



TA 1330-0001

Technical Instruction

Venturi ring insertion and removal press



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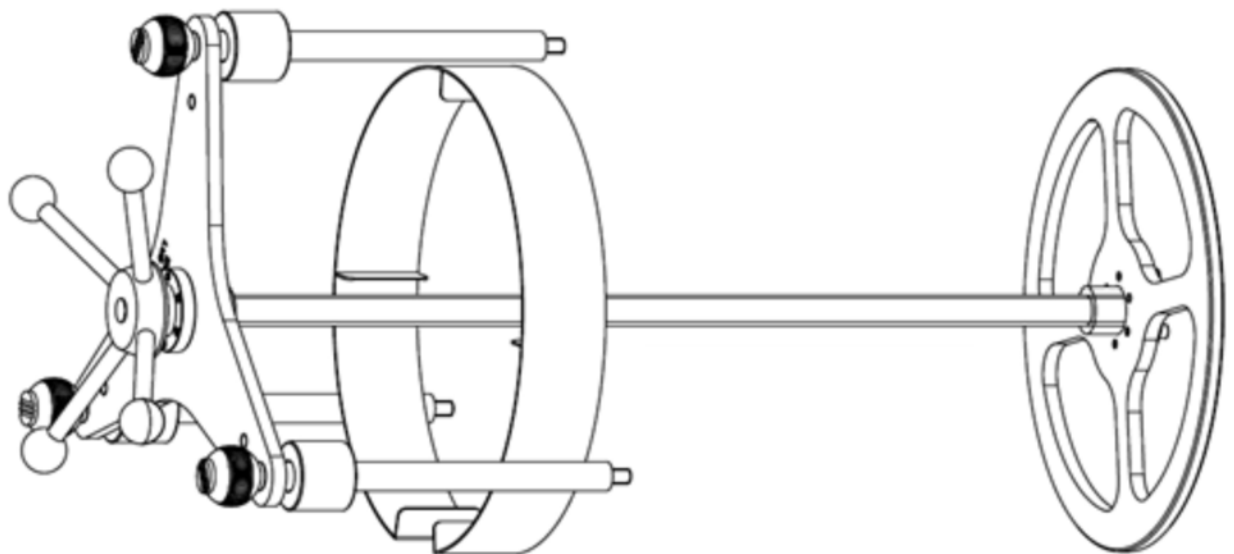
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1 Part number: 1215924



2 Safety regulations



Please observe the employee protection information in Technical Instruction no. 2300-0001.



Please observe the safety and hazard signs in the safety instructions (TA 2300-0005) and wear the appropriate personal protective equipment.

There is a danger of wounding, crushing and being caught, particularly at the thread and between the venturi insert ring and the plate or clamp. Wear appropriate protective gloves.

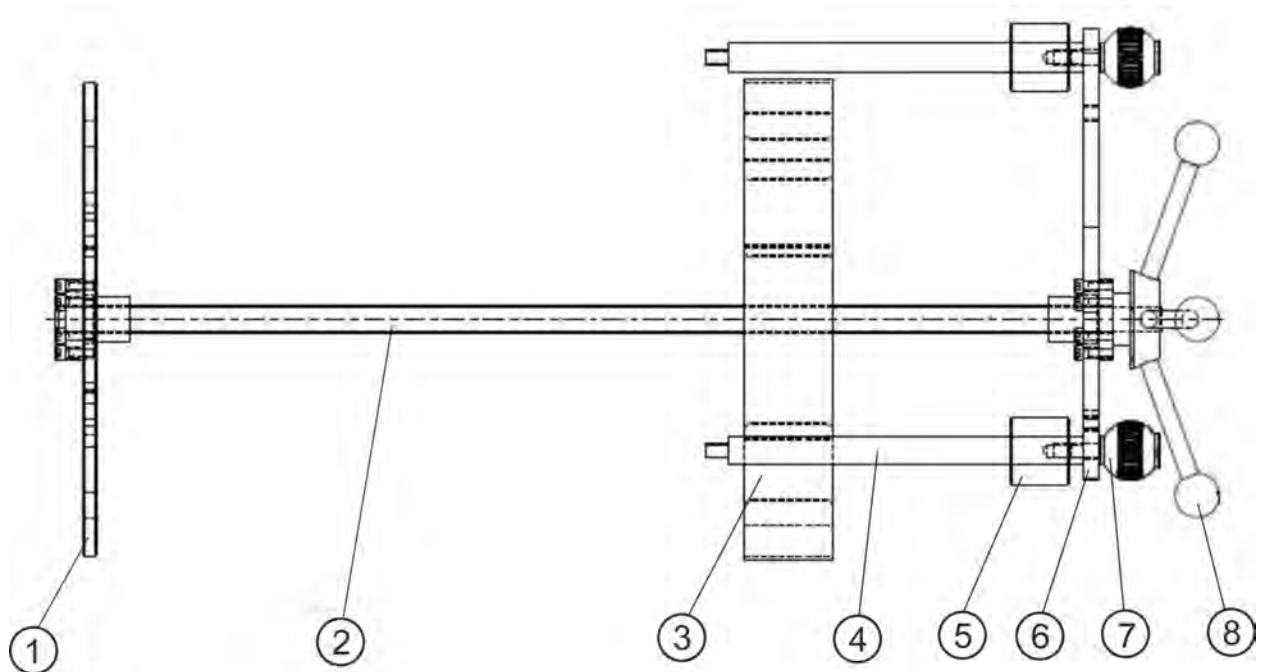
The venturi insert ring can fall out of the spacers in the event of carelessness and therefore represents a hazard.

