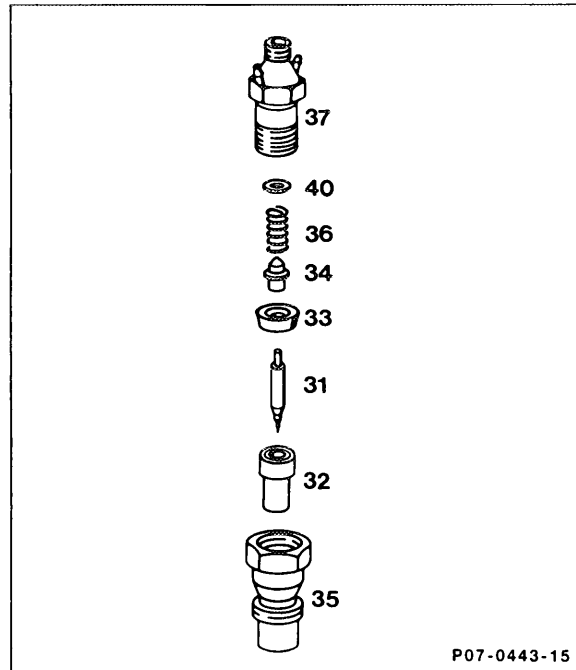


## 07.1-232 Reconditioning injectors (after testing) - Turbodiesel

Preceding work:

Removal and installation of injectors (07.1-230)

Testing injectors (07.1-231)



|                            |   |
|----------------------------|---|
| Injection nozzles          | disassemble(1).   |
| Nozzle needle (31)         | remove, install, visual and sliding inspection; clean center and longitudinal bore of hole pintle nozzles; install in the same nozzle body. |
| Nozzle body (32)           | remove combustion residues.   |
| Intermediate disc (33)     | dress on surface plate.   |
| Pressure pin (34)          | remove, install, point must be facing toward top section.   |
| Nozzle tensioning nut (35) | unscrew, reinstall, tightening torque 70-80 Nm.   |
| Compression spring (36)    | remove, insert.   |
| Holder (37)                | to strip down and assemble the injection nozzles, clamp in protective jaws of vice.   |

Steel washer (40) .....

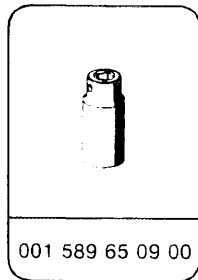
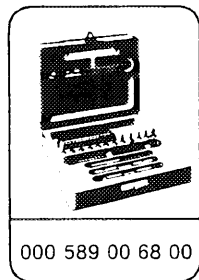
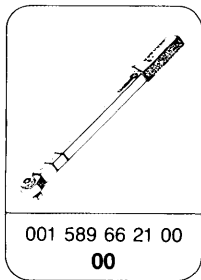
set for ejection pressure.

Specification:

135-145 bar for new or newly set nozzle, at least 120 bar for used nozzle. Ejection pressure higher or lower depending on thickness of washer.

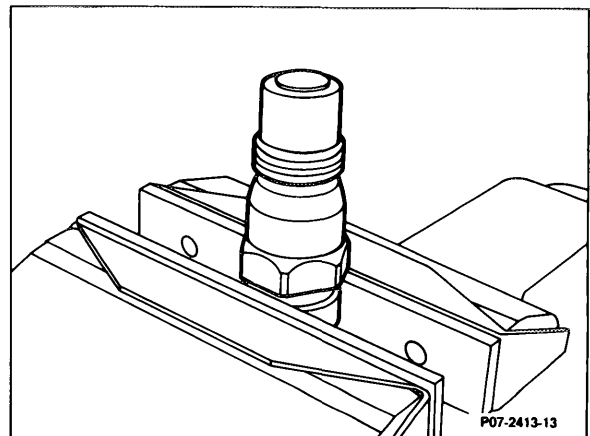
0.05 mm results in approx. 3 bar pressure difference.

### Special tools

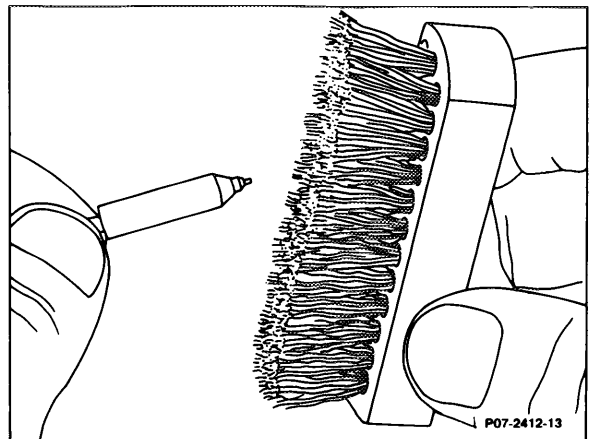


### Reconditioning

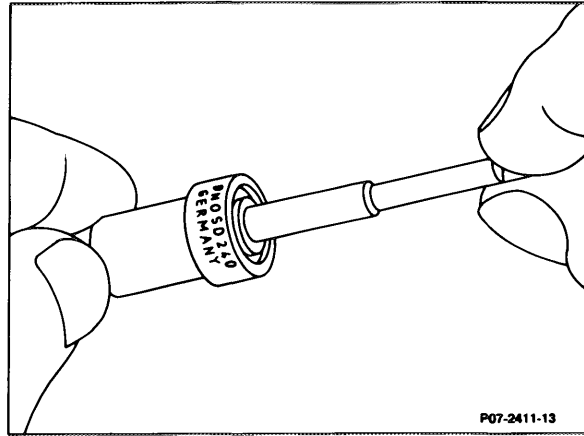
1 Disassemble injection nozzle by clamping body in vice with protective jaws so that the leak oil line connections are not damaged.



2 Clean nozzle needle and nozzle body with a brass wire brush.



Remove combustion residues on seat of nozzle needle with a scraper.



3 Visual and sliding inspection.  
Dip nozzle in filtered diesel fuel. With the nozzle body held upright, the nozzle pintle must slide towards the nozzle seat by its own weight.

4 Dress intermediate disc (33) on a surface plate.

5 Assemble nozzle holder with injection nozzle. Ejection pressure is set with the steel washer (40). Ejection pressure is higher or lower depending on thickness of the washer; 0.05 mm results in approx. 3 bar pressure difference.

6 Test injection nozzles (07.1-231). Set if necessary.

