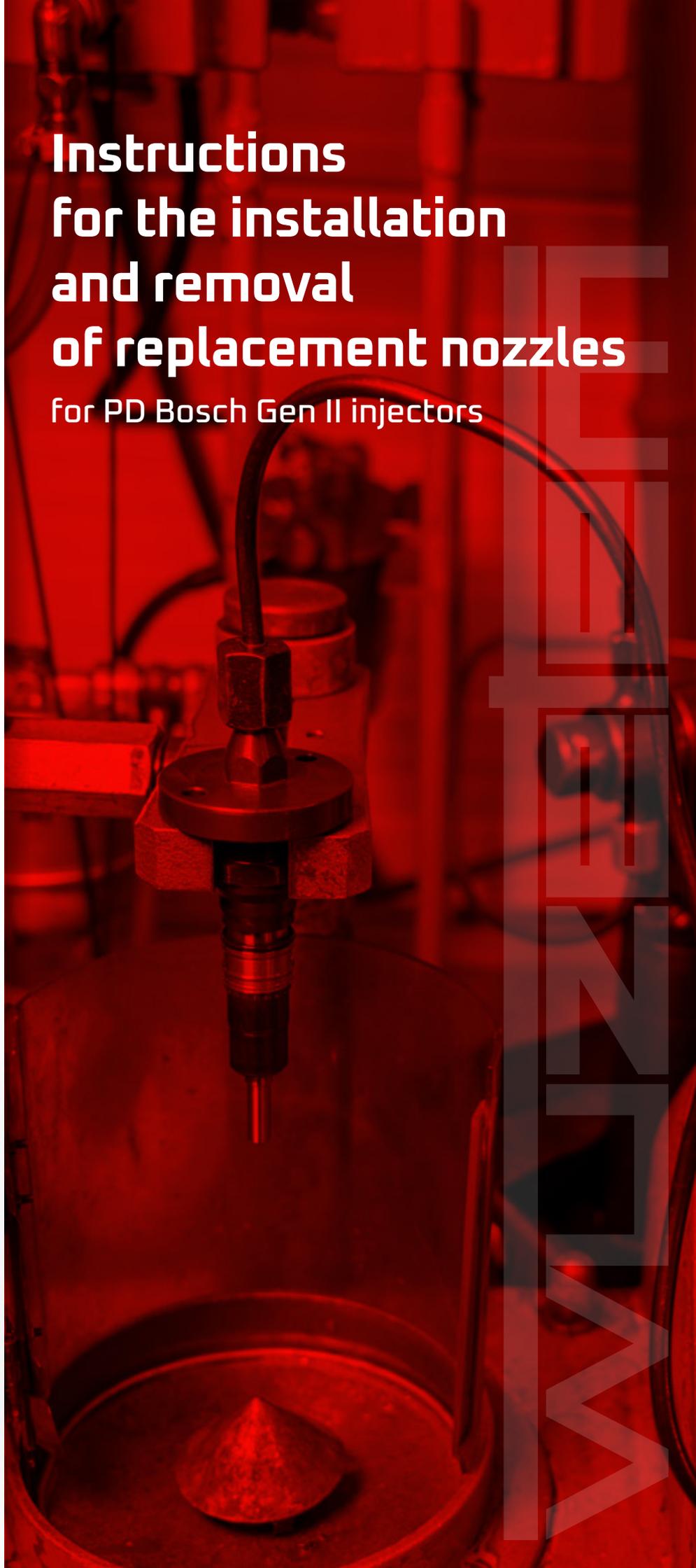
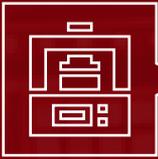


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Instructions for the installation and removal of replacement nozzles for PD Bosch Gen II injectors





All changeover work (installation and removal of the nozzle) should be performed using a suitable press, depending on the manufacturer.



