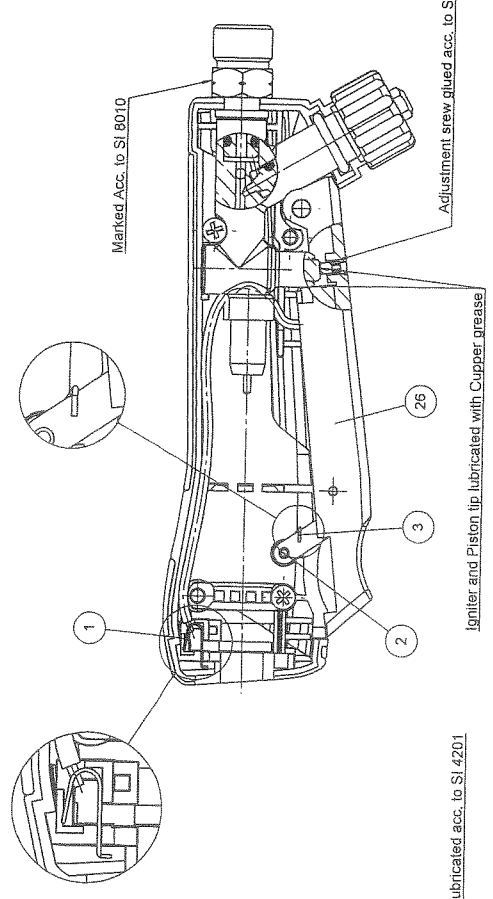


For tolerances see table below. Dimensions are given in mm.
+ IT14 - 2

3-6	0.150
3-6	0.150
6-10	0.160
10-15	0.200
15-20	0.250
20-25	0.310
25-30	0.370
30-35	0.430
35-40	0.500
40-45	0.570
45-50	0.650
50-55	0.730
55-60	0.820
60-65	0.920
65-70	1.030
70-75	1.150
75-80	1.280
80-85	1.420
85-90	1.570
90-95	1.730
95-100	1.900
100-105	2.080
105-110	2.270
110-115	2.470
115-120	2.680
120-125	2.900
125-130	3.130
130-135	3.380
135-140	3.640
140-145	3.910
145-150	4.200
150-155	4.500
155-160	4.820
160-165	5.150
165-170	5.500
170-175	5.870
175-180	6.260
180-185	6.670
185-190	7.100
190-195	7.550
195-200	8.030
200-205	8.530
205-210	9.050
210-215	9.600
215-220	10.180
220-225	10.780
225-230	11.410
230-235	12.070
235-240	12.760
240-245	13.480
245-250	14.230
250-255	15.010
255-260	15.830
260-265	16.680
265-270	17.570
270-275	18.490
275-280	19.450
280-285	20.440
285-290	21.470
290-295	22.540
295-300	23.650
300-305	24.800
305-310	26.000
310-315	27.240
315-320	28.530
320-325	29.870
325-330	31.260
330-335	32.700
335-340	34.190
340-345	35.730
345-350	37.320
350-355	38.960
355-360	40.650
360-365	42.400
365-370	44.200
370-375	46.060
375-380	47.980
380-385	49.960
385-390	52.000
390-395	54.100
395-400	56.270
400-405	58.500
405-410	60.800
410-415	63.170
415-420	65.600
420-425	68.100
425-430	70.670
430-435	73.300
435-440	76.000
440-445	78.770
445-450	81.600
450-455	84.500
455-460	87.470
460-465	90.500
465-470	93.600
470-475	96.770
475-480	100.000
480-485	103.300
485-490	106.670
490-495	110.100
495-500	113.600
500-505	117.170
505-510	120.800
510-515	124.500
515-520	128.270
520-525	132.100
525-530	136.000
530-535	140.000
535-540	144.070
540-545	148.200
545-550	152.400
550-555	156.600
555-560	160.900
560-565	165.300
565-570	169.700
570-575	174.200
575-580	178.700
580-585	183.300
585-590	187.900
590-595	192.600
595-600	197.300
600-605	202.100
605-610	207.000
610-615	211.900
615-620	216.900
620-625	221.900
625-630	227.000
630-635	232.100
635-640	237.300
640-645	242.500
645-650	247.800
650-655	253.100
655-660	258.500
660-665	263.900
665-670	269.400
670-675	274.900
675-680	280.400
680-685	286.000
685-690	291.600
690-695	297.300
695-700	303.000
700-705	308.800
705-710	314.600
710-715	320.500
715-720	326.500
720-725	332.500
725-730	338.600
730-735	344.700
735-740	350.900
740-745	357.100
745-750	363.400
750-755	369.700
755-760	376.100
760-765	382.600
765-770	389.100
770-775	395.700
775-780	402.300
780-785	409.000
785-790	415.700
790-795	422.500
795-800	429.300
800-805	436.200
805-810	443.100
810-815	450.100
815-820	457.200
820-825	464.300
825-830	471.500
830-835	478.700
835-840	486.000
840-845	493.400
845-850	500.800
850-855	508.300
855-860	515.800
860-865	523.400
865-870	531.000
870-875	538.700
875-880	546.400
880-885	554.200
885-890	562.100
890-895	570.100
895-900	578.100
900-905	586.200
905-910	594.400
910-915	602.600
915-920	610.900
920-925	619.300
925-930	627.700
930-935	636.200
935-940	644.700
940-945	653.300
945-950	661.900
950-955	670.600
955-960	679.300
960-965	688.100
965-970	697.000
970-975	705.900
975-980	714.900
980-985	723.900
985-990	733.000
990-995	742.100
995-1000	751.300

