

Assembly Instructions

Marking Gun

In order that the magnet puncher can apply high quality marking it is important that the Assembly Instructions are carefully followed and that the indicated tolerances are observed.

In case of wear, where the indicated tolerances are exceeded, the worn parts should be replaced.

As loose bolts and screws can cause serious damage and operating trouble, it is important that the stated torque moments are observed and that bolts are after-tightened regularly.

Tools for Assembly:

Torque wrench for 8 Nm - 10 Nm - 20 Nm.

Ring/fork wrench: 4mm - 7mm - 22mm.

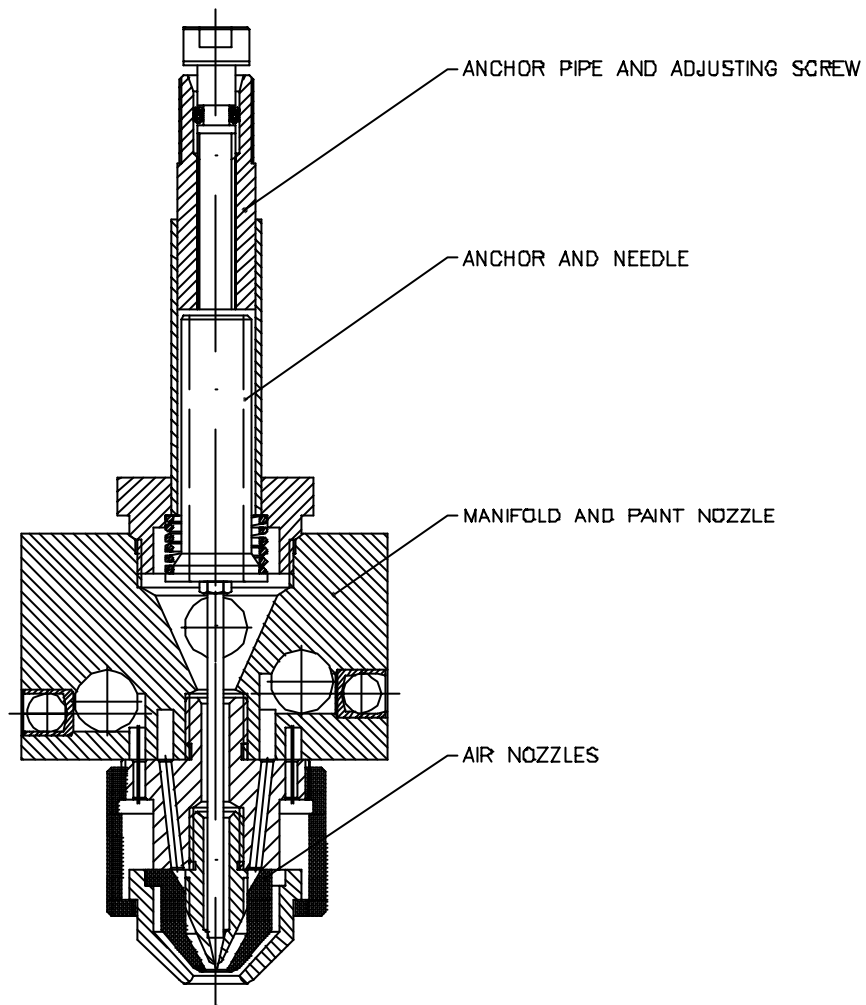
Hexagon socket wrench: 4mm.

Loctite 572.

Safety:

It is important to read the Assembly Instructions before disassembly/assembly of marking sections in the marking head.