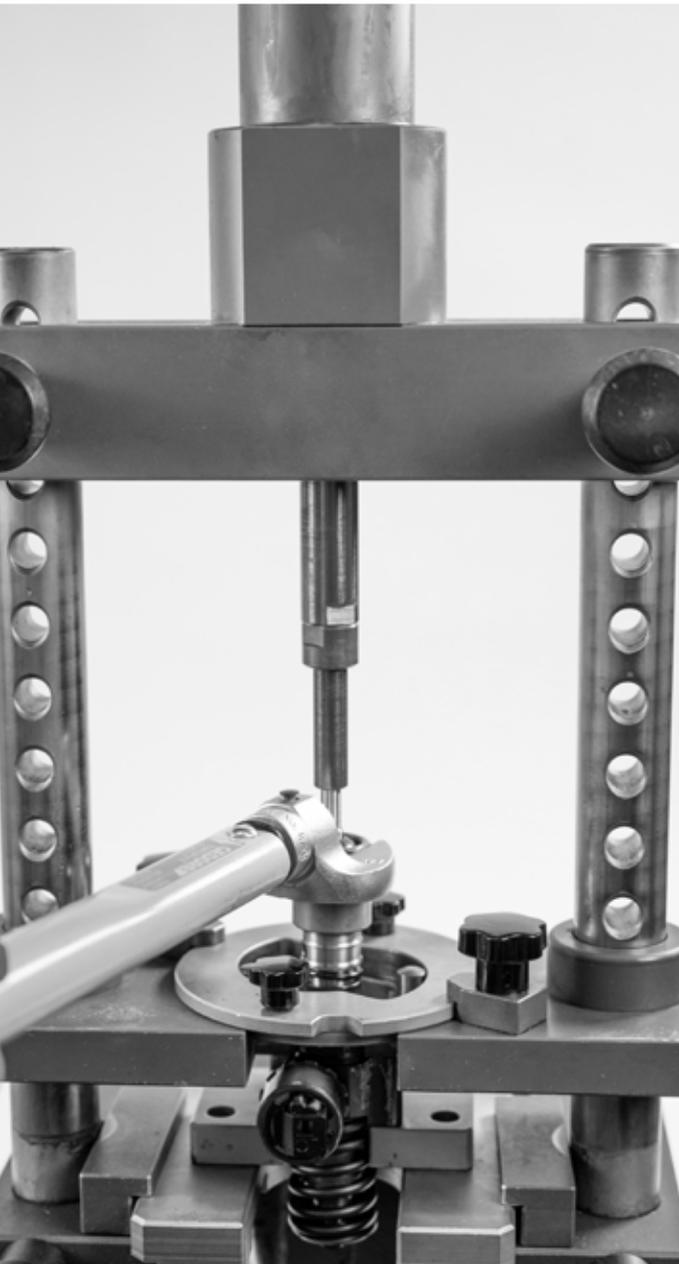
To tighten/loosen the screw of the nozzle retaining holder and nozzle nuts, use a torque wrench and/or angle disk.



When tightening the unit injector nut, always observe the parameters provided by the manufacturer of the injection system.

Instructions for the installation and removal of replacement nozzles for PD Bosch Gen II injectors

