

Installation Procedure IP RP 2.5

REVISION HISTORY

Revision	Date	Change
A	11/28/2023	Initial Release

Installation Procedure, Lee Orifice, 2.5 mm, Press-In

FACTORY INSTALLATION PROCEDURE

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1. Overview

This procedure is intended to provide process guidelines for proper installation of Lee Orifice, 2.5 mm, Press-In product in forward or reverse flow orientation. Section 2 provides an overview of the installation hole requirements. Section 3 contains the installation procedure and customer assembly process recommendations. Section 4 contains reference information on the installation hole and installation tool.

Compliance with this installation procedure will ensure optimal product performance. Please contact your local Lee Company Sales Representative for questions concerning installation of Lee Company products.

2. Installation Hole Requirements

The Lee Orifice, 2.5 mm, Press-In product is purposely designed for installation into plastic manifolds or fittings and to perform well under adverse conditions. Therefore, the installation hole specifications outlined in this section should be followed precisely to ensure proper function of the product's retention and sealing features.

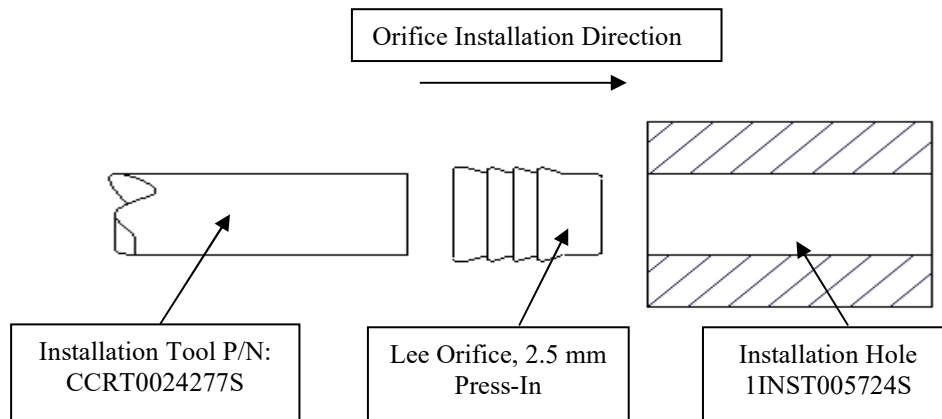
Installation hole specifications as found on Lee Installation Hole Drawing 1INST005724S (Appendix A) will ensure proper operation of the Lee Orifice, 2.5 mm, Press-In product. The hole should be clean, dry, and free of burrs/flash. The series of smoothly curved lands of the Lee Orifice, 2.5 mm, Press-In product allow the product to be pressed in while the plastic flows into the adjacent grooves. Some plastics with a lot of elongation, such as Polypropylene, Nylon, Acetal, Polyethylene and PEEK, cold flow into the grooves affecting retention and sealing.

Other plastics, such as acrylic and polycarbonate, are rigid and therefore the material must be heat flowed around the component. For installation into these types of plastics contact your local Lee Company Sales Representative for more information.

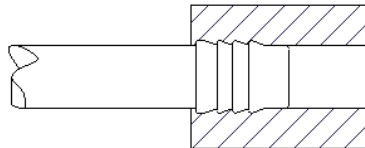
3. Installation

Installation Overview

1. The Lee Orifice, 2.5 mm, Press-In product is inserted into the installation hole oriented as shown below.



2. The installation tool (P/N: CCRT0024277S) is used to simply press the orifice into a plastic installation hole until the product is at a minimum flush with the top of the installation hole.



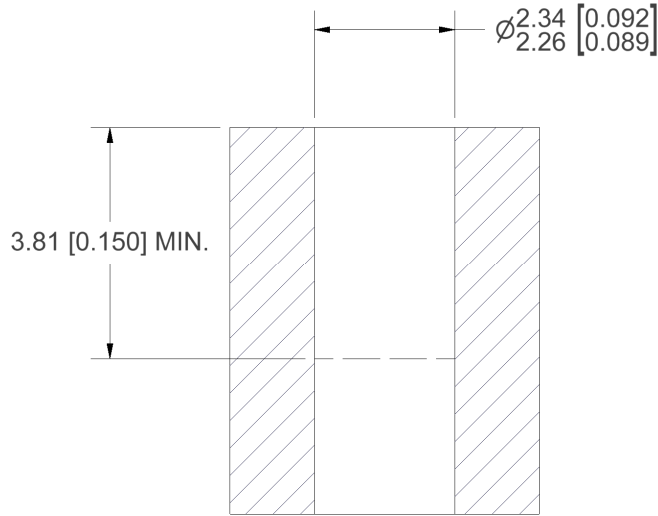
3. The series of smoothly curved lands of the Lee Orifice, 2.5 mm, Press-In product seals and retains the product in the plastic installation hole.

Factory Best Practices:

1. Examine the condition of the Installation Tool at appropriate intervals and replace if damaged or chipped.
2. Clean feed bowls once per day.
3. Turn off vibratory feed bowl when the assembly station is idle, or if the feed rail is full of parts.
4. Use the minimum vibration setting necessary to advance valves in the feed bowl.
5. If the product is blown into the assembly area from the feed rail, minimize the air pressure at which the product is blown into the assembly area to prevent possible damage.

4. Appendices

Appendix A Installation Hole

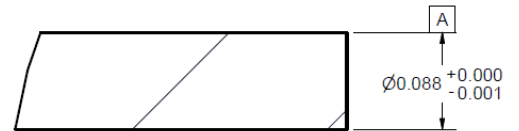
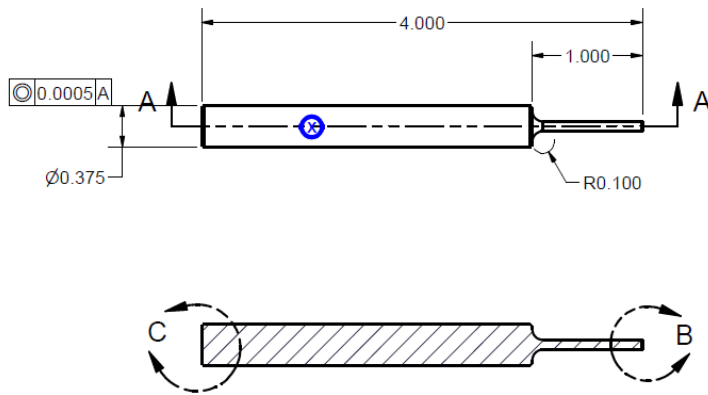


DIMENSIONS IN MILLIMETERS

Note: Draft angle to fall within diameter tolerance

Refer to Lee Drawing No. 1INST005724S

Appendix B Installation Tool



DETAIL B
SCALE 10 : 1

DIMENSIONS IN INCHES

Material: A2 Tool Steel

Hardness: 50-60 Rc

Marked with part number and revision.

Refer to Lee Part No. CCRT0024277S