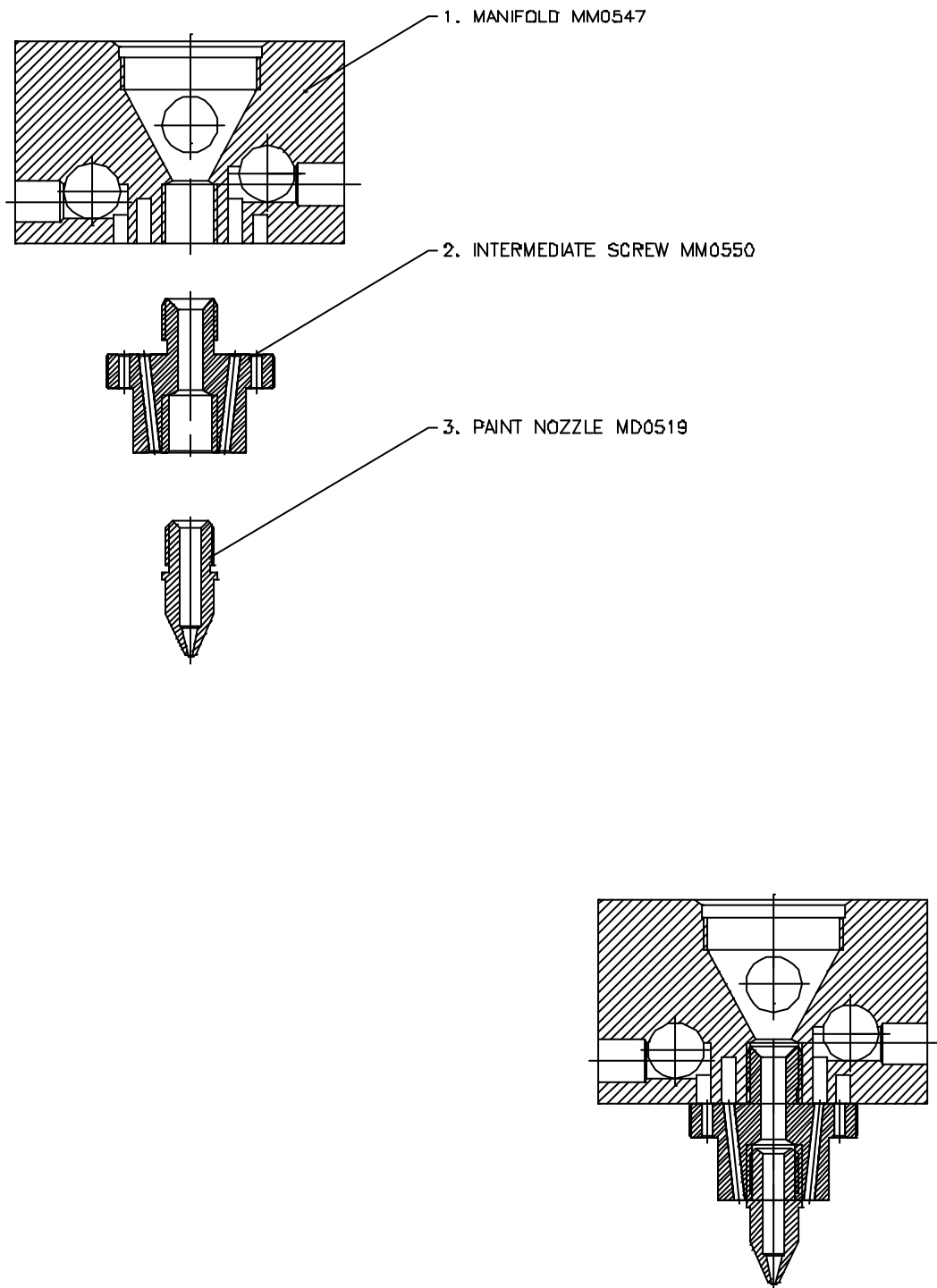
Assembly Instructions Marking Gun



Contents:

| | |
|---|----|
| Assembly of Manifold and Paint Nozzle..... | 5 |
| Assembly of Anchor and Needle..... | 7 |
| Assembly of Ancor Pipe and Adjusting Screw..... | 9 |
| Assembly Air Nozzles..... | 11 |

Assembly of Manifold and Paint Nozzle



Assembly Instructions Marking Gun

Only original, approved and controlled components must be used.

