

# Lapping

Reworking the Seatings of the Seat & Disc



# Objectives of this Presentation. Expand specialized knowledge.

1. Objectives | 2. Lapping of Seat/ Disc with Lapping Stamp | 3. Lapping of Seat/ Disc on a Glass Plate | 4. Lapping of the Seat on the Disc

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The objective of this presentation is to show the **reworking of the seatings of the seat and disc** for safety valves



# Lapping of Seat and Disc with Lapping Stamp.

1. Objectives | 2. Lapping of Seat/ Disc with Lapping Stamp | 3. Lapping of Seat/ Disc on a Glass Plate | 4. Lapping of the Seat on the Disc

- A **lapping stamp** is practical for **reworking damage** to rolled-in seats and discs with a lifting aid.
- The lapping stamp is equipped with a **ready-to-use lapping paste**. The seat or disc is lapped using a rotary motion of the stamp.
- A suitably coarse lapping paste must be selected depending on the size of the surface damage.



# Lapping of Seat and Disc on a Glass Plate.

1. Objectives | 2. Lapping of Seat/ Disc with Lapping Stamp | 3. Lapping of Seat/ Disc on a Glass Plate | 4. Lapping of the Seat on the Disc

- In order to obtain a better finish, **discs without lifting aids and screwed-in nozzles** can also be lapped on a glass plate.
- To do this, the **mono-crystalline diamond powder is mixed with oleic acid** on the glass plate. Then, the seat and disc are lapped with light, circular, hand movements on the glass plate.
- A suitably coarse lapping paste must be selected, depending on the size of the surface damage.



# Lapping of the Seat on the Disc.

1. Objectives | 2. Lapping of Seat/ Disc with Lapping Stamp | 3. Lapping of Seat/ Disc on a Glass Plate | 4. Lapping of the Seat on the Disc

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- To achieve even better surface smoothness, the disc can be re-lapped on the seat.
- To do this, mix mono-crystalline diamond powder with oleic acid and apply it selectively to the disc.
- The workpiece is re-lapped through a uniform rotary motion of the disc.



**Lapping**

Thank you for your attention.