- ▷ removal
- ▷ installation
- ▷ setting the opening pressure



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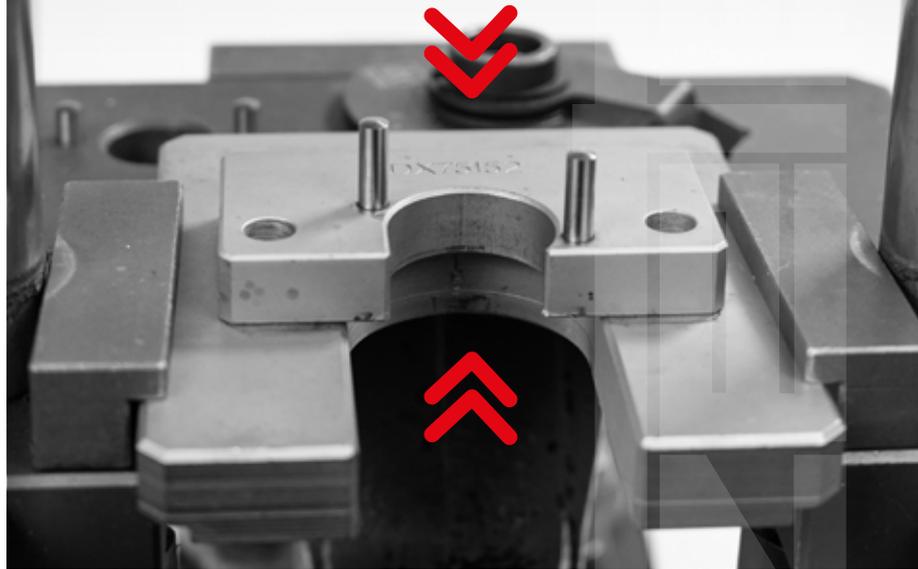
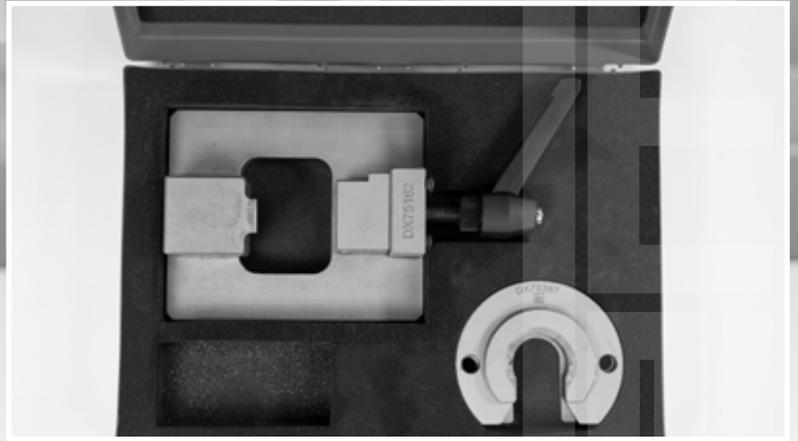
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KRS number: 0000320810
Share capital: PLN 20,000,000.00
Paid-up capital: PLN 20,000,000.00
NIP (Tax Identification Number): 525-000-08-60
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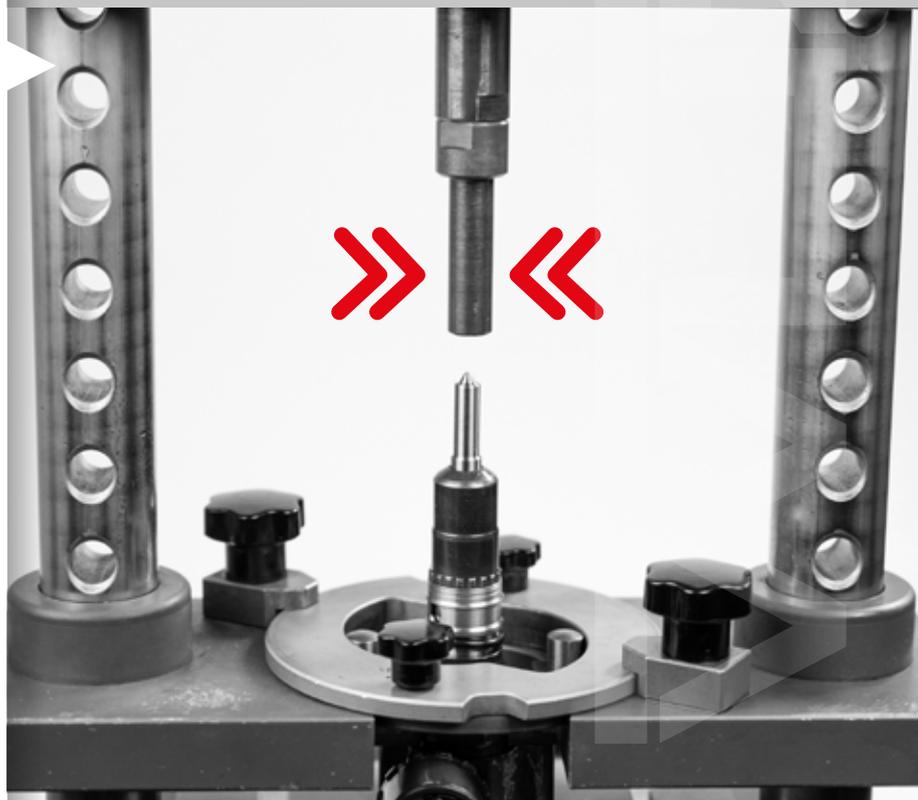
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removal

- 1 Use a suitable **mounting spacer** and place it in the **holder of the station**



- 2 Take the suitable nozzle retaining **holder adapter** and **install it** on the station.



removal

3

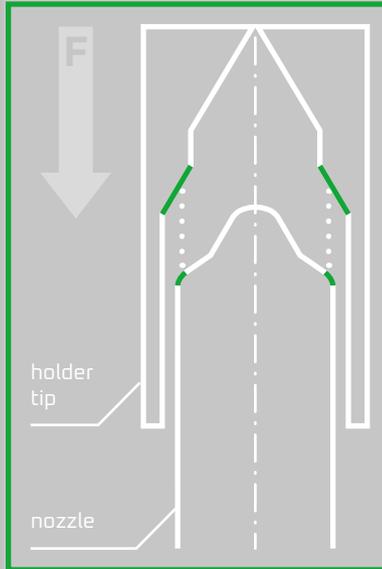
The tip of the nozzle retaining holder should rest on a surface below the spherical part of the nozzle (see the drawing on the right).

