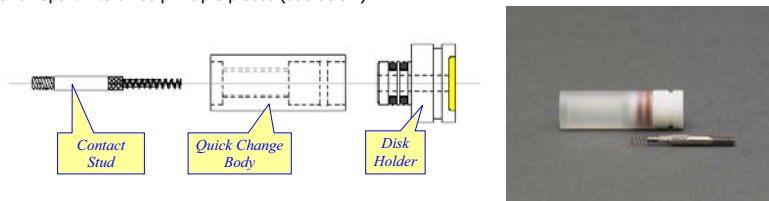




Working With ChangeDisk RDE Tips

Document LMEC002

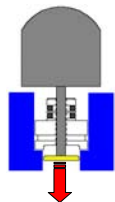
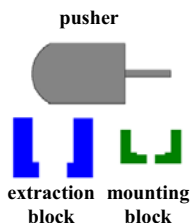
Our popular ChangeDisk style RDE tips allow the disk material to be changed easily. These tips can be taken apart into three principle pieces (see below).



The Teflon disk holder has two silicone o-rings which seal it into the KEL-F quick-change body. A contact stud which passes through the quick-change body provides the electrical connection between the back side of the disk material and the rotator shaft. Before the disk material can be removed or mounted, the disk holder must be removed from the quick-change body.

Tool Kit

Three tools are needed to change the disk material: the pusher, the mounting block, and the extraction block. Be sure to safely store these tools in the same place that you keep your electrode tip.



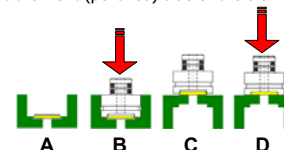
Extracting a Disk from a ChangeDisk RDE Tip

To remove the disk material from the disk holder, place the disk holder into the extraction block with the disk material on the bottom. Insert the pusher through the disk holder and gently apply pressure to push the disk material down and out of the disk holder.



Mounting a Disk in a ChangeDisk RDE Tip

To install disk material into an empty disk holder, use the mounting block. Care should be taken when handling the disk material so that the front (polished) side of the disk is not scratched or damaged.



- Carefully drop the disk material into the mounting block. The polished surface should be face down. The chamfer surface should be on top. Make sure the disk material is centered and seated in the shallow well located in the bottom of the mounting block.
- Place the disk holder down into the mounting block. Gently apply pressure so that the disk material becomes partially inserted into the mounting block. Do not attempt to push the disk material all the way into the disk holder at this time.
- Remove the disk holder from the mounting block and then turn the mounting block over. After checking for any debris on the mounting block that might scratch the surface of the disk material, place the disk holder on top of the inverted mounting block.
- Gently apply pressure to the disk holder until the disk material is fully inserted. The surface of the disk material should be flush with the surface of the disk holder.

Replacement Parts

The following table is useful for reordering standard parts for quick change RDE tips.

	Newer E4 Series Tips (for 5 mm OD disks that are 4 mm thick)	Older E4 Series Tips (for 5 mm OD disks less than 3 mm thick)	QC444 Series** Tips (for 1.5 mm thick disks with 1.0 cm ² area)
contact stud	ACE4TVQ	ACE4TVQ	ACE4TVQ
quick change body	ACE4TB	ACE4TB	ACE4TB
disk holder	ACE4THQ050*	ACE4TH050*	AFPR028
disk holder o-ring	KAA010	KAA010	KAA010
pusher	ACE4KP	ACE4KP	ACE4KP
extraction block	ACE4KE050	ACE4KE050	ACIKB444
mounting block	ACE4KM050	ACE4KM050	ACIKS444
shaft (AFASR rotator)	AFE3A	AFE3A	AFE3A
shaft (AFMSRX rotator)	AFE3M	AFE3M	AFE3M

* E4 tips purchased before October 2005 used disk holder ACE4TH050 and could only accommodate disk inserts up to 3.0 mm thick. Newer tips use part ACE4THQ050 and can accommodate disks up to 4.0 mm thick.

** The QC444 Series tips are offered by Princeton Applied Research. PAR catalog number RDE001 includes the quick change body, contact stud, disk holder, and a stainless steel disk. PAR catalog number RDE002 includes the pusher, extraction block, and mounting block. www.princetonappliedresearch.com