

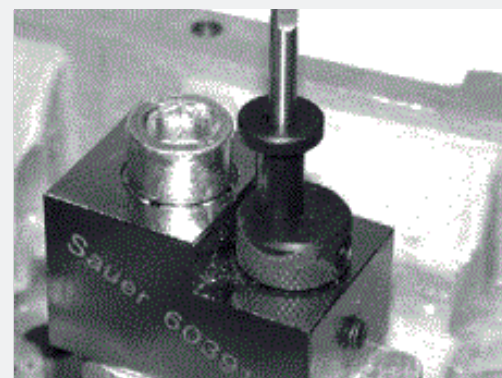
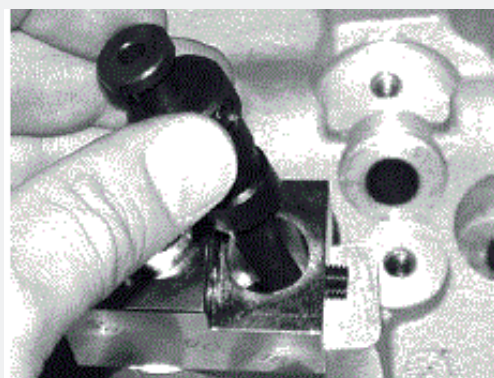
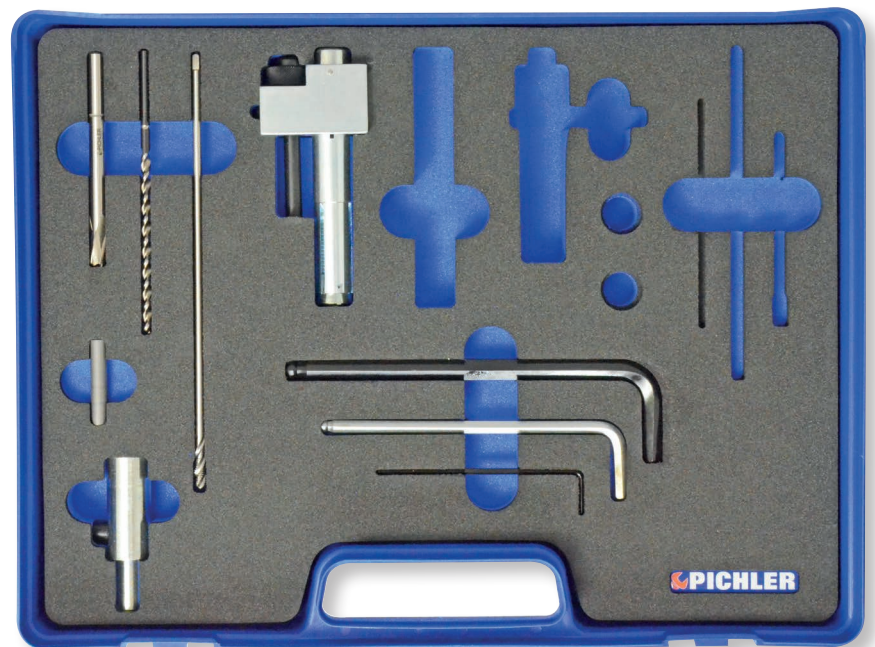


