Lapping Machine DX75480

This grinding/lapping machine has to be used for reconditioning the ball seat internal valve cone on the common rail Bosch type injectors, in order to re-establish the ball tightness in her seat.

Lapping Machine DX75480 is equipped with spindles, which tips have a different conical shape in order to adapt to the different valve seats to be ground.

The choice of the right conical angle allows precision grinding on the right spot of the cone damaged by the small ball hitting action.

The grinding operation has to be done using the small grinding paper strips, which should be positioned between the spindle and the valve seat (on top of the valve seat).

The grinding strips are of different grinding action, from the raw one to the very fine one for end-lapping and are of the right size to suite the valve seat.
The spindles cones are made considering the thickness of the abrasive paper. Pay attention, the use of not compatible abrasive papers can damage the valve cone.

The use of the grinding/lapping stripes offers the following advantages:
- The grinding surface of the strip exhausts after few seconds, avoiding eventual seat damages in case of too strong or too long pushing.
- The conical tip of the spindle is not in contact with grinding material and therefore it does not wear off.

First check ball valve seat condition with the microscope* On the picture you may see an example of a valve seat with signs of wearing.

Without Lapping Machine DX75480 this valve SHOULD BE SCRAPPED.

KIT CONTENTS

FOUR DIFFERENTS SPINDLES WITH DIFFERENT ANGLED CONES:
A: DX 75487
B: DX 75485
C: DX 75486
*D: DX 75488
*UNIVERSAL SPINDLE TO RE-ESTABLISH THE BALL SEAT IN DEPTH

DX 75483
ROTATING VALVE HOLDER TO INSERT THE VALVE FOR CRIP1 - CRI2.1 - CRI2.2 - CRIN - CRIN2
(how to use available on codec.ditex.it)

*INDISPENSABLE MICROSCOPE DX75680
RECOMMENDED MICROSCOPE LIGHT DX75681

Lapping Machine DX75480
Accessories not included in the Kit

**DX75482** Rotating valve holder to insert the valve for CRIN3

**Pre-cut abrasive paper** (pack of 50 strips in pre-cut abrasive paper in 5 different graduations)

- **DX 75490** (RAW)
- **DX 75491** (MEDIUM)
- **DX 75492** (FINE)
- **DX 75493** (POLOSHING)
- **DX 75494** (VERY RAW)

**Pre-cut abrasive paper** (pack of 10 pre-cut abrasive paper in 3 different graduations)

- **DX 75723** (FINE 500)
- **DX 75724** (MEDIUM 320)
- **DX 75729** (RAW 180)

**DX75470** Kit to grind setting shims

* *(INDISPENSABLE MICROMETER GAUGE DX75391 WITH HOLDER DX75392)*

** *(RECOMMENDED SYNTHETIC LIQUID DX75394)*

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