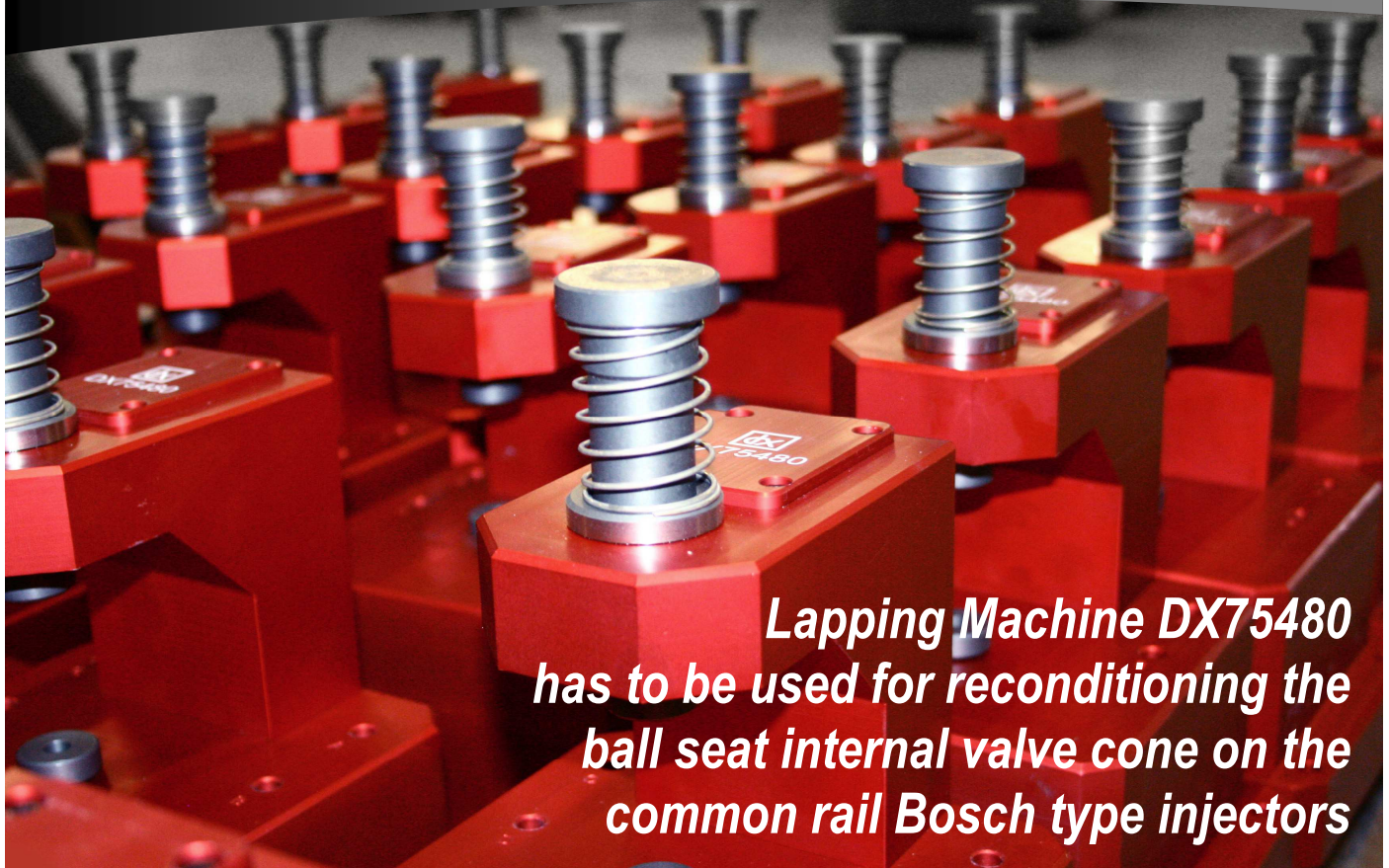


# Lapping Machine DX75480



**Lapping Machine DX75480 has to be used for reconditioning the ball seat internal valve cone on the common rail Bosch type injectors**

***This grinding/lapping machine has to be used fore 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 grinded.***

***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.***

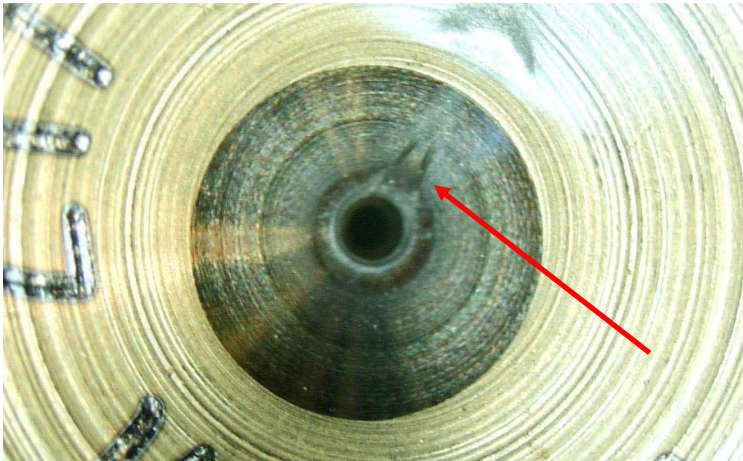


**The spindles cones** are made considering the thickness of the abrasive paper.

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 a 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.**



**Lapping Machine DX75480**



### 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 - CR12.1 - CR12.2 - CRIN - CRIN2

(how to use available on [codec.ditex.it](http://codec.ditex.it))



**\*INDISPENSABLE  
MICROSCOPE DX75680  
RECOMMENDED  
MICROSCOPE LIGHT DX75681**

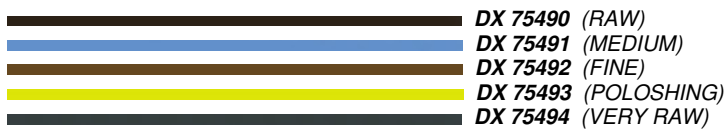


## Accessories not included in the Kit

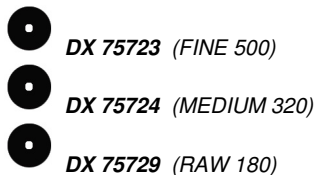


**DX75482** Rotating valve holder to insert the valve for CRIN3

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



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



**DX75470** Kit to grind setting shims

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

**\*\* (RECOMMENDED SYNTHETIC LIQUID DX75374)**



**has to be used for reconditioning the ball seat internal valve cone in order to re-establish the ball tightness in its seat**



37019 PESCHIERA DEL GARDA (VR) ITALY - LOC. MANDELLA - Tel. +390456401191 Fax +390457552215