If it is supported higher, this will greatly increase the risk of misalignment between the tip and the nozzle, potentially causing damage to the nozzle

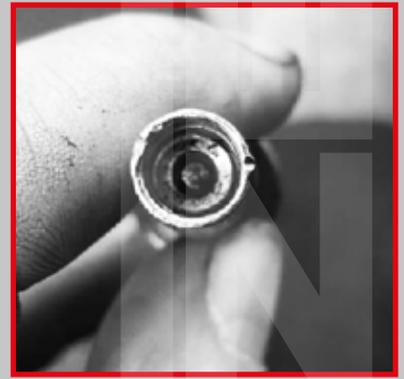
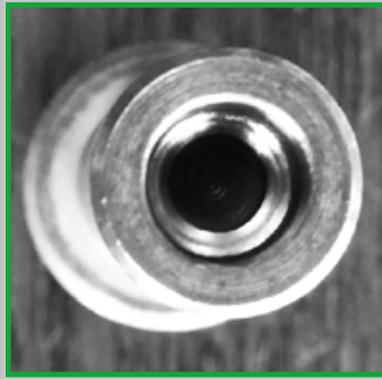
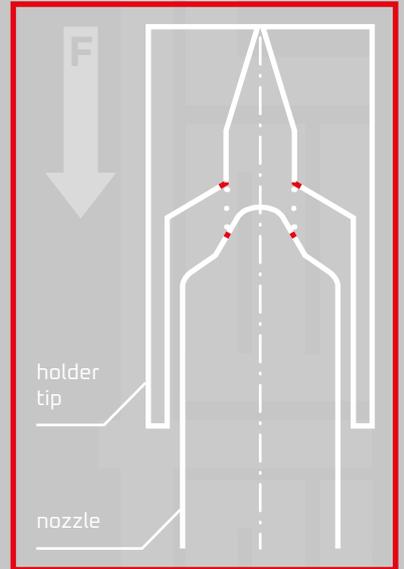


△ The photo shows the consequences of using the wrong holder, where the contact surface is located on the spherical part of the nozzle. In this case, permanent deformation will occur even if a relatively small force is used.

✓ correct



✗ incorrect



removal

4

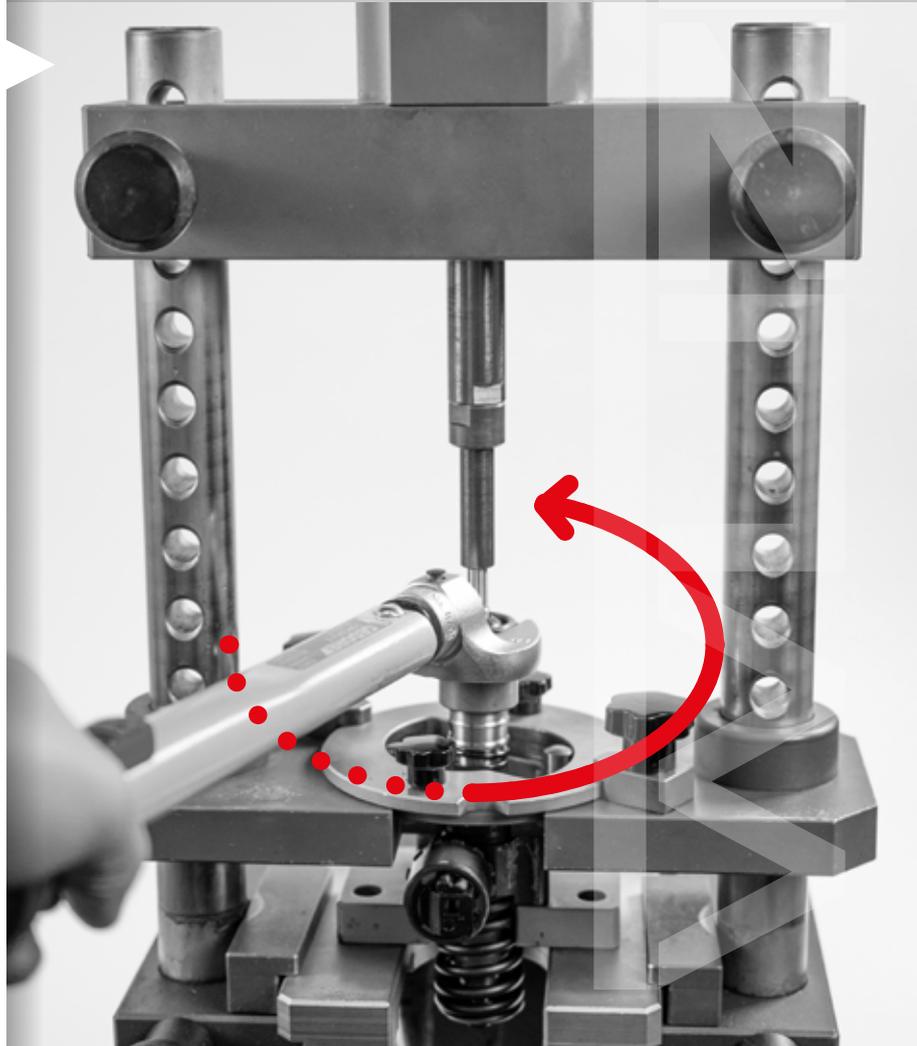
Tighten the top screw of the nozzle retaining holder until it is clamped against the face of the nozzle.