Assembly of Manifold and Paint Nozzle.

1. The thread is cleaned so that there is no oil and grease.
2. LOCKTITE 572 is applied to intermediate screw Pos. 2, which is screwed into manifold Pos. 1 and tightened with 10 Nm.
3. Manifold Pos. 1 must be turned in such a way that the intermediate screw is turned upwards. Thereby surplus LOCKTITE, if any, is prevented from clogging the air channels in the intermediate screw.
4. Drying time approx. 3-4 hours.
5. Paint nozzle Pos. 3 is screwed into the intermediate screw and tightened with 8 Nm.



Important

At renovation:

Channels and holes are thoroughly cleaned for paint residues.

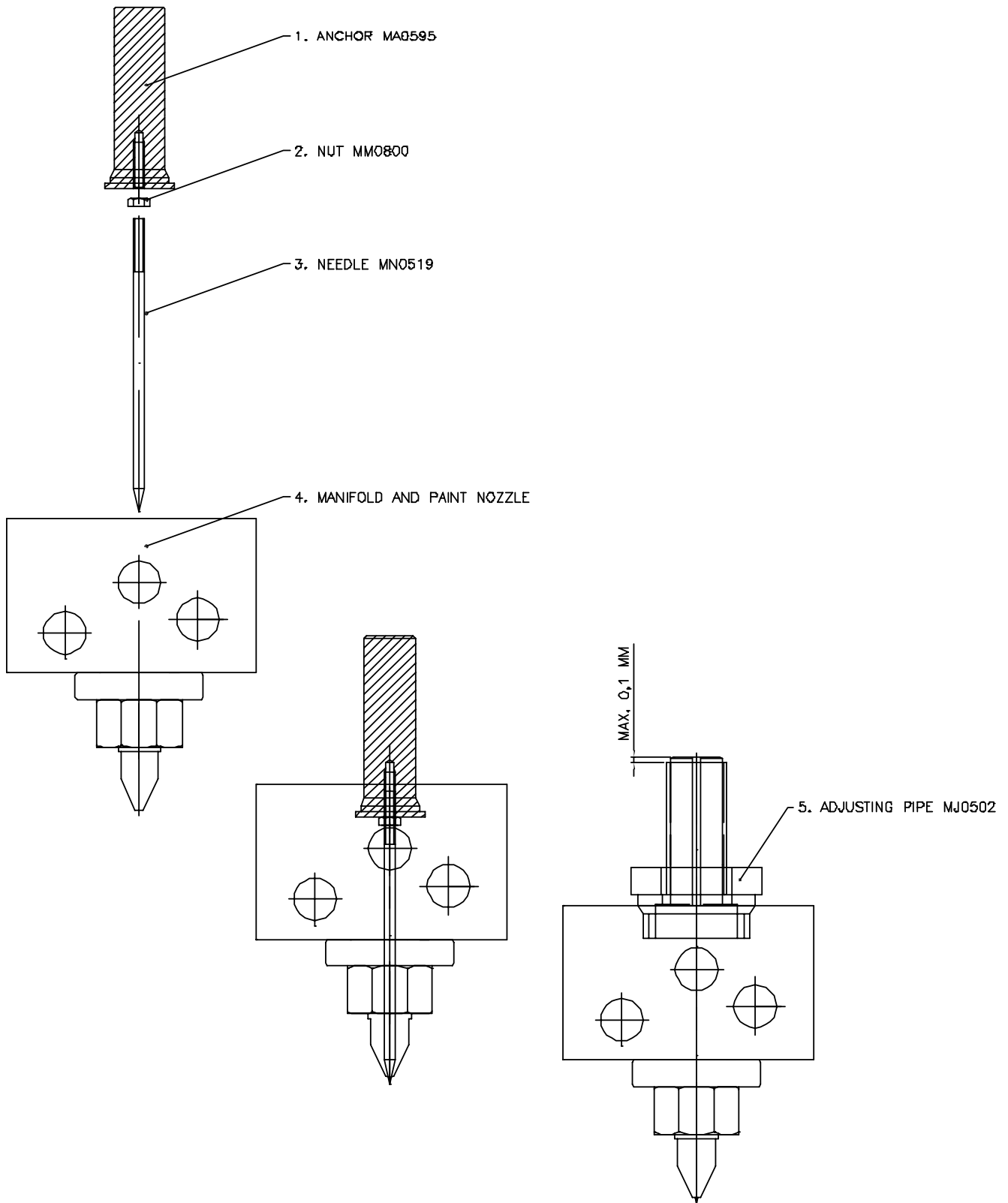
During cleaning tools, which can damage channels and surfaces for sealing, must not be used.

