

## 83–614 Preparations for vacuum test

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### Data

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Permissible leaks per vacuum circuit (without vacuum reservoir)	30 mbar/min at 400 mbar vacuum
Permissible leaks in check valves	50 mbar in 10 min at 300 mbar vacuum
Permissible leaks in remaining components	20 mbar/min at 300 mbar vacuum
Plug-on length of connections	10 – 12 mm

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### Special tools

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Tester for vacuum systems	116 589 25 2100
Distributor	115 805 03 22

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### Self-made tool

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1 Blind plug	Welding wire 4 mm dia. 40 mm long
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### Note

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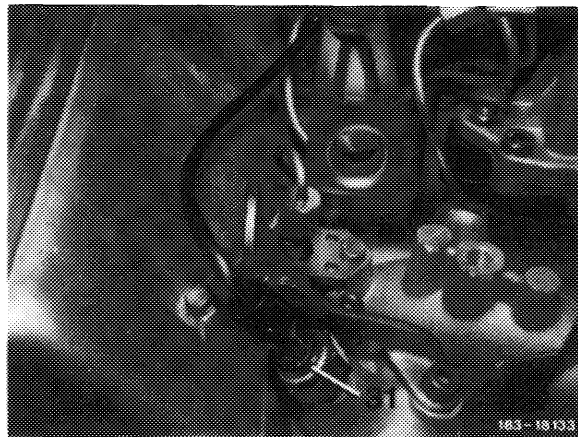
The vacuum system is subdivided into 8 test circuits.  
If a given trouble prevails (e.g. center nozzle not opening) the respective circuit can be tested first.

If a leak or functional trouble is suspected in entire vacuum unit, proceed according to 83–615 and perform each time the first test step (total test) of the individual vacuum circuits until the faulty vacuum circuit is found. Then continue testing the respective circuit until the actual fault is found.

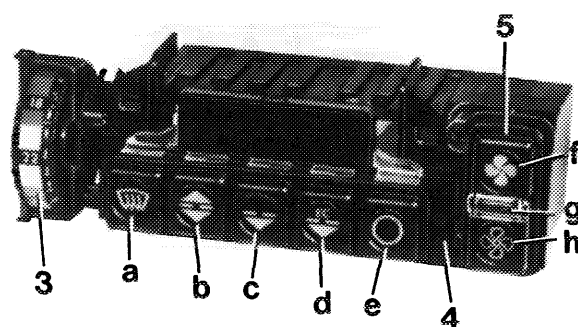
## Preparing for test

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1 Run engine warm to approx. + 60 °C. Cold engine lock (31) is switched off. Then shut off engine again.



2 Push function selection button "d".



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