Tighten the screw to **30 Nm** using a torque wrench with a **30 mm** adapter



5

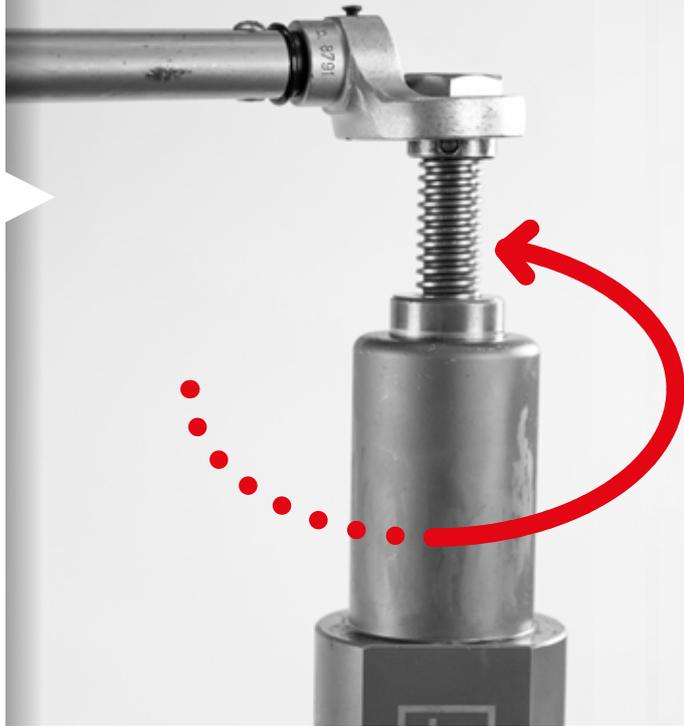
Undo the nozzle nut using a grooved adapter and a torque wrench with a **24 mm** adapter



removal

6

Undo the screw of the nozzle retaining holder and retract it into a position that enables the removal of the nut.

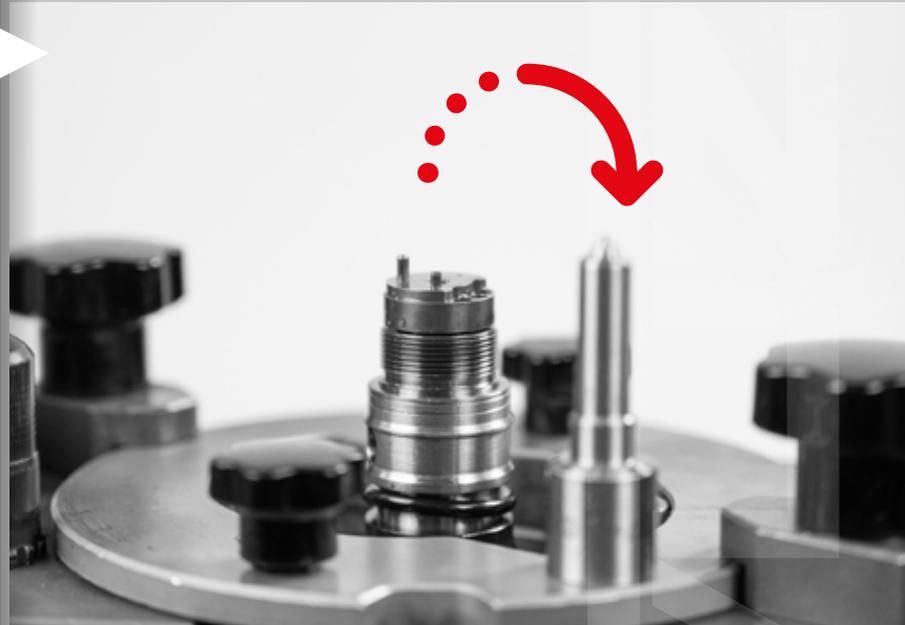


7

Remove the nut and then remove the **nozzle body with the needle**.

