

## Assembly instructions for the initial VOSS leak-off rail assembly

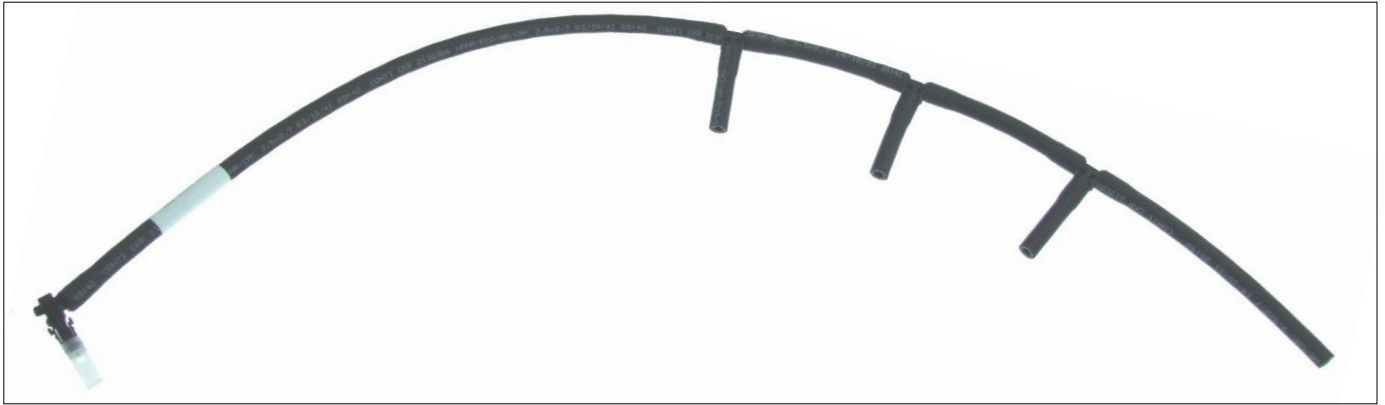


Fig. 1: VOSS leak-off rail 5 4 76 00 44 00



Fig. 2: Plug of quick connect system 250 with attached protective cap



Fig. 3: Plug of quick connect system 250 with detached protective cap

These assembly instructions are intended for qualified fitters of fuel systems in automotive engineering.

Before the assembly of the leak-off rail, check the connecting port of the pump and the four injector connections. The connections must be clean and should not show any signs of damage.

The assembly must be carried out at room temperature ( $23^{\circ}\text{C} \pm 5^{\circ}\text{C}$ ). All components must have room temperature.

Before pushing-in the elbow plug of VOSS quick connect system 250, the protective cap has to be detached, see figs. 2 and 3.