Paint nozzle is replaced, if the nozzle gap (which is 0.5 mm originally) is 0.8 mm or more.

Wear Parts:

Pos. 3 Paint nozzle MD0519

Assembly of Anchor and Needle



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Assembly of Anchor and Needle

1. The needle Pos. 3 with lock nut Pos. 2 is screwed into anchor Pos. 1, until the needle's thread protrudes approx. 5 mm from the anchor.
2. Anchor and needle are placed in the paint nozzle, whereafter adjusting pipe MJ0502 is assembled.
3. The upper edge of the anchor must not protrude more than 0.1 mm from the adjusting pipe.
4. The adjusting pipe is disassembled.



Important

Check that:

At renovation:

The anchor is replaced, if there are wear marks from the adjusting screw of more than 0.5 mm in the top.

That the needle is straight.

If the needle's seat is worn through the wear layer (yellow coating), the needle is replaced.

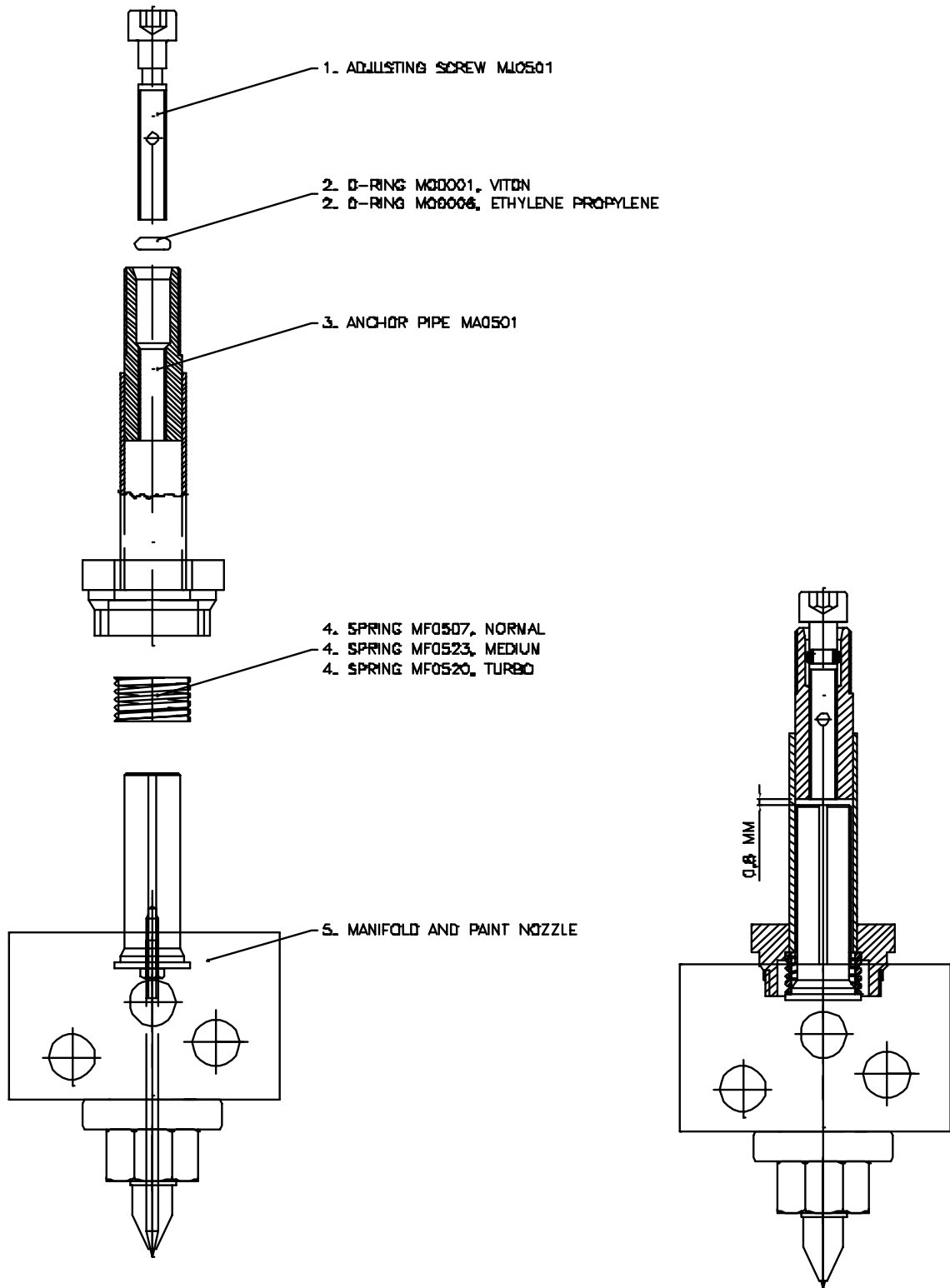
Needle and nozzle are replaced at the same time.

