

- NOTES:**
- "BLUE GOOP" TO BE APPLIED TO ALL HIGH PRESSURE FITTINGS.
 - HIGH PRESSURE FITTING TORQUE SPECS ARE TO BE:
 - 1/4" FITTINGS: 15-25 FT-LBS (20-34 Nm)
 - 3/8" FITTINGS: 35-45 FT-LBS (47-60 Nm)
 - BALLOON ITEMS WITH THE 8-DIGIT PN'S ARE SERVICE PARTS ONLY, AND DO NOT CONTRIBUTE TO THE BOM FOR THIS SCHEMATIC.
 - SEVERAL COMPONENTS REQUIRE DISASSEMBLY TO REPLACE ITS EXISTING COLLAR AND GLAND W/ AN ANTI-VIBRATION ASSY.

- CUSTOMER SERVICE NOTES:**
- HIGH PRESSURE GAUGE BECAME STANDARD SABERJET EQUIPMENT AND WAS ADDED TO THE HEAD & BRIDGE ON 1/2/19 (ECO 7588). IT WAS MOVED TO THIS DRAWING WITH THE RELEASE OF THE SABERJET XP ON 6/20/19. SEE ECO'S 7588 AND 7942 FOR DETAILS.
 - WITH THE RELEASE OF THE SABERJET XP THE ISOLATION VALVE LOCATED ON THE SWIVEL FRAME WAS ELIMINATED FROM SABERJET'S. AFTER 6/20/19, THIS VALVE WAS NEVER INSTALLED ON A SABERJET XP. SEE ECO 7940 FOR DETAILS.
 - WITH THE ADDITION OF THE TWO TABLE SABERJET XP THE (2) "Y"-AXIS 1/4" CABLE CARRIER TUBES WERE MOVED TO THE "BASE ASSEMBLY" ON THE SABERJET AND SABERJET XP AND IS CALLED OUT ON THE "BRIDGE TO BASE 1 ASSEMBLY" ON THE SABERJET XP-2T.

NO	PART NO	DESCRIPTION	SIZE	QTY
40	70000755	HP ADAPTOR, 3/8M X 1/4F		1
39	94097	HP GAUGE LINE, 1/4 INCH		1
38	70000773	GAUGE, WATER, 0-80,000 PSI		1
37	97001	C-AXIS TO A-AXIS HP LINE, 1/4 INCH		1
36				1
35	70003257	ABRASIVE REGULATOR ASSEMBLY		1
34	94096	R&F HP LINE SHORT, 3/8 INCH		1
33	70000911	HP PLUG 3/8"		1
32	70000774	HP TEE 3/8"		1
31				
30				
29				
28	70000785	FLEXIBLE METAL HOSE, 1/4 ID	780.000 in	1
27	70000786	FLEXIBLE METAL HOSE, 3/8 ID	180.000 in	1
26	70000985	REDUCER COUPLING 4F#		1
25	70008044	3/8" INLINE SWIVEL		1
24	70003271	DIALINE CUTTING HEAD ASSEMBLY		1
23	70003270	ACCUVALVE ASSY		1
22	70003272	ACCUVALVE MOUNT		1
21	94096	A-AXIS HP LINE, 1/4 INCH		1
20	70002373	1/4" HP COUPLER		1
19	70008045	90 DEG 1/4" HP SWIVEL		1
18	70003281	1/4" HP GLAND		10
17	70003290	1/4" HP COLLAR		10
16				
15				
14				
13	94089	C-AXIS HP LINE, 1/4 INCH		1
12	70000766	ELBOW, 1/4" HP		1
11	70009867	3/8" ANTI-VIBRATION ASSEMBLY		1
10	70009968	1/4" ANTI-VIBRATION ASSEMBLY		1
9	70003330	3/8" HP COLLAR		5
8	70003331	3/8" HP GLAND		5
7	70001490	TUBE, 3/8 HP, 3" LG		1
6	70000781	ELBOW, 3/8 HP		1
5	93444	R&F HP LINE LONG, 3/8 INCH		1
4	93443	X-TRAV HP LINE, 1/4 INCH		2
3	93442	BRIDGE HP LINE, 3/8 INCH		1
2				
1	70003284	3/8" TO DUAL 1/4" HP INLINE WYE		4

DATE	DESCRIPTION	BY	CHKD
8/28/20	DELETED ITEM 57 (70000300) MOVED TO HP PUMP DWG.	H	
	ADDED NOZZLE REFERENCE NOTE (BKT 2)	8747	
5/8/20	DELETED ITEM 2 (93441)	G	
KJK	MOVED TO BASE ASSEMBLY	8648	
	ADDED ITEM 40	G	
	ADDED SERVICE NOTE 3	8568	
3/16/20	DELETED ITEM 36 (100 FT OF 70006160)	F	
KJK	TEMP REMOVAL OF ITEM 35	6731	
8/16/19	REVISED 60 HP ORIFICE REF	8592	
	VERIFIED HP POLYMER VALVE (ITEM 15-70000759) AND CONNECTING TUBES	8132	
6/20/19	ADDED ITEM 35 AND 36 (SEE ECR 1642)	5247B	
KJK	ADDED ITEM 35 AND 36	A	
	DATE	DESCRIPTION	BY
			EQD

