



INJECTOR FIXING SCREWS REPAIR KIT M8

Manual

60393500



SAFETY NOTICE

To understand the functioning of the tools, is it necessary to read the manual first!

- > Read these instructions before assembling, during installation and throughout use and in the proper sequence
- > Always refer to the OEM manufacturer's instructions and service manuals for the latest data and to maintain the correct sequence
- > These work instructions and the recommended tools are meant to serve as aides only and are by no means a guarantee for certain results.
- > This tool kit is a special collection and it has been tested and used successfully on several occasions. It is of the utmost importance to maintain the correct procedure as per the instructions
- > The use of the tools should only be carried out by qualified personnel!



ATTENTION

Special caution



CORRECT



LIGHT BULB

Hint or recommendation



WRONG

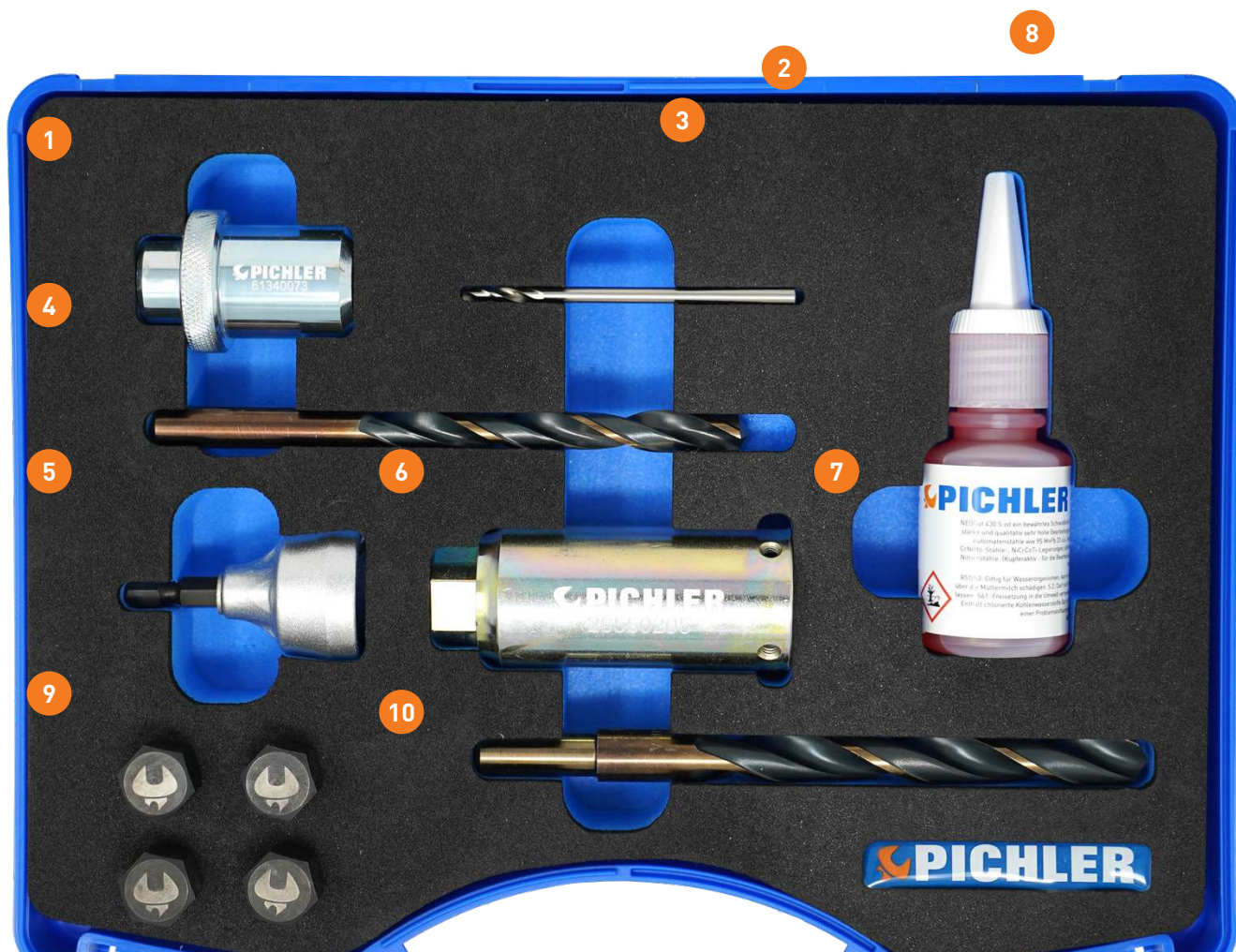


SAFETY GOGGLES

Wearing safety goggles
necessary

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Nr.	PART.-NR.	Description	60393500
1	61340073	Drill guide 3,5 mm	1
2	63800350100	HSS-Eco Hardox drill 3,5 mm	1
3	52520100	Angle Allen key	1
4	20209000	HSS twist drill DIN 338, 9 mm	1
5	30640005	External reamer for bolts from 3,0-19,0 mm with 1/4" drive	1
6	26550205	V-cutter holder size for M8x1.25	1
7	2500800	HSS die round DIN 223, M8	1
8	90417911	Cutting oil 25 ml	1
9	60393511	Spare special nut M8 (PU 1)	4
10	20311500	HSS twist drill 11,5 mm DIN 338 RN	1

I. WORK STEPS

1. PREPARATION

For preparation, dismantle all parts that hinder work, such as plastic cover, wiring harness on valve cover, injection lines, etc.



2. REMOVING THE SCREW HEAD

Position the drill guide [61340073](#) at the hexagon of the screw.



Clamp the Hardox drill $\varnothing$ 3,5mm [63800350100](#) in a drill and pour some cutting oil [90417911](#) into the hole of the drill guide [61340073](#).



Push the clamped Hardox drill $\varnothing$ 3,5 mm **63800350100** through the guide.



Fix the drill guide **61340073** with an open-end wrench SW17 and drill (center) the screw head clockwise.



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After centering, remove the drill guide **61340073**.



Then moisten the Hardox drill Ø 3,5 mm **63800350100** again with cutting oil **90417911** and drill out the center of the screws to a depth of approx. 8 mm.



Use a magnet or other suitable tool to remove the chips.



