

**Special Tools**

Refrigerant cylinder with R 12	conventional
Gauge set with 3 filling hoses or evacuating and filling equipment for air-conditioning systems	conventional
Pressure test plate	109 589 00 25 00

**Tightening Torque in kpm**

Hex. bolt for pressure test plate on refrigerant compressor	1.7
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**1** Check installed sealing rings (3) on refrigerant compressor (1) for their condition and replace, if required, also add refrigeration oil (Fig. 1).

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

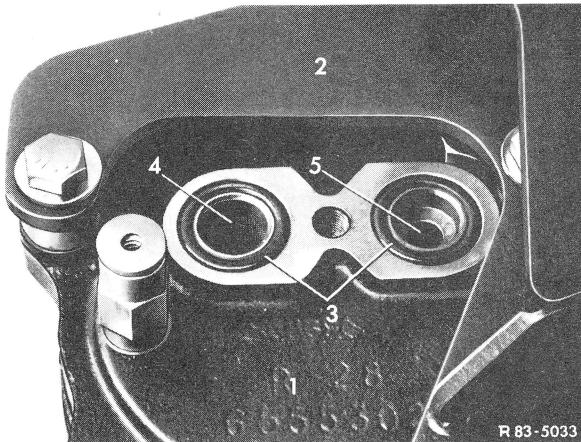


Figure 1

Arrangement of O-rings on discharge and suction connection

1 Refrigerant compressor	4 Suction connection
2 Mounting bracket	5 Discharge connection
3 O-ring	

**3** Connect hose line (10) on center connection of gauge set (2) and on upper valve (13) of filling cylinder (12) (refer to Job No. 83.0-840, Fig. 2).

**4** Connect both hose lines (5 and 9) to gauge set (2) and to Schrader valves (suction and discharge connection) on pressure test plate (3) (refer to Fig. 2 and Job No. 83.0-840, Fig. 2).

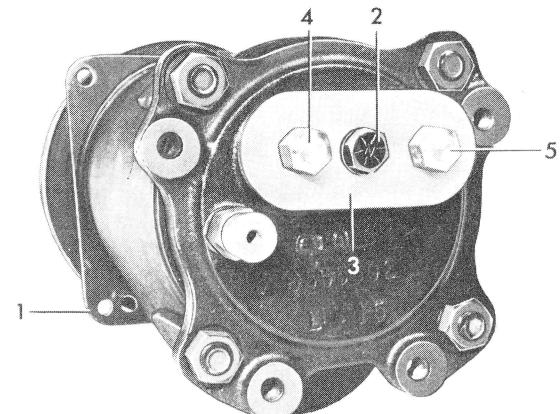


Figure 2

Arrangement of pressure test plate on refrigerant compressor

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

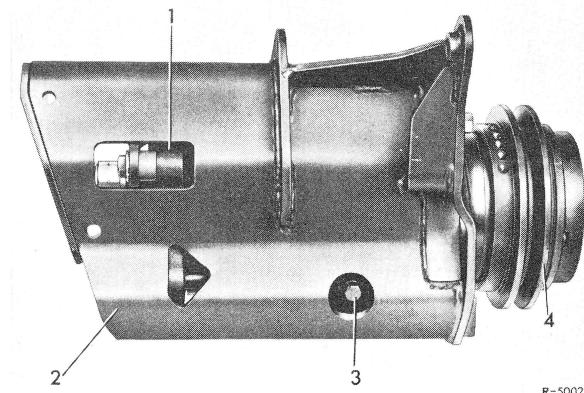


Figure 3 Refrigerant compressor with electro-magnetic clutch and mounting bracket

1 Refrigerant compressor	3 Oil check plug
2 Mounting bracket	4 Electromagnetic clutch



- 5** Permit refrigerant vapor to flow into refrigerant compressor with valve A and B on gauge set opened. A cylinder or filling cylinder pressure above 4 atm is required.
- 6** Open oil check plug (3) in compressor housing and permit air to flow out until refrigerant vapors are coming out (Fig. 3).
- 7** Screw back oil check plug and permit cylinder pressure in refrigerant compressor to stabilize.
- 8** Rotate compressor shaft several times manually in direction of rotation with refrigerant compressor in installation position (oil sump down).
- 9** Check refrigerant compressor for leaks with leak detector.
- 10** Close upper valve (13) on filling cylinder and remove hose line from pressure test plate.
- 11** Unscrew oil check plug and drain any remaining refrigeration oil. Then fill specified quantity of refrigeration oil into compressor housing (refer to Job No. 83.0-870).
- 12** Remove pressure test plate (3) again, immediately prior to installing pipeline.