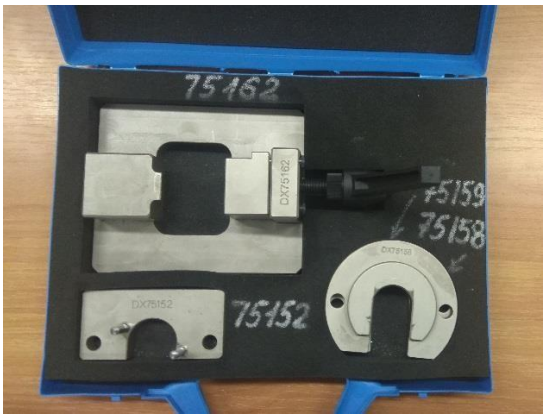
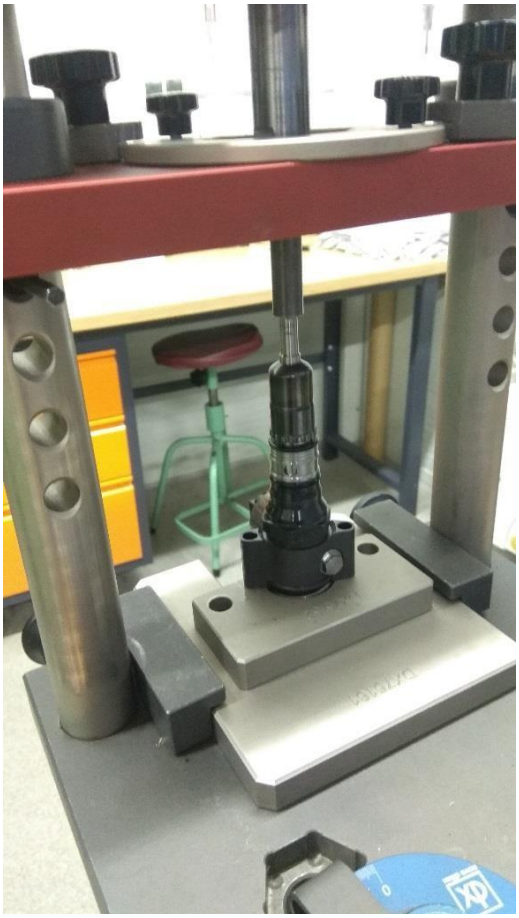
As regards this Instruction Manual, all refitting works (installation, removal of nozzle) are carried out using press **DX-75165** and **Nova Ditex** tooling. To tighten/unscrew nozzle retaining holder screw, nozzle nuts, use torque wrench and/or angle disc. When tightening the injector nut follow parameters given by the injection system manufacturer.

Procedure for nozzle removal:

1. Use appropriate mounting spacer from set **DX-75168** and place it in holder of station **DX-75165**.

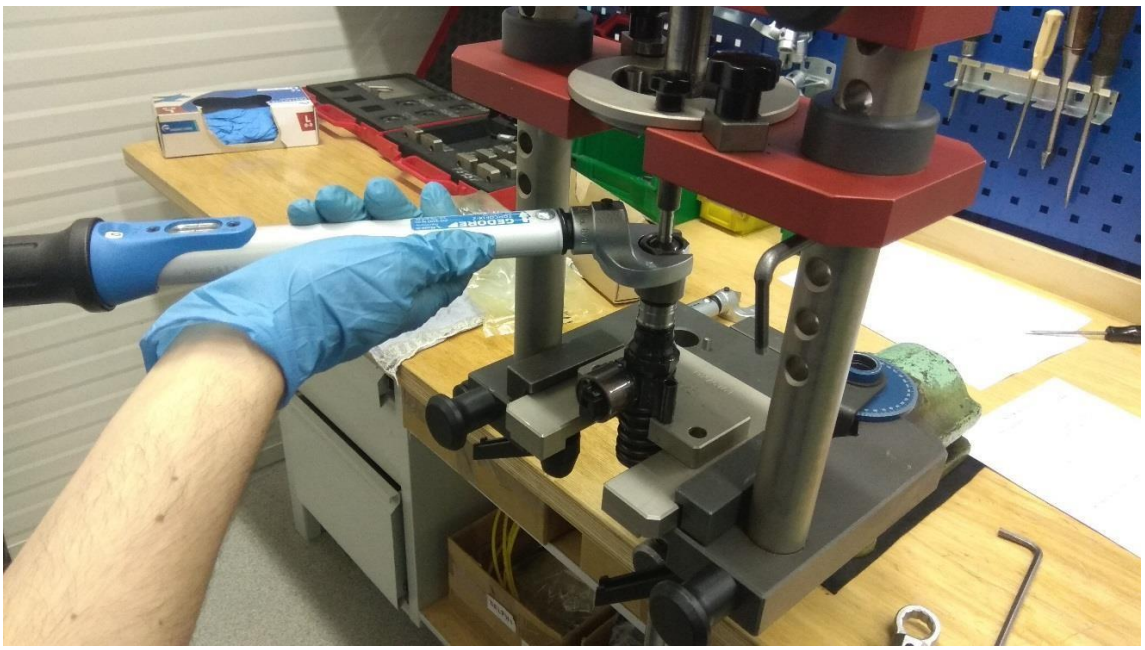


2. Take appropriate adapter of nozzle retaining holder **DX-75239** and install it on station **DX-75165**.



3. Tighten upper screw of nozzle retaining holder until clamped on nozzle front part. Tighten the screw to **30 Nm** by using adapter **30 mm DX-75356** and torque wrench.

4. Undo the nozzle nut by using a grooved adapter **DX-75328** by using a torque wrench with adapter **24 mm.**



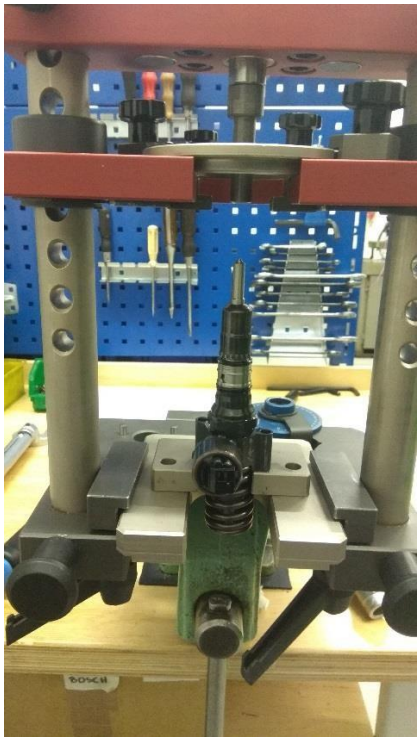
5. Unscrew nozzle retaining holder screw and retract it to position allowing for nut removal.

6. Remove the nut, and then nozzle body with the needle. Note: when removing please pay attention not to loose injector components located under the nozzle.

Procedure for nozzle installation:

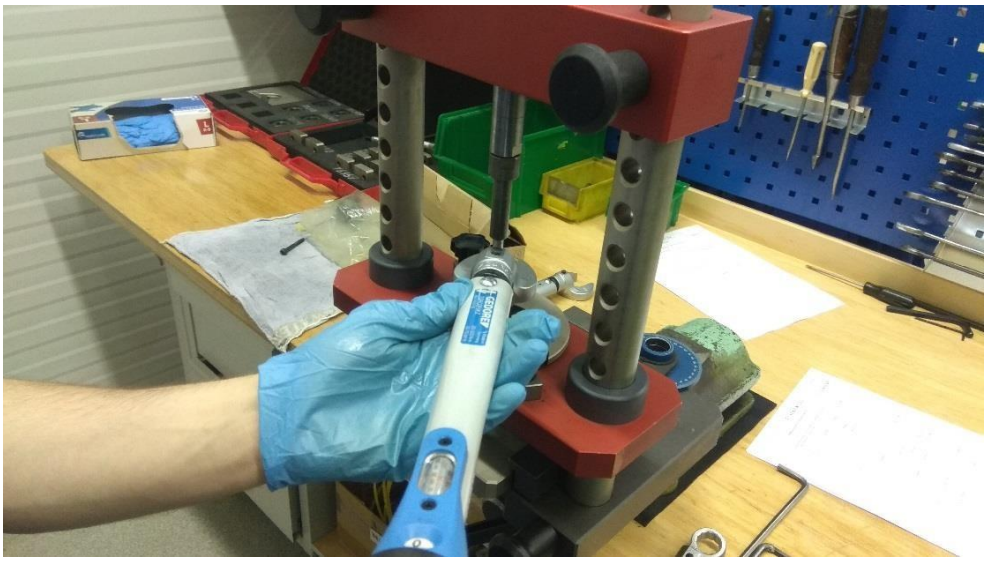
1. Insert the nozzle into injector front part, adjusting its position accordingly on base pins.

