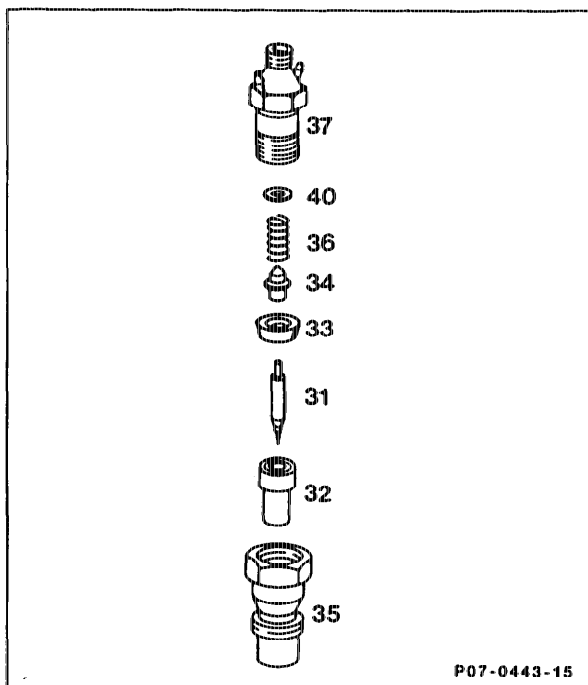


07.1-6750 Adjusting Injection Nozzles (After Testing)

Preceding work:
 Removing and installing injection nozzles (07.1-6810).
 Testing injection nozzles (07.1-6712).

Operation no. of operation texts and work units or standard texts
 and flat rates: 07-6750 or 07-6752



P07-0443-15

Injection nozzles	strip down (1).
Nozzle needle (31)	remove, install, visual and sliding inspection; clean centre 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, screw on, 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)

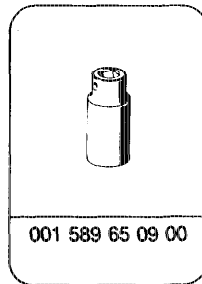
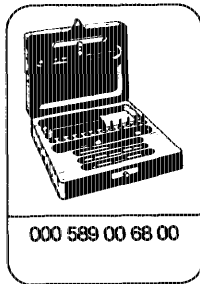
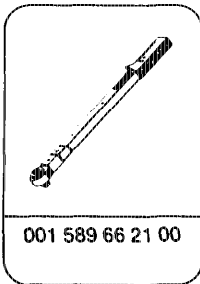
set for ejection pressure.

Specification:

135–145 bar for new or newly set nozzle, at least 130 bar for used nozzle. Ejection pressure higher or lower depending on thickness of washer.

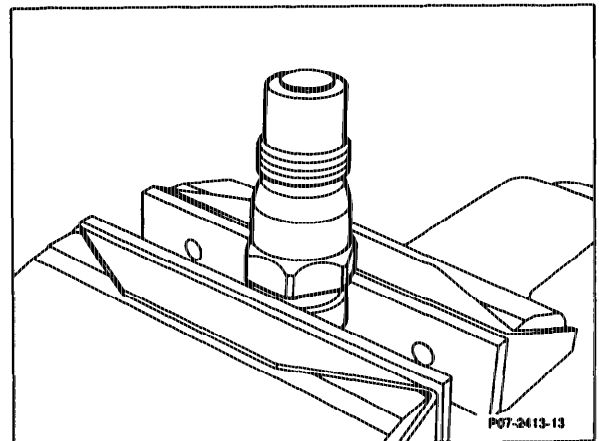
0.05 mm results in approx. 3 bar pressure difference.

Special tools

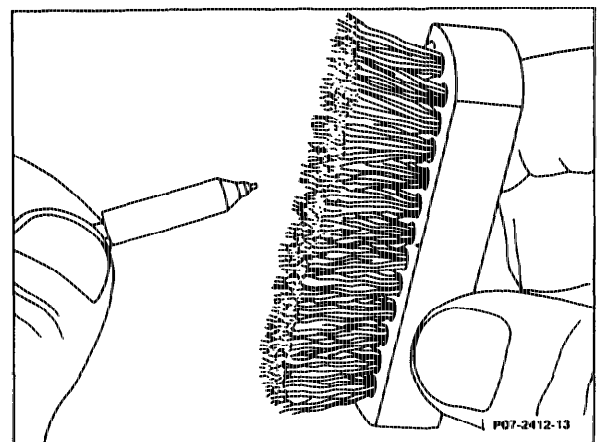


Reconditioning

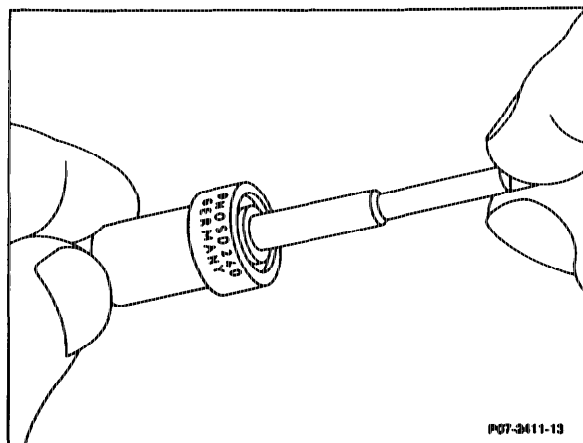
1 Disassemble injection nozzle by clamping body in vice with protective jaws so that the leak oil line connections are not damaged.



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



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



3 Visual and sliding inspection.

Dip nozzle in filtered diesel fuel. With the nozzle body held upright, the nozzle pintle must lie toward the nozzle seat as a result of its own deadweight.

4 Dress intermediate disc (33) on the 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.

