

## 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
---	-----

- 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).

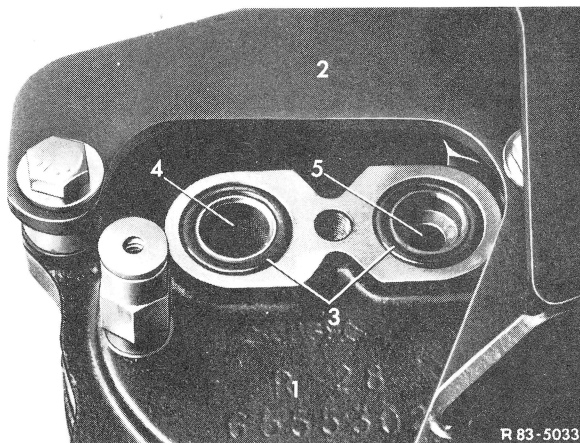
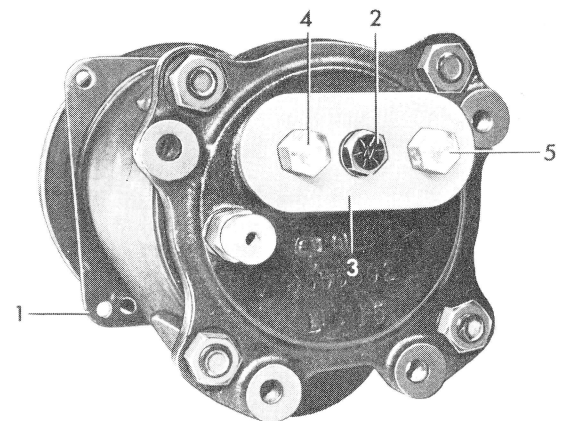


Figure 1  
Arrangement of O-rings on discharge and suction connection

- |                          |                        |
|--------------------------|------------------------|
| 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).

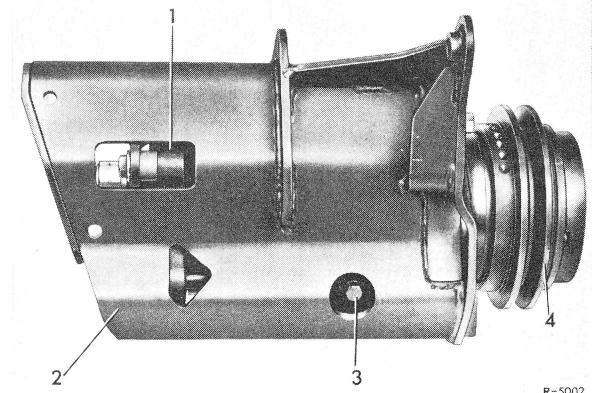
4 Connect both hose lines (5 and 9) to gauge set (2) and to Schrader valves (suction and discharge connection) on pressure test plate (3) (refer to Fig. 2 and Job No. 83.0–840, Fig. 2).



R 83/7109

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



R-5002

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.