

Tightening torque	Nm	(kpm)
Hex bolt for pressure test plate on refrigerant compressor	17	(1.7)

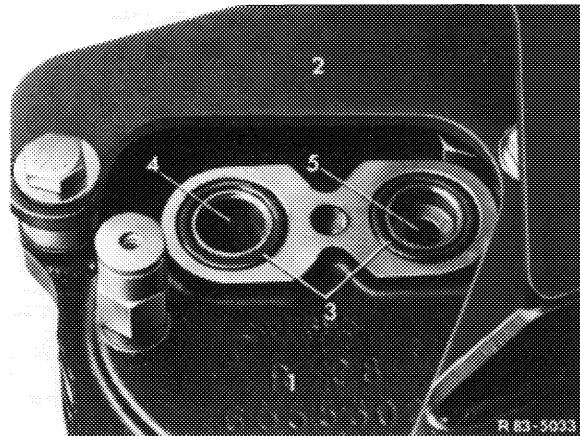
Special tool

Pressure test plate		109 589 00 25 00
---------------------	---	------------------

Conventional tools

Refrigerant bottle with R 12	e.g. made by Christof Fischer
Assembly tester with 3 filling hoses or evacuating and filling unit (service unit) for air conditioning systems	Augsburger Straße 289, 7000 Stuttgart 60

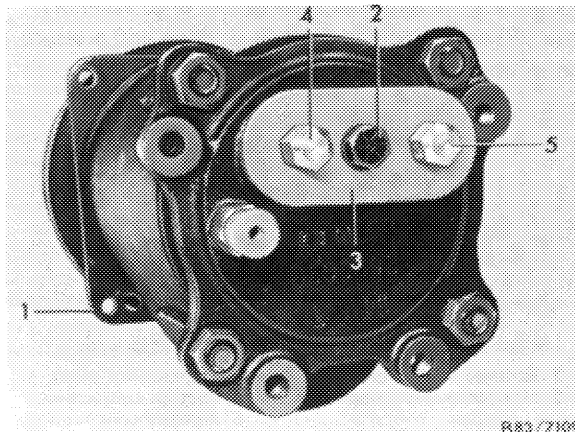
1 Check installed sealing rings (3) on refrigerant compressor (1) for condition, renew if required and provide with refrigerant oil.



Layout O-rings on pressure and suction connection

- 1 Refrigerant compressor
- 2 Carrier
- 3 O-ring
- 4 Suction connection
- 5 Pressure connection

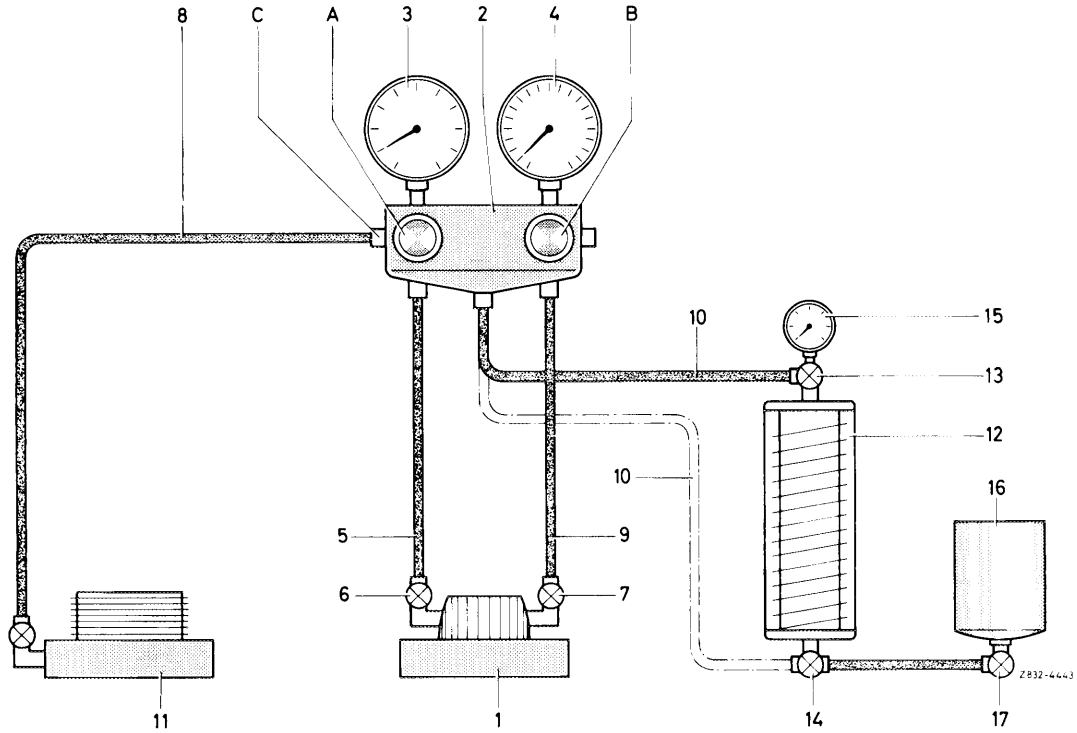
2 Screw pressure test plate (3) with available hex bolt and snap ring (2) to refrigerant compressor (1).