Manual

# CDI Injector Holding Screw Drilling Out Kit

M6x1 MB CDI

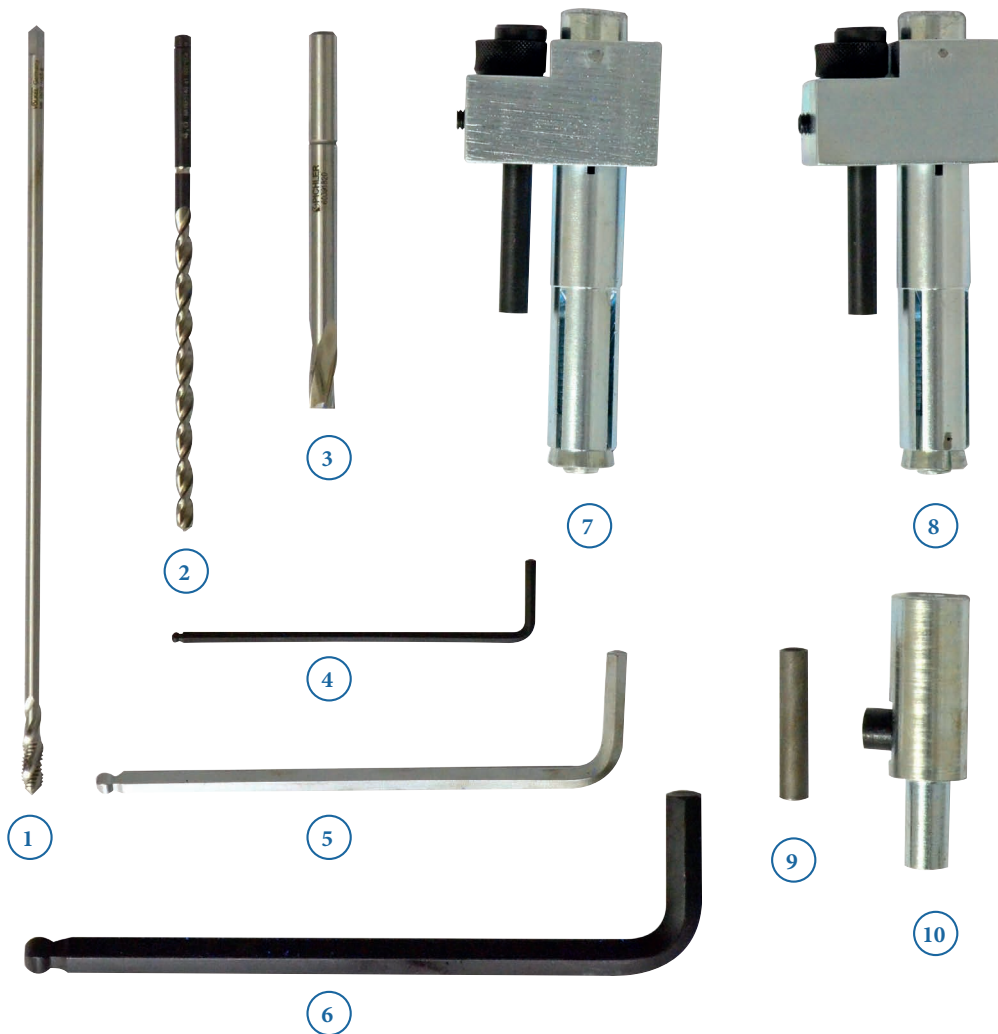
Art.-Nr. 60391800 - 60391805 - 60392000 - 60393000





# CDI Injector Holding Screw Drilling Out Kit

## M6 x 1 MB



	Article no.	Description	60391800	60391805	60392000	60393000
①	60418255	Tap M6x1,0x200 mm with Indentation	1x	-	1x	1x
②	20604800	VA HSS E Drill Ø 4,8 mm with Indentation	1x	-	1x	1x
③	60391820	End Milling Cutter HSS-E 3 Edges, Ø 8 mm	1x	-	1x	1x
④	151.2103	Hex Key 3mm with Ball End	1x	-	1x	1x
⑤	151.2106	Hex Key 6mm with Ball End	-	1x	1x	1x
⑥	151.2110	Hex Key 10mm with Ball End	1x	-	1x	-
⑦	60391810	Drilling Out Holder with Excenter- and Drill Guide	1x	-	1x	-
⑧	60393001	Drilling Out Holder with Excenter- and Drill Guide	-	-	-	1x
⑨	60391801	Drilling Out Sleeve M6	1x	-	1x	1x
⑩	60392001	Drilling Out Holder with Drill Guide	-	1x	1x	-

## CDI Injector Holding Screw Drilling Out Kit M6x1 MB CDI

### Injector Holding Screw Drilling Out Kits

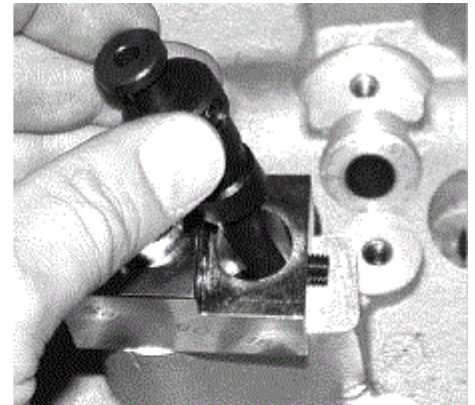
CDI (except A-class)	603 91 800
A-class (supplement kit)	603 91 805
CDI incl. A-class	603 92 000
MBPI	603 93 000
MBPI (supplement kit)	603 93 002

### Manual (except A-class):

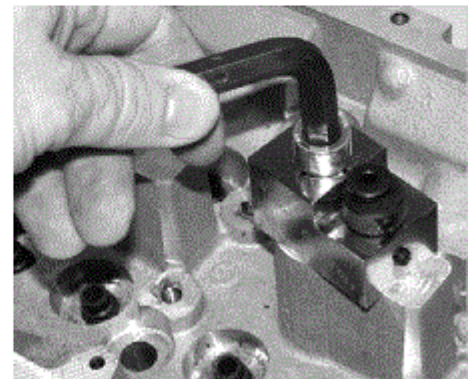
1. Prepare the vehicle; remove injectors and valve cover..
2. Close the injector bore to the combustion chamber.
3. Cover the work area around the injector shaft generously. Clean the injector shaft, injector sealing face and injector shaft face thoroughly.
4. Place the guiding block with collet into the injector shaft of the cylinder to be repaired and pretension it slightly by the turning the Allen screw (10mm). (The stepped side of the guiding block faces upward.).