REVISIONS

NO	DATE	DESCRIPTION
1	6/15/2017	ISSUED FOR PRODUCTION
2	6/15/2017	ISSUED FOR PRODUCTION
3	6/15/2017	ISSUED FOR PRODUCTION
4	6/15/2017	ISSUED FOR PRODUCTION
5	6/15/2017	ISSUED FOR PRODUCTION
6	6/15/2017	ISSUED FOR PRODUCTION
7	6/15/2017	ISSUED FOR PRODUCTION
8	6/15/2017	ISSUED FOR PRODUCTION
9	6/15/2017	ISSUED FOR PRODUCTION
10	6/15/2017	ISSUED FOR PRODUCTION
11	6/15/2017	ISSUED FOR PRODUCTION
12	6/15/2017	ISSUED FOR PRODUCTION
13	6/15/2017	ISSUED FOR PRODUCTION
14	6/15/2017	ISSUED FOR PRODUCTION
15	6/15/2017	ISSUED FOR PRODUCTION
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31	6/15/2017	ISSUED FOR PRODUCTION
32	6/15/2017	ISSUED FOR PRODUCTION
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37	6/15/2017	ISSUED FOR PRODUCTION
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39	6/15/2017	ISSUED FOR PRODUCTION
40	6/15/2017	ISSUED FOR PRODUCTION

Park Industries P.O. BOX 188
ST. CLOUD, MN 56302
USA

HIGH PRESSURE SCHEMATIC
SABERJET AND SABERJET XP

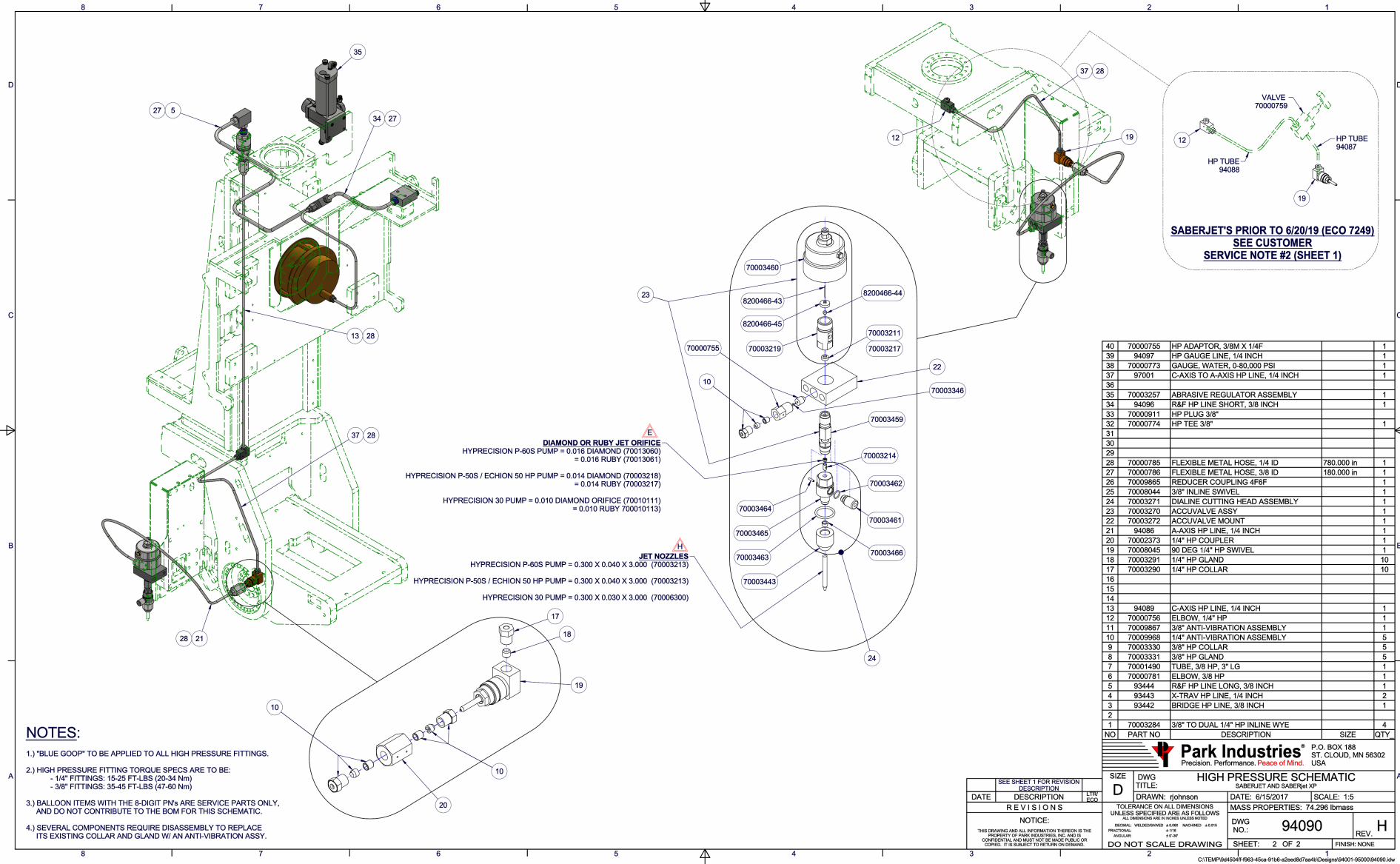
DRAWN: rjohnson DATE: 6/15/2017 SCALE: 1 / 20
MASS PROPERTIES: 74.296 lbmass

