

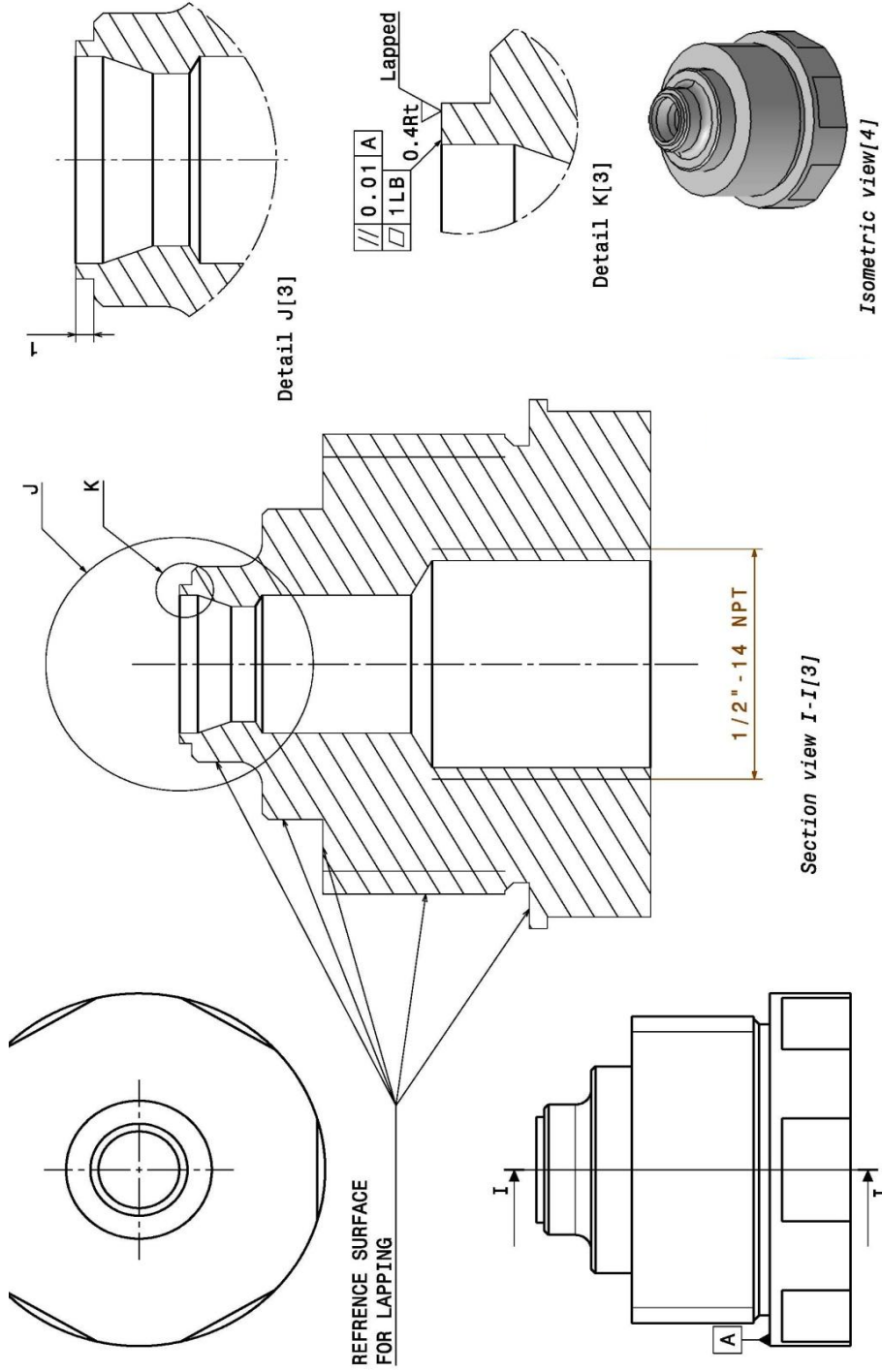


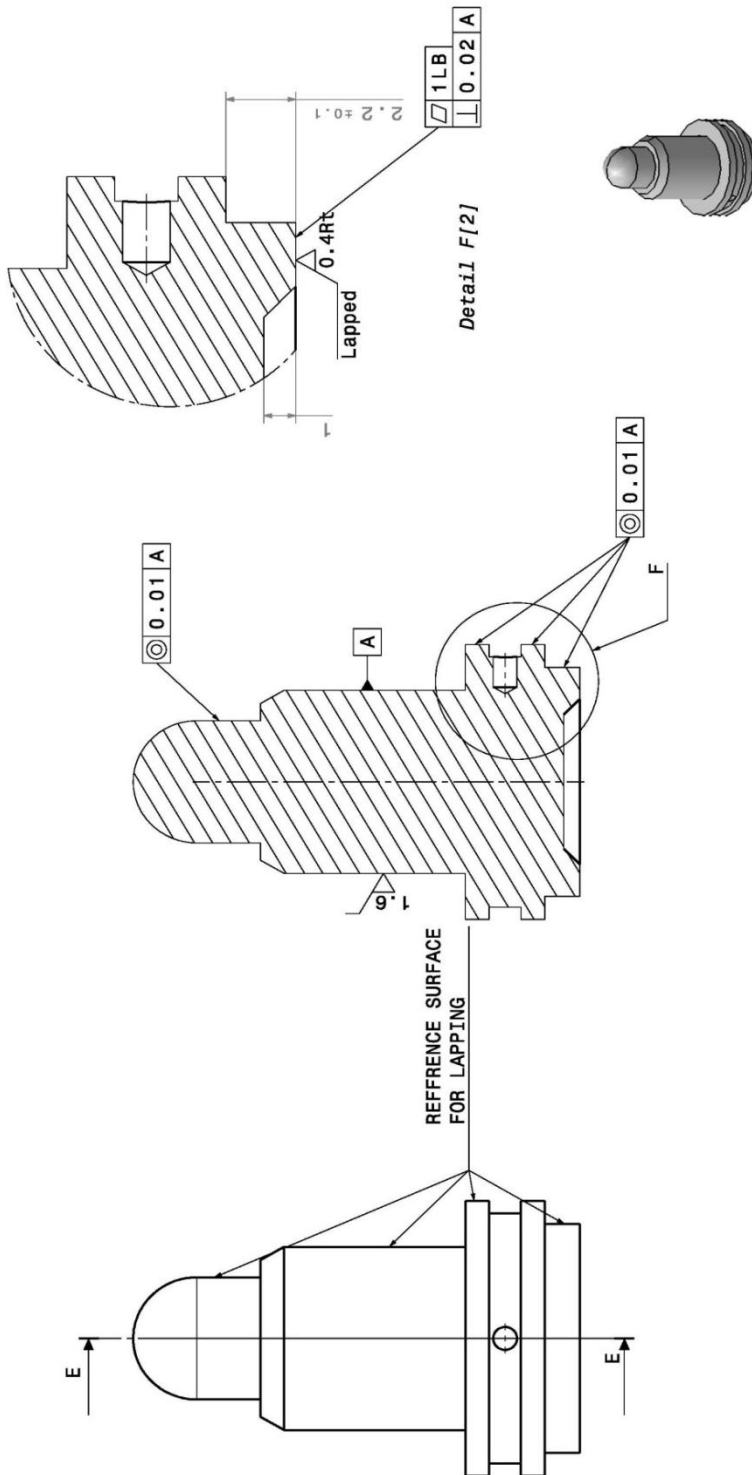
LAPPING PROCEDURE

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Different individuals have different methods of lapping valve seats, but certain essential steps must be taken to get satisfactory results. The following procedure is suggested for lapping of valve seats:

- 1- Never lap the disc insert against the nozzle. Lap each part separately against a cast iron lapping block of the proper size. These blocks hold the lapping compound in their surface pores, but must be recharged and reconditioned frequently.
- 2- Check the lapping block frequently on a good lapping block conditioner to make certain that it is perfectly flat on both sides.
If considerable lapping is required, spread a thin coat of medium lapping compound on the block. After lapping with this compound, lap again with a fine compound using a new lapping block surface. Unless much lapping is called for, the first step can be omitted. Next, lap again using a polish compound.
- 3- Lap the block against the seat. Never rotate the block continuously, but use an oscillating movement.
- 4- After final lapping, clean the seating area with the lapping thinner and then with acetone (or equivalent) and dry it.
- 5- Lapping surface shall be packing satisfactory and protected to damage.
- 6- Lapping quality and reference surface for lapping shown in below:





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