

Intensifier Hollow Screw Update

Consult your Product and Operation Manuals for all applicable safety precautions before attempting to perform this Service Procedure. Failure to do so could result in damage to equipment, injury to yourself or others, or death.



Prior to service, perform proper shutdown of the machine. Place locks on services as necessary and de-energize. Refer to Intensifier pump manual for specifics of your machine.

Required Equipment

- Torque wrench (0-100 in. lb minimum).
- 5/32" hex bit socket
- Plastic mallet.
- Precision Lube thread lubricant.
- Degreaser
- Moly Grease
- Lapping Stone
- Lapping Compound
- Hollow Screws - 2x 112437

Recommended Parts

The following parts are recommended to be replaced:

- Inlet Poppets - 2x 104047
- Check Tube O-Rings - 4x 45793-128
- High Pressure Seal and Backup Hoop Kit
- 110717 for 7/8 Intensifiers
- 110716 for 1" Intensifiers

Procedure

1. Remove the intensifier pump from production. Perform any necessary LOTO operations for the equipment.
2. Follow machine specific instructions (found in the operations manual or the appropriate video at jetedgewaterjets.com/resources) to remove the check tube/end cap from the intensifier pump.
3. With the end cap removed, remove the check tube assembly from the end cap. Place end cap aside.
4. On the check tube assembly, using a hex key, remove the existing screw from the assembly.
5. Inspect the low pressure poppet housing and poppet. Replace as necessary

6. Lap the sealing face of the check tube using the lapping stone and compound. Lap until there is no ridge present where the poppet contacts the face of the check tube.
7. If re-using the inlet poppet, lap the sealing surface until no ridge is visible.
8. With the components cleaned, place the poppet in the poppet housing (the direction of the locating pin)
9. Place the poppet housing/poppet on the face of the check tube, aligning the locating pin with hole on the check tube
10. Apply a small dab of anti-seize to the protruding hollow screw (end threads only).
11. Carefully align the poppet housing assembly to the check tube, by threading in the hollow screw, while using the spring pin for final alignment.
12. Torque the hollow screw to 65 +/- 5 in-lbs (7.4 +/- 0.6 N-m) using a 5/32" hex bit socket and torque wrench.
13. Verify the poppet moves freely in the poppet housing by shaking the check tube assembly. You should hear a distinct clicking sound. if no movement is observed, remove the components, clean, and repeat the process
14. Apply Precision Lube to the surface of the check tube that contacts the high pressure end cap. Inspect and replace any worn O-rings that are on the check tube or the high pressure end cap.
15. Install the check tube into the high pressure end cap. lubricating the O-rings with high pressure lubricant.
16. Follow machine specific instructions to re-install the high pressure end.