For gauges, see drawing R52-2001 and tol. fig. 201.04. Use ISO profiles with thread, where no tolerance is given.



29	HANDTAG VÄNSTER	HANDLE LEFT	1	52494
28	BRICKA	WASHER	1	52497
27	HANDTAG HÖGER	HANDLE RIGHT	1	52493
26	TRYCKE SMST	TRIGGER ASSY	1	52490
25	PROPP	PLUG	1	63229
24	BOXMUTTER	RETAINER	1	60367
23	FJÄDER	SPRING	1	63188
22	O-RING	O-RING	1	50660
21	FJÄDER	SPRING	2	63356
20	BLADFJÄDER	SPRING LEAF	1	63391
19	O-RING	O-RING	1	90027
18	VENTILSPINDEL smst	PLUNGER assy	2	900425
17	PINNE	PIN	1	50659
16	SPINDEL	SPINDLE	1	46680
15	VENTILHUS	VALVE	1	46531
14	VENTILSÄTE	VALVE SEAT	1	61249
13	NIPPEL	NIPPLE	1	63230
12	SKRUV	SCREW	3	63233
11	MUTTER	NUT	1	63670
10	O-RING	O-RING	1	900016
9	O-RING	O-RING	1	901057
8	KOLV	PISTON	1	61260
7	BYGEL	HOOK	1	63232
6	RATT	KNOB	1	46681
5	SKRUV	SCREW	1	69284
4	KULA	PELLET	1	61580
3	VRIDFJÄDER	TORSION SPRING	1	63228
2	PINNE	PIN	1	61263
1	KONTAKTBLECK	CONTACT CLIP	1	61263

Adjustment screw should be set after assembly. With trigger fully depressed the screw is turned clockwise until the valve opens, whereupon it is released 3/4-1 revolution. The valve shall then be closed. Spindle 46680 is lubricated acc. to SI 4203A and punched with a torque of Mv=2.5 Nm. Sealing tested acc. to SI 7410A, torque 0.5 Nm. Valve sealing tested at 600 kPa acc. to SI 7410. Function tested at 200 kPa with burner attached.

Material: S, E, Surface: E, Scale: 1:1, Approved by: AE, Created by: DJ, Date: 2007-02-28, Factor: 1:1, Revision no.: 0, Drawing no.: 52491, Name: HANDTAG smst, HANDLE ASSY, Manufacturer: SIEVERT, Sweden.