TOLERANCE ON ALL DIMENSIONS UNLESS SPECIFIED AS FOLLOWS:
ALL DIMENSIONS ARE IN INCHES UNLESS NOTED OTHERWISE.
FRACTIONAL DECIMALS: 1/16" 1/8" 3/16" 1/4" 3/8" 1/2" 5/8" 3/4" 7/8" 1" 1 1/8" 1 1/4" 1 1/2" 1 3/4" 2" 2 1/4" 2 1/2" 2 3/4" 3" 3 1/4" 3 1/2" 3 3/4" 4" 4 1/4" 4 1/2" 4 3/4" 5" 5 1/4" 5 1/2" 5 3/4" 6" 6 1/4" 6 1/2" 6 3/4" 7" 7 1/4" 7 1/2" 7 3/4" 8" 8 1/4" 8 1/2" 8 3/4" 9" 9 1/4" 9 1/2" 9 3/4" 10"

DWG NO.: **94090** REV. **H**

DO NOT SCALE DRAWING SHEET: 1 OF 2 FINISH: NONE

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NOTES:

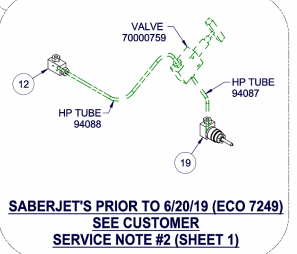
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DIAMOND OR RUBY JET ORIFICE
 HYPRECISION P-60S PUMP = 0.016 DIAMOND (70013060)
 = 0.016 RUBY (70013061)

HYPRECISION P-50S / ECHION 50 HP PUMP = 0.014 DIAMOND (70003218)
 = 0.014 RUBY (70003217)

HYPRECISION 30 PUMP = 0.010 DIAMOND ORIFICE (70010111)
 = 0.010 RUBY (70010113)

JET NOZZLES
 HYPRECISION P-60S PUMP = 0.300 X 0.040 X 3.000 (70003213)
 HYPRECISION P-50S / ECHION 50 HP PUMP = 0.300 X 0.040 X 3.000 (70003213)
 HYPRECISION 30 PUMP = 0.300 X 0.030 X 3.000 (70006300)



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37	97001	C-AXIS TO A-AXIS HP LINE, 1/4 INCH		1
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33	70000911	HP PLUG 3/8"		1
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NO	PART NO	DESCRIPTION	SIZE	QTY

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 USA

Precision. Performance. Peace of Mind.

HIGH PRESSURE SCHEMATIC
 SABERJET AND SABERJET XP

DATE: 6/15/2017 SCALE: 1:5
 DRAWN: rjohnson
 TOLERANCE ON ALL DIMENSIONS UNLESS SPECIFIED ARE AS FOLLOWS:
 ALL DIMENSIONS ARE IN INCHES UNLESS NOTED OTHERWISE
 FRACTIONAL 1/16" DECIMAL 0.0005" 0.001" 0.002" 0.005" 0.010" 0.015" 0.030" 0.050" 0.100"
 ANGULAR ±0.5° ±1.0° ±2.0° ±3.0° ±4.0° ±5.0° ±6.0° ±8.0° ±10.0° ±15.0° ±20.0° ±25.0° ±30.0° ±45.0° ±60.0° ±90.0° ±120.0° ±180.0°
 FINISH: NONE

NO. 94090 SHEET: 2 OF 2

DATE	DESCRIPTION	BY	EQD

REVISIONS

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DO NOT SCALE DRAWING

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