Clamp the twist drill Ø 9 mm **20209000** in a drilling machine. Moisten the drill bit and the hole on the screw with cutting oil **90417911** and drill out the screw head via the 3.5 mm hole until it is removed.



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3. REMOVING THE RETAINING FORK

Using a magnet or other suitable tool to remove the ball disc and chips.



Remove the retaining fork and the injector and close the injector shaft bore.



TIP

For easy removal of the injector we recommend our injector disassembly tools. See „Recommended accessories“.



4. DRILL OUT THE RETAINING FORK

Clamp the removed holding fork firmly in a vice.

Moisten the twist drill Ø 11,5 mm **20311500** with cutting oil **90417911** and ream the fork in the alignment of the original bore hole.



Use a magnet or other suitable tool to remove the chips.



5. CUT THREAD ON SCREW REST

Clamp the outer deburrer **30640005** in a drill, moisten the remaining screw with cutting oil **90417911** and deburr or chamfer it clockwise.



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Use a magnet or other suitable tool to remove the chips.



Moisten the remaining screw again with cutting oil **90417911**.



Using the thread cutter M8 **2500800**, clamped in the holder **26550205**, cut a thread on the remaining screw until the holder **26550205** contacts the valve cover screws.



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Use a magnet or other suitable tool to remove the chips



6. MOUNT RETAINING FORK

Place the retaining fork and the injector back on the cylinder head.



TIP

In order to mount the injector correctly, the injector shaft should be cleaned beforehand. For this purpose we recommend our cleaning set **9038100**.



Screw the fixing nut M8 **60393511** onto the cut thread on the screw and tighten according to the manufacturer's instructions.



RECOMMENDED ACCESSORIES

REPLACEMENT SPECIAL NUT M8 (PU 1) FOR
INJECTOR HOLDING SCREWS REPAIR KI

60393510



CUTTING OIL 25ML IN DRIP BOTTLE

90417911



HSS DIES ROUND DIN 223 M8

2500800



FLEXIBLE MAGNETIC LIFTER GR. 2 460
MM LONG 500 G 8,0 MM

52601020



INJECTOR SHAFT CLEANING

9038100



BIO-CUT CUTTING OIL 400 ML

99900175



INJECTOR DISASSEMBLY KIT MOD. SOFIM
WITH 20 T. HYDRAULIC CYLINDER

60385345



INJECTOR DISASSEMBLY KIT MOD. UNI
WITH HYDR. HOLLOW PISTON CYLINDER
12 T

60385445



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