Wear Parts:

Pos. 1 Anchor MA0595

Pos. 3 Needle MN0519

Assembly of Anchor Pipe and Adjusting Screw



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Assembly of Ancor Pipe and Adjusting Screw

1. Spring Pos. 4 is mounted around the anchor.
2. Adjusting screw Pos. 1 is provided with O-ring Pos. 2
3. Adjusting screw Pos. 1 is screwed all the way into the anchor pipe Pos. 3, and it is screwed 1 turn backwards corresponding to 0.8 mm air between head of adjusting screw and anchor pipe.
4. Fine adjustment of anchor and needle is carried out. The adjusting screw is carefully screwed as much as possible. There must be very little air between anchor and adjusting screw. This is verified by pressing the pinpoint, which protrudes 0.5 mm through the paint nozzle, against a piece of brass or similar soft material. The needle is fine adjusted, if it can move more than 0.1 mm. This is done by disassembling the anchor pipe. Anchor and needle are removed, the lock nut is loosened and fine adjustment is carried out. When fine adjustment is finished, anchor and needle are assembled in the paint nozzle. Spring and anchor pipe are assembled. Anchor pipe is tightened with 20 Nm.



Important

Check that:

The needle can move easily by pressing the pinpoint.

At renovation:

Adjusting screw is checked for wear. If there are wear marks of more than 0.5 mm, it is replaced as well as the O-ring.