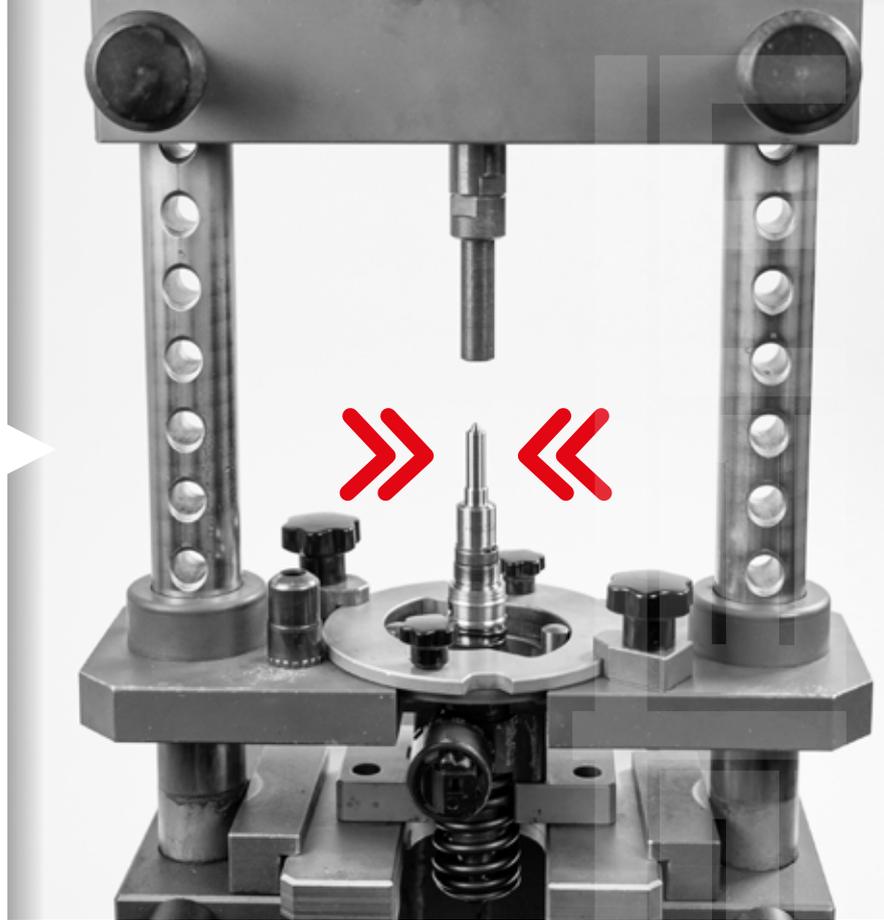
NOTE:

During nozzle removal, make sure **not to lose any components** of the unit injector located under the nozzle.



installation

- 1 Insert the **nozzle into the face** of the unit injector, aligning it accordingly using the alignment pins.



- 2 **Pre-tighten the nut** of the unit injector without using a torque wrench.

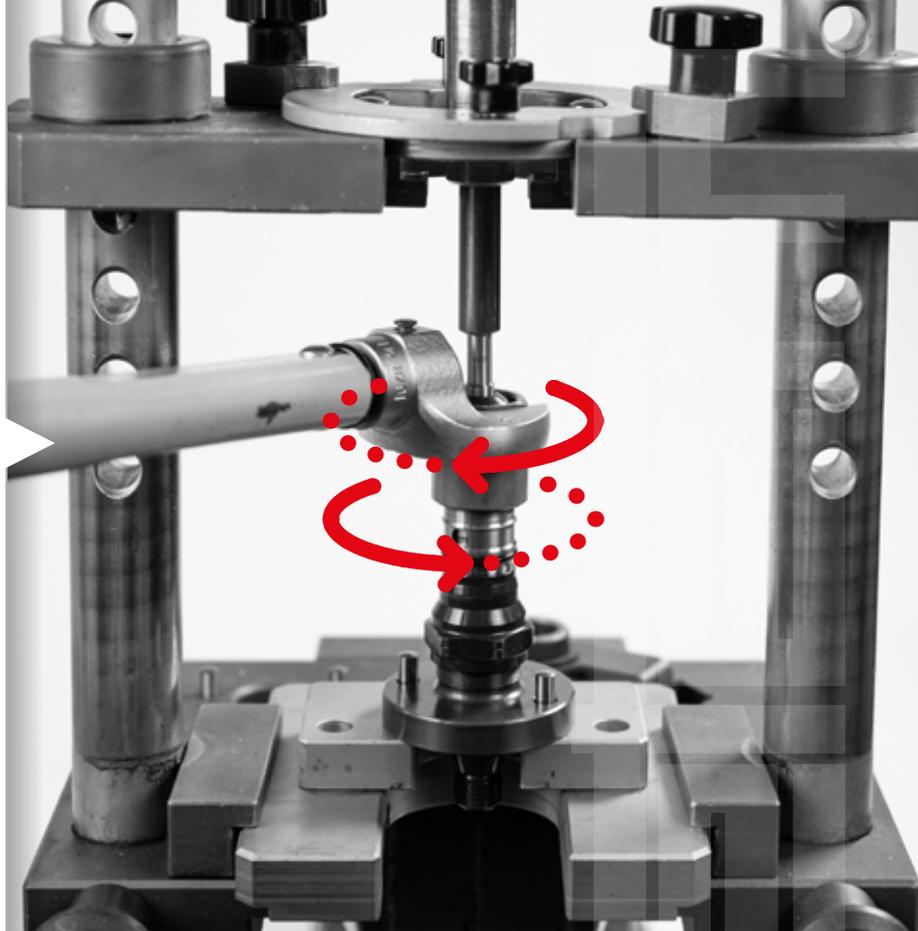
Tighten the screw of the nozzle retaining holder **to 30 Nm**.



