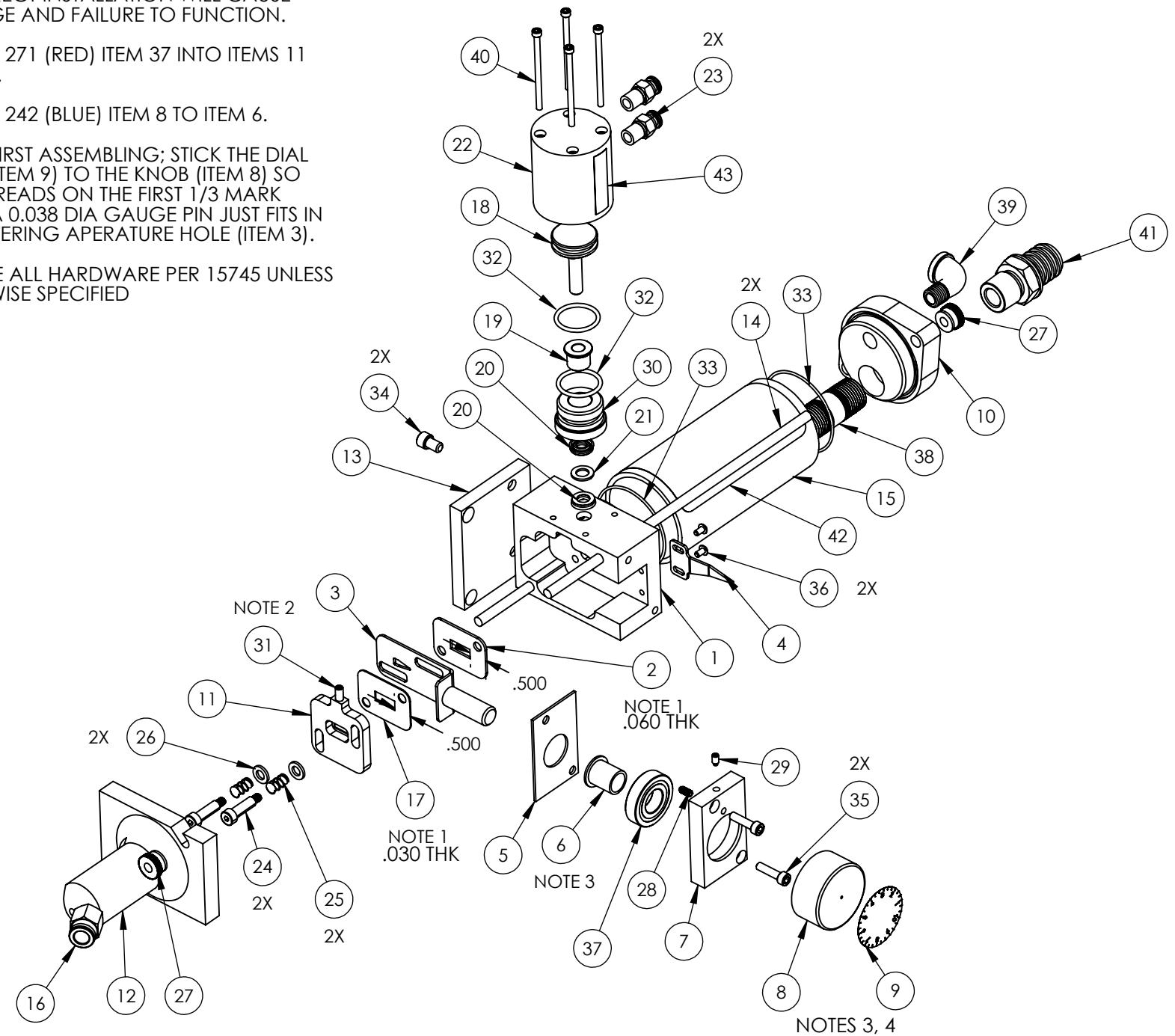


ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	13763	HOUSING BASE, REG 2	1
2	11411	EXIT PLATE, REG 2	1
3	11414	APERATURE ASSEMBLY, REG 2	1
4	11412	POINTER, REG 2	1
5	11419	DIVIDER, REG 2	1
6	11405	BEARING NUT, REG 2	1
7	11404	BEARING HOUSING, REG 2	1
8	11406	ADJUSTMENT KNOB, REG 2	1
9	11485	DIAL LABEL	1
10	11410	COVER, REG 2	1
11	11413	VALVE PLATE, REG 2	1
12	11409	BOTTOM ADAPTER, REG 2	1
13	11443	BOTTOM ADAPTER, REG 2	1
14	12247	THREADED ROD	2
15	12251	ACRYLIC TUBE	1
16	12075	TUBE FITTING; 1/4 NPT X 3/8 TUBE, STRAIGHT, PUSH T	1
17	12318	SANDWICH PLATE, REG 2	1
18	13757	PISTON, AIR CYLINDER, ABRASIVE REGULATOR	1
19	13758	BEARING, STRAIGHT, ABRASIVE REGULATOR	1
20	13759	U Cup Seal, 5/16 ID x 9/16 OD	2
21	13760	BACKUP WASHER FOR ABRASIVE REGULATOR	1
22	13761	AIR CYLINDER BODY, ABRASIVE REGULATOR	1
23	12736	FITTING, 1/8" NPT X 1/4" TUBE	2
24	12255	SHOULDER BOLT	2
25	12256	SPRING	2
26	12257	FST; FLAT WASHER 1/4 300SS	2
27	11751	THUMB NUT	4
28	12260	SPRING PLUNGER	1
29	12783	FST; STSS 8-32X0.25 SS, NYLON	1
30	13836	AB REG 2 AIR ACT. SEAL PLUG	1
31	13604	FST; CPSS 10-32X0.75 BO	1
32	11679-119	ORING; 70A BUNA BLACK -119	2
33	11679-034	ORING; 70A BUNA BLACK -034	2
34	15918	FST; SHCS 1/4-20X3/8F SS	2
35	13805	FST; SHCS 10-32X0.75 SS	2
36	12734	FST; BHCS 6-32X0.25 SS	2
37	12258	BALL BEARING	1
38	12799	1/2 NPT X 2" LG NIPPLE, SS	1
39	12800	1/4 NPT STREET ELBOW; STAINLESS	1
40	13749	FST; SHCS 6-32X2.25P SS	4
41	13128	Hose Barb 1/2"NPT X 3/4" Hose Barb	1
42	13300	Tube Decal	1
43	15465	DECAL, HYPER THERM, GRAY, 1.75 IN	1
44	13615	1/4" I.D. Clear Blue Polyurethane Tubing	6FT

NOTES:

- ORIENTATION OF ITEMS 2 AND 17 MUST BE AS SHOWN WITH .500 DIMENSION TOWARD THE FRONT OF THE REGULATOR. INCORRECT INSTALLATION WILL CAUSE DAMAGE AND FAILURE TO FUNCTION.