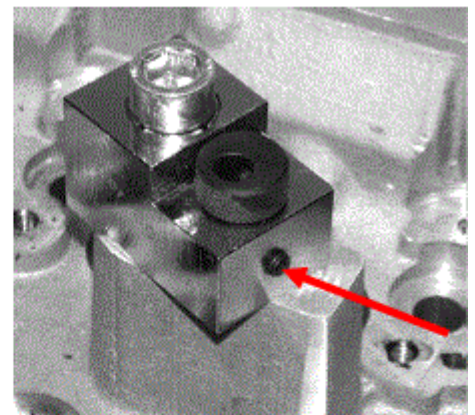
5. Place the black excenter sleeve and drill guide into the guiding block and turn it until the drill guide slides into the holding screw hole of the cylinder head.



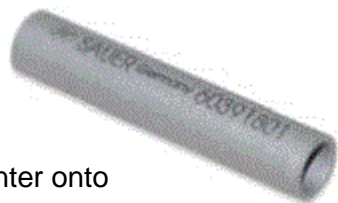
6. Tighten the holding screw of the guiding block.



7. Tighten the Allen screw that fixes the excenter. Remove the drill guide from the excenter.

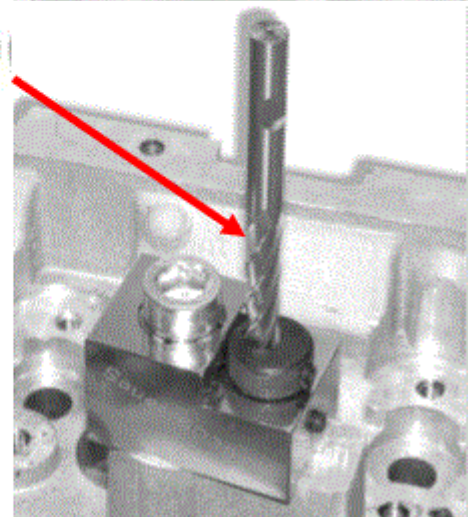


**Attention! Grease the milling cutter!**

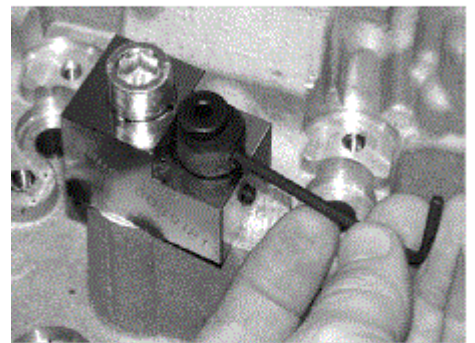
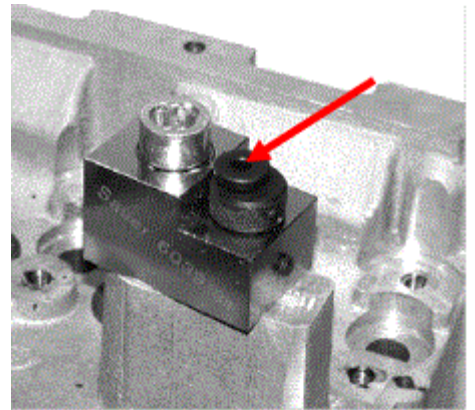


8. Slide the drilling out sleeve through the excenter onto the rest of the bolt.
9. (The sleeve serves for centering only and is drilled out also during the drilling out procedure)

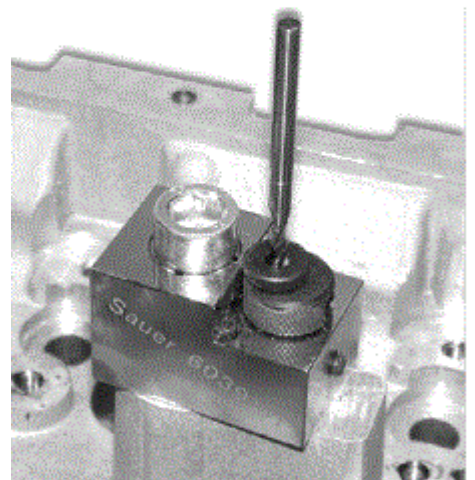
Cut by means of the 8 mm end milling cutter, guided by the excenter the part of the broken off screw above the thread until the indentation on the cutter (depth ca. 71 mm) is reached. Do not attempt in one go and remove the chips regularly. Remove the drill and drill guide and clean the hole.