installation

3

Pre-tighten the nut using a grooved adapter and a torque wrench with a **24 mm** adapter to the torque recommended by the manufacturer of the injection system and then unscrew the nut until the thread is completely loose.



4

Tighten the nut to the intermediate torque recommended by the manufacturer of the injection system to set the thread.



5

Tighten the nut to the final torque recommended by the manufacturer of the injection system.

setting the opening pressure

Before installing the unit injector on the test bench and before each replacement of the nozzle with a different nozzle, **check the nozzle opening pressure on the PRW-3 test bench injector.**

- 1** Undo the body of the unit injector using a **29 mm** adapter and pull the stack out together with the spacers and the nozzle of the injector unit.

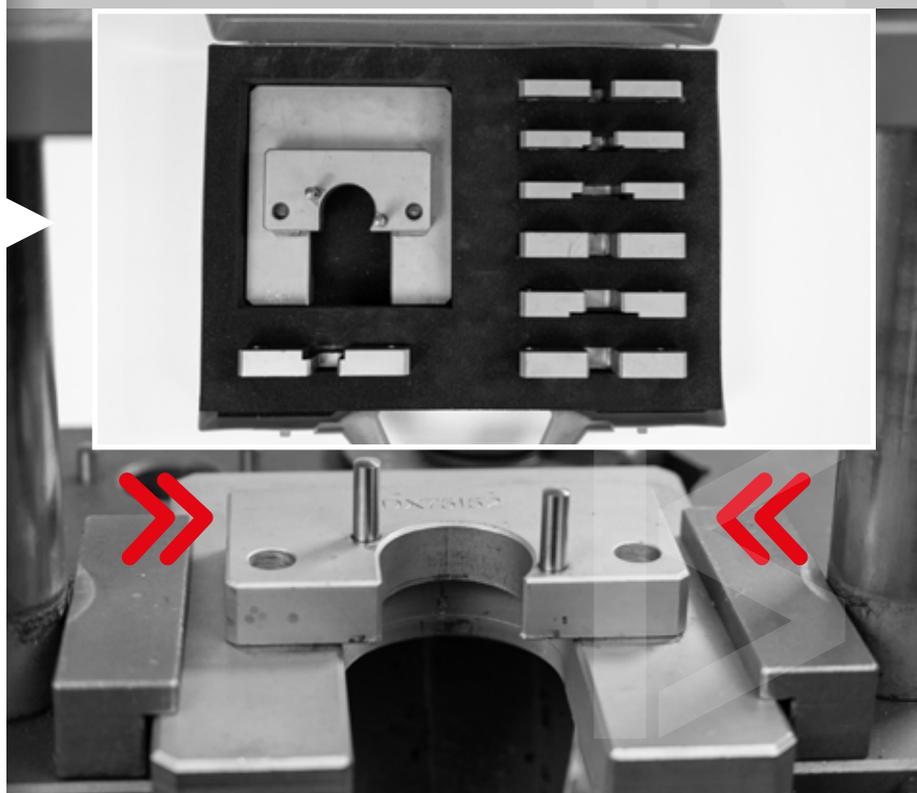


- 2** Install a suitable mounting spacer in the holder of the station.

Place the removed stack in the adapter and install it on the station.

