACT IS MADE. NOTE: DO NOT WRENCH TIGHTEN AT THIS TIME..
5. WHILE APPLYING 60 PSI AIR PRESSURE (MILL AIR) TO AIR ACTUATOR ASSEMBLY, TORQUE TO 12-15 FT-LBS. RELEASE AIR PRESSURE.
6. THREAD INTEGRAL DIAMOND EDUCTOR ONTO GLAND NUT. ROTATE ABRASIVE INLET TO DESIRED LOCATION. TORQUE TO 35-40 FT-LBS.



ITEM NO.	QTY.	PART NUMBER	DESCRIPTION
1	1	100027-1-2-C	BODY, ADJ. NOZZLE BODY, P-III, HIGH VELOCITY
2	1	100027-2-D	COLLAR, ADJUSTABLE NOZZLE BODY, P-III
3	1	100027-3-C	GLAND NUT, ADJ. NOZZLE BODY

H2O JET™

Ecn #	DATE	Rev	REASON FOR CHANGES	Drwn	Chk	Appvd

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DRAWN: M.H.
CHECKED: J.N.
APPRVD: H.A.
SCALE: 1:1
DATE: 08/09/06

TITLE: **ASSEMBLY ADJUSTABLE NOZZLE BODY, P-III**

REF. NO: -
MADE FROM: -

SIZE	DWG. NO.	REV.	SHEET
A	301099-1	0	1 OF 1

5 4 3 2 1