- LOCTITE 271 (RED) ITEM 37 INTO ITEMS 11 AND 18.
- LOCTITE 242 (BLUE) ITEM 8 TO ITEM 6.
- WHEN FIRST ASSEMBLING; STICK THE DIAL LABEL (ITEM 9) TO THE KNOB (ITEM 8) SO THAT IT READS ON THE FIRST 1/3 MARK WHEN A 0.038 DIA GAUGE PIN JUST FITS IN THE METERING APERATURE HOLE (ITEM 3).
- TORQUE ALL HARDWARE PER 15745 UNLESS OTHERWISE SPECIFIED

REVISIONS					
REV	ECO	DATE	DRAWN	DATE	APPROVED
B	23731	12-1-14	MWW	12-16-14	MWW



<p>HIGHLY CONFIDENTIAL PROPRIETARY INFORMATION</p> <p>THIS DRAWING AND ALL INFORMATION CONTAINED THEREON IS CONSIDERED PROPRIETARY AND MAY NOT BE USED FOR MANUFACTURING OR FABRICATION PURPOSES WITHOUT PERMISSION FROM HYPER THERM, INC.</p>  <p>309 5TH AVENUE NW PHONE: 651-294-8600 NEW BRIGHTON, MN 55112 FAX: 651-294-8620 EMAIL: WATERJET@HYPERTHERM.COM WEB: WWW.HYPERTHERM.COM</p>	TITLE:		ABRASIVE REGULATOR 2 ASSEMBLY																					
	<p>-TOLERANCES- UNLESS OTHERWISE SPECIFIED DIMENSIONS IN INCHES</p> <p>ANGULAR: MACH ± 1 BEND ± 1 ONE PLACE DECIMAL ± .05 TWO PLACE DECIMAL ± .015 THREE PLACE DECIMAL ± .005 BREAK AND DEBURR ALL EDGES .015 MAX</p>	<table border="1"> <tr><th>NAME</th><th>DATE</th><th>MATERIAL</th></tr> <tr><td>DRAWN</td><td>BLR</td><td>6/30/2010</td><td>SEE PARTS LIST</td></tr> <tr><td>CHECKED</td><td>-</td><td>-</td><td>HARDNESS</td></tr> <tr><td>ENG APPR.</td><td>-</td><td>-</td><td>WEIGHT</td></tr> </table>	NAME	DATE	MATERIAL	DRAWN	BLR	6/30/2010	SEE PARTS LIST	CHECKED	-	-	HARDNESS	ENG APPR.	-	-	WEIGHT	<table border="1"> <tr><td>SHEET 1 OF 1</td><td>SCALE: 2:7</td><td>FINISH -</td></tr> <tr><td>SIZE B</td><td>DWG. NO. 13762</td><td>REV B</td></tr> </table>	SHEET 1 OF 1	SCALE: 2:7	FINISH -	SIZE B	DWG. NO. 13762	REV B
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