2. Pre-tighten injector nut without using torque wrench and tighten nozzle retaining holder screw to **30 Nm**.



3. Pre-tighten the nut using the grooved adapter **DX-75328** with a torque wrench with bit **24 mm** to a torque as recommended by the injection system manufacturer, and then unscrew the thread until completely loosen.

4. Tighten the nut intermediately to a torque as recommended by the injection system manufacturer to insert the thread.

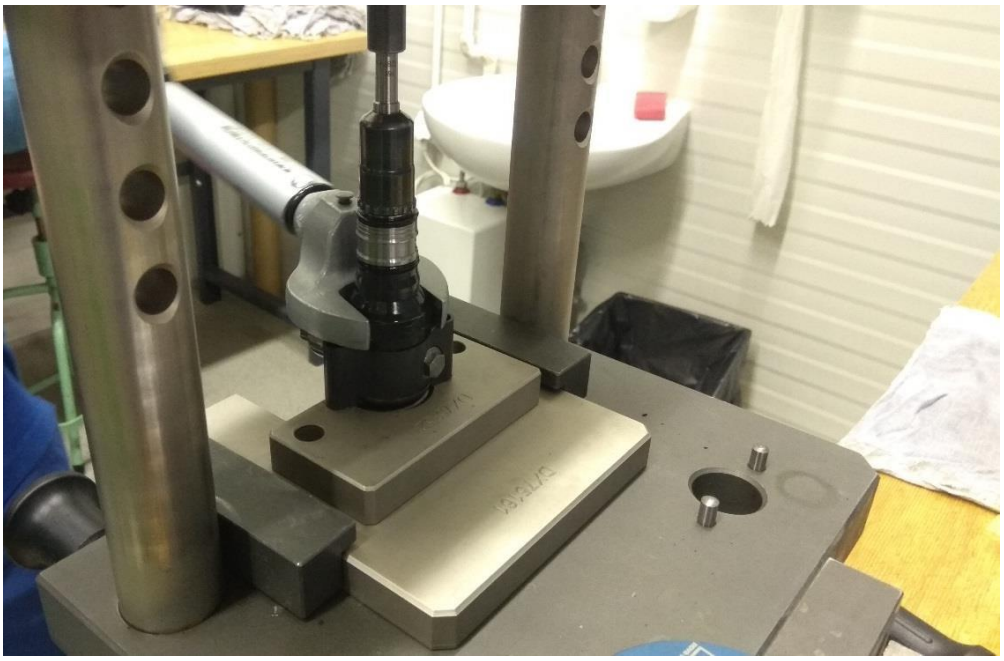


5. Tighten the nut to the final torque as recommended by the injection system manufacturer to insert the thread.

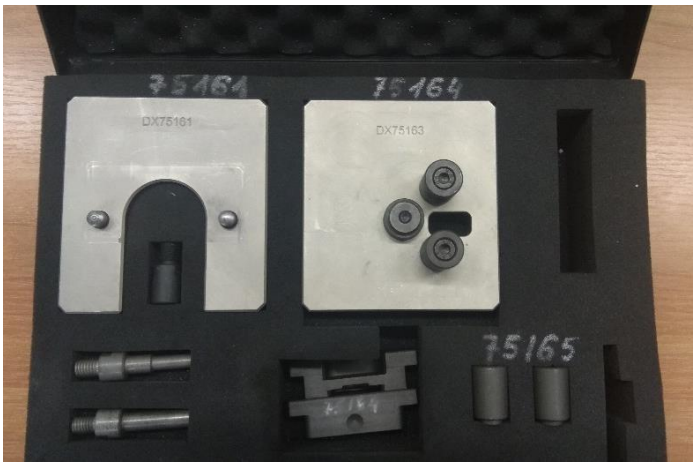
Procedure for setting opening pressure:

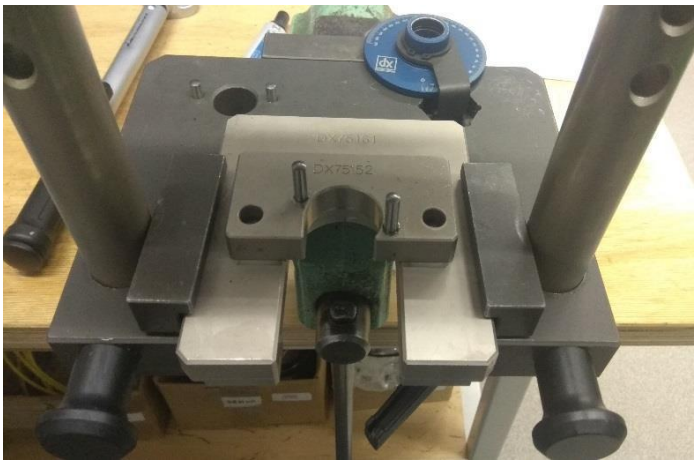
Before installation of unit injector on test table and for each replacement of nozzle for other, it is necessary to check nozzle opening pressure on test bench injector PRW-3. Procedure for checking opening pressure:

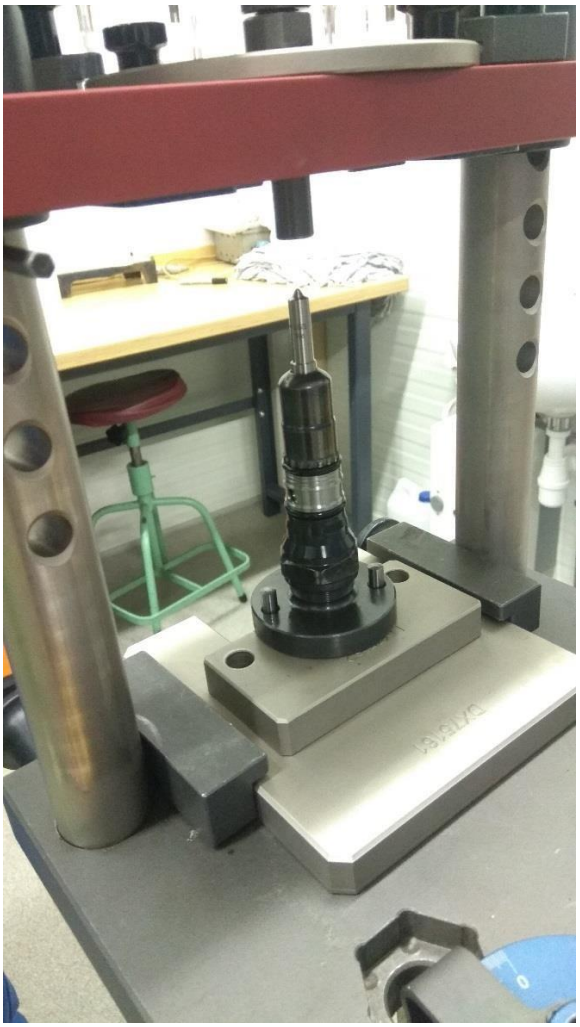
1. Unscrew the unit injector body by using bit **24 mm** and pull out the stack together with spacers and injector unit nozzle.



2. Install appropriate mounting spacer from set **DX-75239** and place it in holder of station **DX-75165**. Place the disconnected set in adapter **DX-73374** and install on the spacer, pre-tighten the nut without using a torque wrench, and then tighten the injector retaining holder screw by using bit **30 mm** to **30 Nm**.







3. Tighten the nut using grooved adapter **DX-75328** by using bit **24 mm** to a torque as recommended by the injection system manufacturer.

4. Install the adapter on test bench injector PRW-3, and then check and adjust nozzle opening pressure:
    a. If the opening pressure is too low, replace adjustment washer under first spacer for a thicker one,
    b. If the opening pressure is too high, replace adjustment washer under first spacer for a thinner one.

5. Once the adjustment is done, in the same way undo the nut and pull out the stack from the adapter, and then insert the stack together with spacers and nozzle to the unit injector.