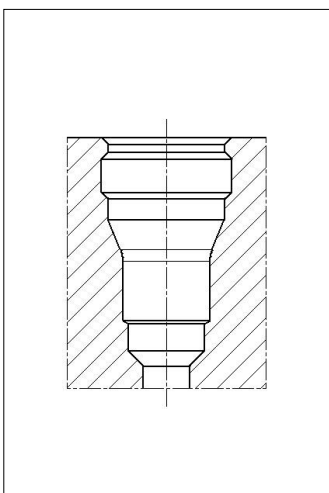


Fig. 4: Connecting port for the elbow plug of quick connect system 250

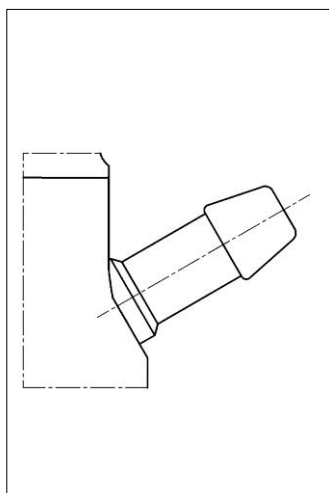


Fig. 5: Injector connection for hose ends

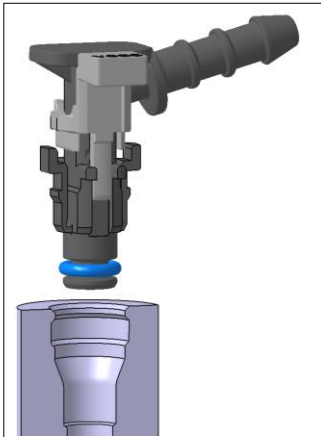


Fig. 6: Plug and port in the initial position

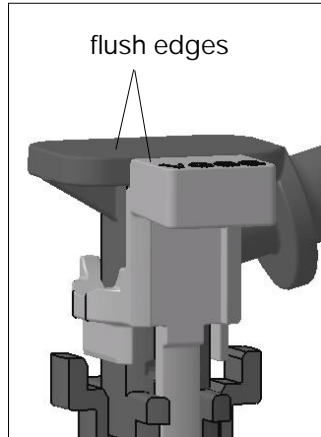


Fig. 7: The locking element is flush with the plug's top edge

While inserting the plug, the locking element has to be flush with the plug's top edge (locking element not pressed down, figs. 6 and 7).

At first the plug has to be pushed down to the limit stop of the plug collar into the bore-hole of the connecting port (figs. 4 and 8).

Pressing down the locking element secures the connection (fig. 9).

Then the hose is being mounted in holding clips 1 and 2 (fig. 10).

The pushing-in of the elbow plug of quick connect system 250 and the mounting of the hose in holding clips 1 and 2 must be carried out without interruption.

Subsequently the four open hose ends are being mounted without damage onto the injectors A-D (figs. 5 and 10). If required, the hose is being fixed with a clamp.

Then the hose is being mounted in holding clips 3 and 4 (fig. 10).

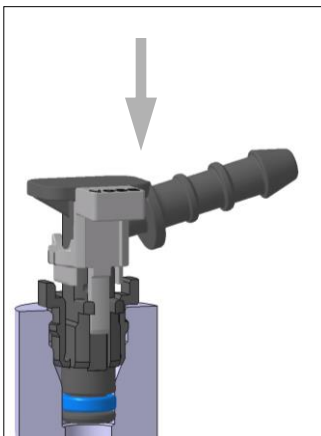


Fig. 8: Pushing the plug into the connecting port

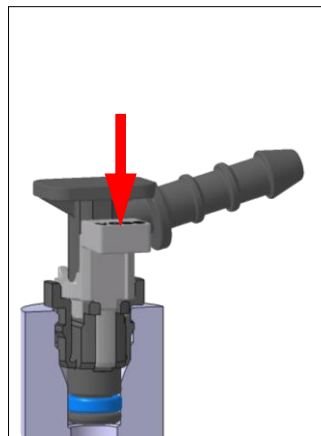


Fig. 9: Locking the plug

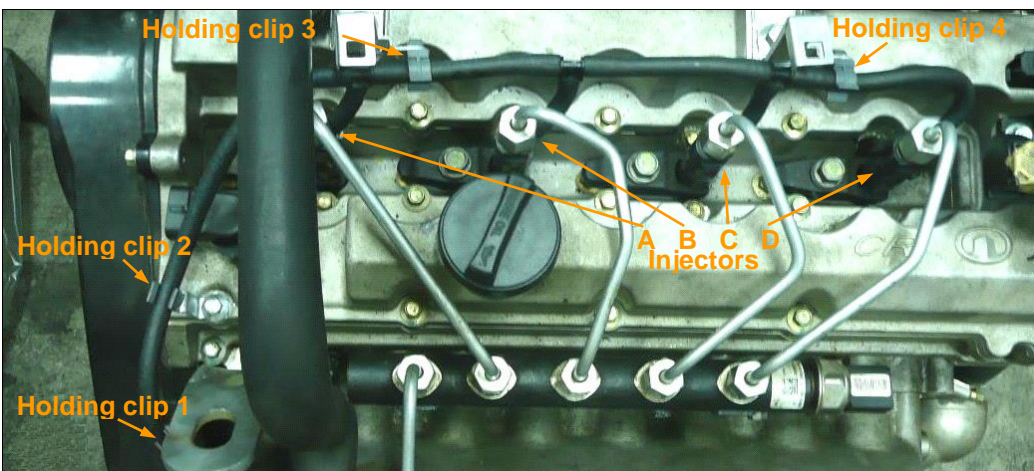


Fig. 10: Assembly situation