




Orifices WorkFlow

Version 1.0



 OXIKIT WORKFLOW	Document #	Date Effective
	OXIKIT-OR001	
Supersedes Document Version #:		
Document Title		
Workflow - Orifices		

Change History Log:

VERSION #	REVISION DATE	DESCRIPTION OF CHANGE	
		FROM	TO
1.0	11/27/2020	Original Release	


- I. **Purpose:**
This Workflow is intended to serve as a guide in making the Orifices of the Oxikit.

- II. **Scope:**
This guideline applies to all individuals who wish to build the DIY Oxikit. It includes the Materials, tools and the Video Link needed in making the Orifices.

- III. **Picture:**



Fig 1.0 (Orifices)

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IV. Safety Operating Conditions:

- Always wear protective gloves

V. Workflows

- Please see next page for the step by step guidelines in making the Orifices

Steps

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Material

Tools

YouTube Link

1	Measure 7mm into the aluminum rod.	<table border="1"> <thead> <tr> <th>Name</th> <th>Description</th> <th>Metric Conversion</th> <th>Unit of Measure</th> </tr> </thead> <tbody> <tr> <td>Aluminum Rod</td> <td>1/4" Aluminum Rod</td> <td>6.4mm Aluminum Rod</td> <td>Piece</td> </tr> </tbody> </table>	Name	Description	Metric Conversion	Unit of Measure	Aluminum Rod	1/4" Aluminum Rod	6.4mm Aluminum Rod	Piece	Caliper	https://www.youtube.com/watch?v=qwXvRRReWQ54&list=PL4O1RQEiLpHBJ0i1zqe-CZk1p_NTtGI76&index=7
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3

Cut the aluminum rod. Make 6 pieces

Name	Description	Metric Conversion	Unit of Measure
Aluminum Rod	1/4" Aluminum Rod	6.4mm Aluminum Rod	Piece

- Tube Cutter

https://www.youtube.com/watch?v=qwXvRRReWQ54&list=PL4O1RQEiLpHBJ0i1zqe-CZk1p_NTtGI76&index=7

4

Hold the Orifice in place

Name	Description	Metric Conversion	Unit of Measure
Orifices	1/16" hole Orifices	1.6 mm hole Orifices	Piece

- Heavy Nut
- Locking Pliers

https://www.youtube.com/watch?v=qwXvRRReWQ54&list=PL4O1RQEiLpHBJ0i1zqe-CZk1p_NTtGI76&index=7

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5

Mark and Punch a small hole on the center of the Orifice

Name	Description	Metric Conversion	Unit of Measure
Orifices	1/16" hole Orifices	1.6 mm hole Orifices	Piece

- Heavy Nut
- Locking Pliers
- Hammer
- Punch Steel

https://www.youtube.com/watch?v=qwXvRRReWQ54&list=PL4O1RQEiLpHBJ0i1zqe-CZk1p_NTtGI76&index=7

6

Place the Orifice inside the Drill Bit Machine Chuck

Name	Description	Metric Conversion	Unit of Measure
Orifices	1/16" hole Orifices	1.6 mm hole Orifices	Piece

- Drill Bit Machine

https://www.youtube.com/watch?v=qwXvRRReWQ54&list=PL4O1RQEiLpHBJ0i1zqe-CZk1p_NTtGI76&index=7

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10	Drill the other end of the Orifice using a 1/8" Drill bit (holding it by hand) until it reaches the middle portion of the orifice	<table border="1"> <thead> <tr> <th>Name</th> <th>Description</th> <th>Metric Conversion</th> <th>Unit of Measure</th> </tr> </thead> <tbody> <tr> <td>Orifices</td> <td>1/16" hole Orifices</td> <td>1.6 mm hole Orifices</td> <td>Piece</td> </tr> </tbody> </table>	Name	Description	Metric Conversion	Unit of Measure	Orifices	1/16" hole Orifices	1.6 mm hole Orifices	Piece	<ul style="list-style-type: none"> • Drill Bit Machine • Drill Bit 1/8" 	https://www.youtube.com/watch?v=qwXvRRReWQ54&list=PL4O1RQEiLpHBJ0i1zqe-CZk1p_NTtGI76&index=7
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11

Drill the marked Orifice using a 1/8" Drill bit(holding it by hand) on the other end until it reaches the middle portion of the orifice

Name	Description	Metric Conversion	Unit of Measure
Orifices	1/16" hole Orifices	1.6 mm hole Orifices	Piece

- Drill Bit Machine
- Drill Bit 1/8"

https://www.youtube.com/watch?v=qwXvRRReWQ54&list=PL4O1RQEiLpHBJ0i1zqe-CZk1p_NTtGI76&index=7

12

Measure 104mm length of Tubing.

Name	Description	Metric Conversion	Unit of Measure
Tubing	High Density Polyethylene (HDPE) Tubing, 1/4" ID, 3/8" OD (10 Feet Per Machine Required)	High Density Polyethylene (HDPE) Tubing, 6mm ID, 10mm OD (3 meters Per Machine Required)	meter

- Ruler
- Sharpie/Marker

https://www.youtube.com/watch?v=qwXvRRReWQ54&list=PL4O1RQEiLpHBJ0i1zqe-CZk1p_NTtGI76&index=7

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13

Cut the marked tubing as per step 12. Ensure tube is cut evenly, no skews on the end. Make 6 pieces

Name	Description	Metric Conversion	Unit of Measure
Tubing	High Density Polyethylene (HDPE) Tubing, 1/4" ID, 3/8" OD (10 Feet Per Machine Required)	High Density Polyethylene (HDPE) Tubing, 6mm ID, 10mm OD (3 meters Per Machine Required)	meter

• Scissors/Cutter

https://www.youtube.com/watch?v=qwXvRRReWQ54&list=PL4O1RQEiLpHBJ0i1zqe-CZk1p_NTtGI76&index=7

14

Place and Push the orifices inside the clear vinyl tubing until it reaches the middle Portion of the tube

Name	Description	Metric Conversion	Unit of Measure
Tubing	High Density Polyethylene (HDPE) Tubing, 1/4" ID, 3/8" OD (10 Feet Per Machine Required)	High Density Polyethylene (HDPE) Tubing, 6mm ID, 10mm OD (3 meters Per Machine Required)	meter
Orifices	1/16" hole Orifices	1.6 mm hole Orifices	Piece

• Punch Steel

https://www.youtube.com/watch?v=qwXvRRReWQ54&list=PL4O1RQEiLpHBJ0i1zqe-CZk1p_NTtGI76&index=7

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15	Inspect the Orifices if they fit well inside the tubes. If loose, proceed to the next step. If fits well, product is okay	<table border="1"> <thead> <tr> <th>Name</th> <th>Description</th> <th>Metric Conversion</th> <th>Unit of Measure</th> </tr> </thead> <tbody> <tr> <td>Orifices</td> <td>1/16" hole Orifices</td> <td>1.6 mm hole Orifices</td> <td>Piece</td> </tr> </tbody> </table>				Name	Description	Metric Conversion	Unit of Measure	Orifices	1/16" hole Orifices	1.6 mm hole Orifices	Piece		https://www.youtube.com/watch?v=qwXvRRReWQ54&list=PL4O1RQEiLpHBJ0i1zqe-CZk1p_NTtGI76&index=7
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