Models Affected:
Linea – UL ONLY
FB-70 – UL ONLY

LA·MARZOCCO

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TECHNICAL BULLETIN #36
November 8, 2004

Repair of Diffuser Screw Mating Threads in Group Casting

⚠ CAUTION: Prior to performing this procedure, ensure espresso machine has cooled down to less than 95°F. Failure to do so may cause burns.

The threads in the group casting that accept the stainless steel diffuser screw (L106/V) can be repaired using the following procedure:

Repair Procedure #1
If the diffuser screw has been cross threaded or caused galling by inserting incorrectly, the threads may be repaired by re-threading the hole.
- Turn Machine off
- Drain brew boiler
- Remove group cap (L103), bayonet ring (L109), diffuser screw (L106/V) and diffuser screen (L107).
- Loosen TL29 – Tube, Internal Group, and bend away from hole.
- Thread M6X1 Tap in through the top of the group casting and slowly turn it until it has cleaned up all threads in the hole.

Repair Procedure #2
If the threads have been damaged beyond the repair process in procedure #1 then a threaded insert must be installed. After completing the steps in Repair Procedure #1, use the following procedure to install a threaded insert:
- Enlarge hole using a ¼" drill.
- Tap hole using a M6X1 STI (Screw Thread Insert) Tap.
- Place threaded insert on installation tool
- Thread insert into group casting starting from the bottom (screen side)
- Insure that the insert does not protrude from the top of the casting. Protrusion of the insert will cause the TL29 tube not to seat correctly.
- Break of tang using needle nose pliers.
- Thread diffuser screw into group casting to ensure fit.
- Replace parts removed during Repair Procedure #1

Necessary Additional Tools to Complete Procedure:
- M6X1 Metric Tap (Repair Procedure #1 only)
- Helicoil Repair Kit #5546-6 (See Picture on following page)
- ¼" Drill Bit (Suitable for drilling stainless steel)

**HeliCoil Thread Repair Kit
#5546-6 M6X1**

**Repair Kit Contents
1 - M6X1 STI Tap
1 – Plastic tool (Not Used)
1 – Installation Tool
12 – Threaded Inserts**

Installation tool with Insert