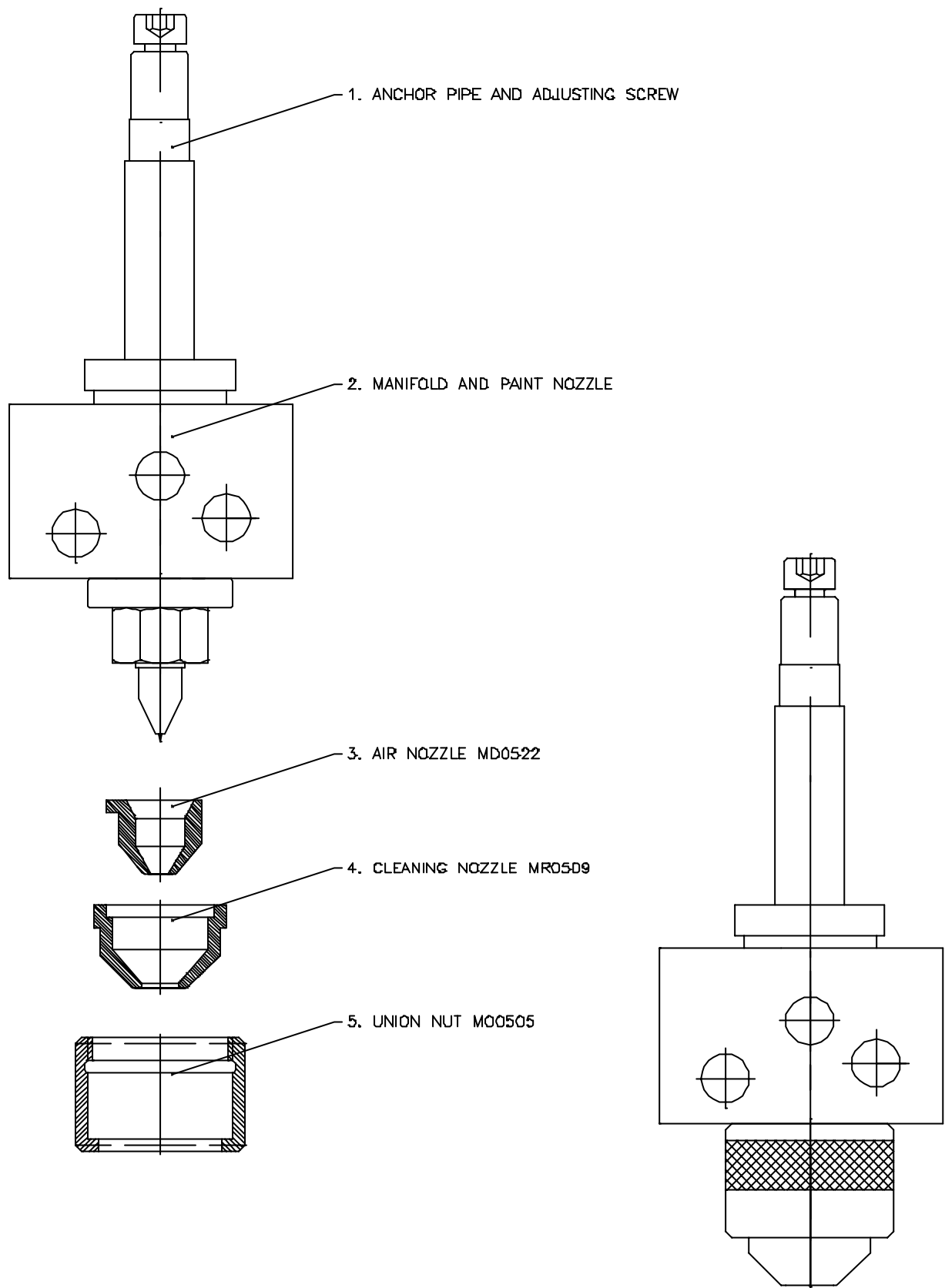
Wear Parts:

Pos. 1 Adjusting screw MJ0501

Pos. 2 O-ring MO0001 or MO0006

Pos. 4 Spring MF0520

Assembly Air Nozzles



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Only original, approved and controlled components are used.

Assembly air nozzles

1. Air nozzle Pos. 3 is placed in cleaning nozzle Pos. 4
2. Cleaning nozzle Pos. 4 is placed in union nut Pos. 5
3. Union nut Pos. 5 is screwed onto the intermediate screw.



Important

Check that:

Marking section is tight.

(It is recommended to have a test stand in order to check whether the marking section is tight).

At renovation:

Air nozzle and cleaning nozzle are cleaned for paint residues. When cleaning tools, which can damage holes and surfaces on the nozzles, must not be used.

Hole in air nozzle is intact.

Wear parts:

Pos. 3 Air nozzle MD0522