10. Place the drill guide until it stops in the excenter and fix it by means of the Allen screw in the excenter.

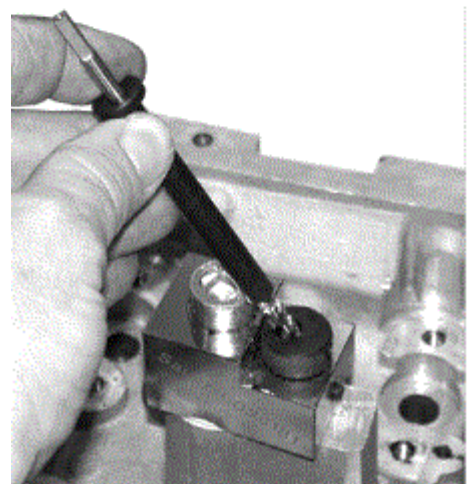


11. Bore out the remains of the broken off screw with the 4.8 mm drill (with indentation), guided by the drill guide, until it reaches the indentation (depth 95 mm). Again do not attempt in one go and remove the chips regularly. Remove the drill and drill guide and clean the hole.

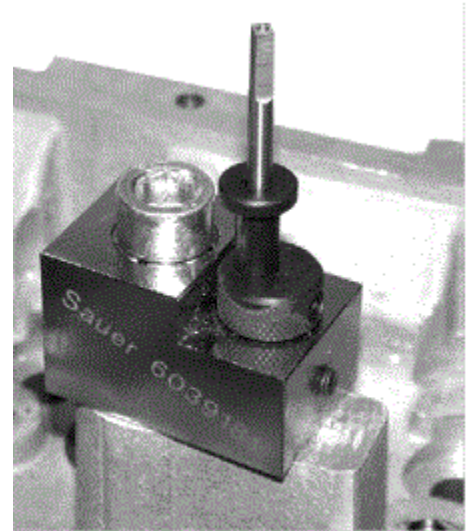


12. Place the tap in the drill sleeve (MBPI; 60418255!).

**Attention! Do not fix the sleeve in the excenter!**

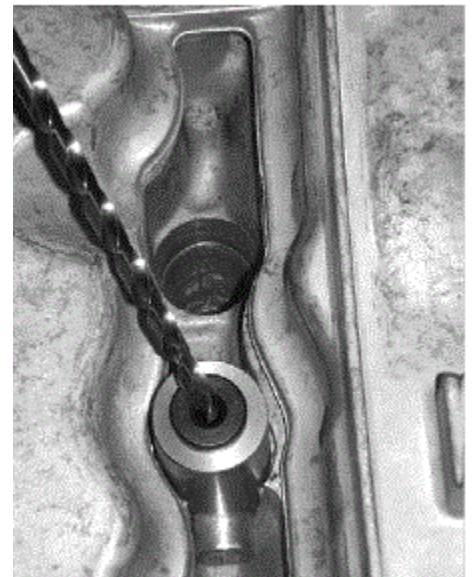


13. Place the combination in the excenter (the sleeve guides the tap) and re-cut the thread.
14. Remove the tools and clean the thread. Check with a new holding screw for play. If the play is too big, the thread has to be renewed by means of a thread repair kit such as 604 17 800.



#### **Guide to supplement kit 603 91 805 for A-class CDI**

1. Place the Drilling Out Holder (see figure) and cut by means of the 8 mm end milling cutter until the indentation on the cutter the broken off screw. Do not attempt to do all in one go and remove the chips regularly. Remove the drill and drill guide and clean the hole.
2. Place the Drill Guide in the Drilling Out Holder and drill out the remains of the broken off screw with the 4,8 mm drill until it reaches the indentation. Again do not attempt to do all in one go and remove the chips regularly.
3. Clean with the Tap the thread in the shaft using the Drill Guide and Drilling Out Holder. Check the thread with a new holding screw for play. If the play is too big, the thread can be renewed by means of a thread repair kit such as 604 17 800.



#### **Other required or recommended tools**

Drill or angle drill	820 03 000
Hydraulic injector extractor	603 84 000
Cleaning & cutting tool injector shaft	903 90 305
Thread repair kit M6x1.0	604 17 800



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