Pre-tighten the nut without using a torque wrench.

Tighten the **screw of the nozzle retaining holder** using a **30 mm** adapter to **30 Nm**.



setting the opening pressure

3

Tighten the nut using the **29 mm** adapter to the torque recommended by the manufacturer of the injection system.



4

Install the adapter on the PRW-3 test bench injector and then check and adjust the opening pressure of the nozzle:

- a. **If the opening pressure is too low:**
Undo the nut using a **24 mm** adapter and **replace the puck** under the first spacer with a **thicker one**.
- b. **If the opening pressure is too high:**
Undo the nut using a **24 mm** adapter and **replace the puck** under the first spacer with a **thinner one**.



setting the opening pressure

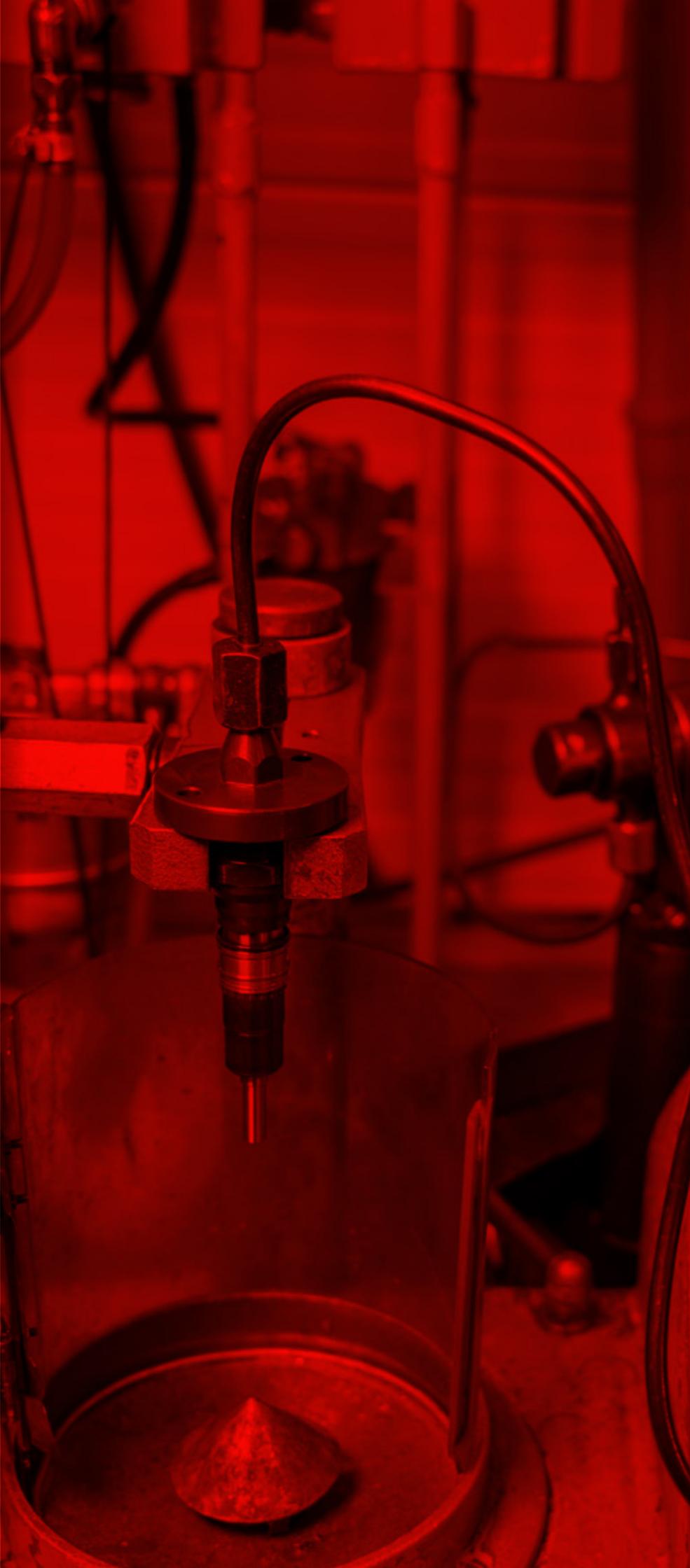
5

After adjustment, follow the same procedure to **undo the nut and pull the stack out** of the adapter.

Insert the stack together with the spacers and nozzle **into the unit injector**.

Tighten the top screw of the nozzle retaining holder to **30 Nm**. Tighten the body of the unit injector using the **29 mm** adapter to the torque recommended by the manufacturer of the injection system.





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Number): 012078978