Layout pressure test plate on refrigerant compressor

- 1 Refrigerant compressor
- 2 Hex screw with snap ring
- 3 Pressure test plate
- 4 Suction connection
- 5 Pressure connection

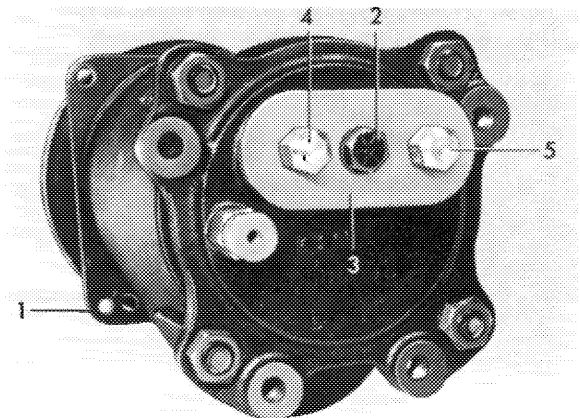
3 Connect hose line (10) to center connection of assembly tester (2) and on valve top (13) of filling cylinder (12).



Assembly tester and filling cylinder with all connections

- | | | |
|-------------------------------------|--------------------------------|---------------------------------|
| A Valve on suction pressure gauge | 4 High-pressure gauge | 10 Hose line |
| B Valve on high-pressure gauge | 5 Hose line | 11 Vacuum pump |
| C Schrader valve on assembly tester | 6 Service valve (suction end) | 12 Filling cylinder |
| 1 Refrigerant compressor | 7 Service valve (pressure end) | 13 Valve top |
| 2 Assembly tester | 8 Hose line | 14 Valve bottom |
| 3 Suction pressure gauge | 9 Hose line | 15 Pressure gauge |
| | | 16 Refrigerant bottle with R 12 |
| | | 17 Valve on refrigerant bottle |

4 Connect the two hose lines (5 and 9) to assembly tester (2) and to Schrader valves (suction and pressure connection) on pressure test plate (3).



Layout pressure test plate on refrigerant compressor

- | | |
|----------------------------|-----------------------|
| 1 Refrigerant compressor | 3 Pressure test plate |
| 2 Hex screw with snap ring | 4 Suction connection |
| | 5 Pressure connection |

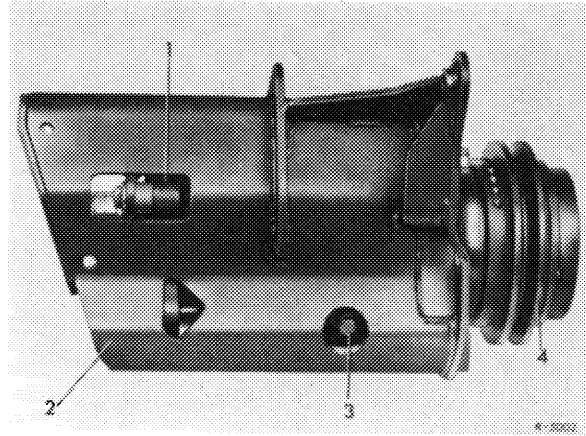
R63/7309

5 With valve (A and B) on assembly tester open, let refrigerant vapor flow into refrigerant compressor. A bottle or filling cylinder pressure of 4 bar gauge pressure is required.

6 Open oil check valve (3) in compressor housing and let air flow out until refrigerant vapors are showing up.

Refrigerant compressor with electromagnetic clutch and carrier

- | | |
|--------------------------|--------------------------|
| 1 Refrigerant compressor | 3 Oil check screw |
| 2 Carrier | 4 Electromagnetic clutch |



7 Screw oil check plug back and permit bottle pressure in refrigerant compressor to stabilize.

8 In installation position of refrigerant compressor (oil pan in downward direction) rotate compressor shaft several times in direction of rotation by hand.

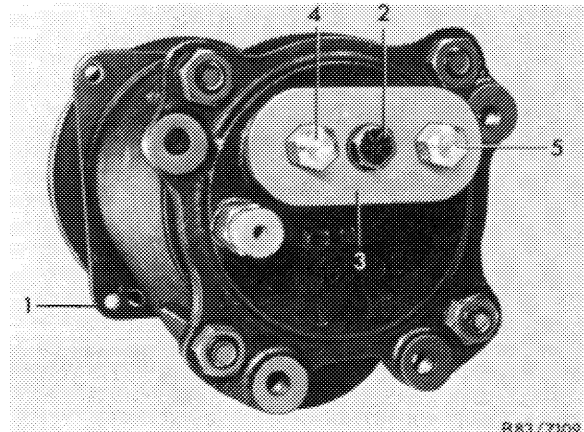
9 Check refrigerant compressor for leaks by means of leak tester.

10 Close valve at top (13) on filling cylinder again and remove hose lines on pressure test plate (3).

11 Unscrew oil check screw and permit cold-flowing oil to drain, if any. Then fill specified quantity of cold-flowing oil into compressor housing (83–520).

Layout pressure test plate on refrigerant compressor

- | |
|----------------------------|
| 1 Refrigerant compressor |
| 2 Hex screw with snap ring |
| 3 Pressure test plate |
| 4 Suction connection |
| 5 Pressure connection |



12 Remove pressure test plate (3) again, but only directly prior to mounting pipe line.