3 Scope

This Instruction applies to the use of the assembly tool for inserting and removing the venturi insert ring in Type J612F, J616F and J620F engines.

4 Design and method of operation of the tool

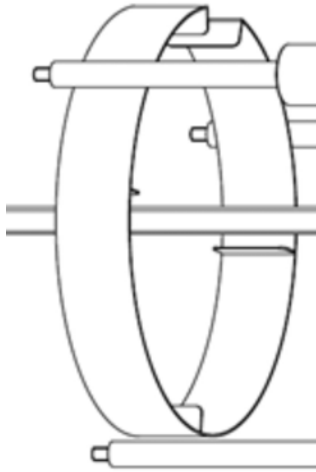
The tool consists of a number of parts. These are explained with the aid of the Figure below.



① Plate	⑤ Guide
② Spindle	⑥ Clamp
③ Centring ring	⑦ Knurled [thumb] screw
④ Spacer	⑧ Hand wheel

The purpose of plate ① is to push the venturi insert ring in or out of the gas mixer housing. Turning hand wheel ⑧ moves spindle ② so that plate ① is pressed against clamp ⑥. Three spacers ④ are screwed in place between the gas mixer housing and clamp ⑥ for both inserting and removing the venturi insert ring. During fitting, another 3 spacers can be screwed into the side of the gas mixer housing opposite the hand wheel ⑧ so that the venturi insert ring can be held here.

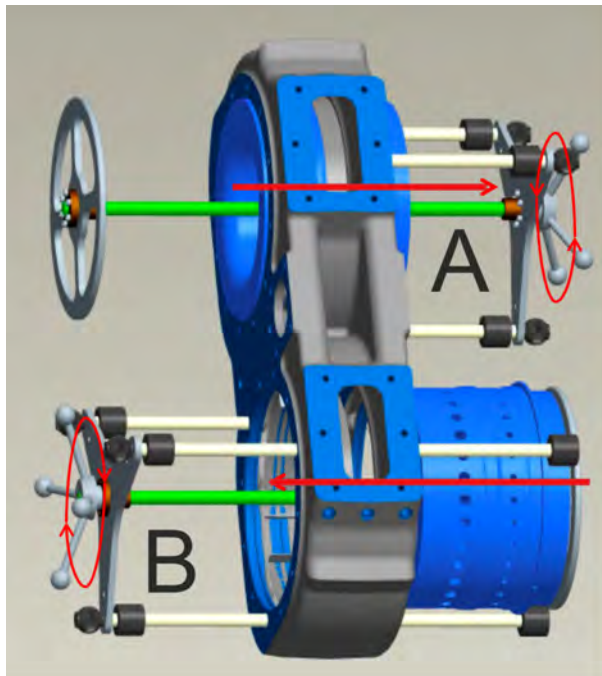
5 Method of operation of the centring ring



The centring ring is used when pressing the venturi insert ring into the gas mixer housing. It is used to secure the O-ring temporarily in the groove until the venturi insert ring has been fully pressed into the appropriate groove. After the O-ring has been placed in the groove, the centring ring is clamped in the appropriate position. The centring ring is then pushed out by the venturi insert ring when the latter is pressed into position.

6 Work steps when pressing a venturi insert ring in and out

The procedure for pressing a venturi insert ring in and out is shown in the illustrations below.



A	Pressing out the venturi insert ring	B	Pressing in the venturi insert ring
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6.1 Pressing in the venturi insert ring

1. Screw 3 spacers ④ into the gas mixer housing on the side from which the venturi insert ring is to be pressed in.
2. Screw 3 spacers ④ into the opposite side of the gas mixer housing.
3. Place the venturi insert ring on the spacers at the side from which the venturi insert ring is pressed in.
4. Insert spindle ② on clamp ⑥ in the venturi insert ring.
5. Secure clamp ⑥ on spacers ④ using knurled screws ⑦ on the side opposite the venturi insert ring.
6. Screw plate ① on to the spindle.
7. Check if the washer is in the correct position on the venturi insert ring.
8. Place the O-ring (closest to the venturi insert ring) in the groove in the gas mixer housing.
9. Tighten down the clamp ring on the position of the O-ring.
10. Turn hand wheel ⑧ to press in the venturi insert ring until the latter completely covers the relevant O-ring.
11. Repeat steps 8 to 10 for the following O-ring positions until the venturi insert ring is pressed in all the way.
12. Unscrew plate ① from spindle ② and remove it.
13. Undo knurled screw ⑦ and remove clamp ⑥.
14. Unscrew and remove all spacers ④.

6.2 Pressing out the venturi insert ring

1. Screw 3 spacers ④ into the gas mixer housing on the side where the venturi insert ring is to be pressed out.
2. Insert spindle ② on clamp ⑥ in the venturi insert ring.
3. Secure clamp ⑥ on spacers ④ using knurled screws ⑦ on the side where the venturi insert ring is to be pressed out.
4. Screw plate ① on to spindle ②.
5. Check if the plate is in the correct position on the venturi insert ring.
6. Turn hand wheel ⑧ until the venturi insert ring has been completely pressed out.
7. Undo knurled screw ⑦ and remove clamp ⑥.
8. Remove the venturi insert ring from the spacers.
9. Unscrew and remove all spacers ④.

7 Revision code

Revision history

Index	Date	Description / Revision summary	Expert Auditor
2	15.04.2019	GE durch INNIO ersetzt / GE replaced by INNIO	Opoku <i>Pichler R.</i>
1	19.06.2013	Erstausgabe / First issue	Bilek <i>Spyra</i>