



# TA 1400-0162

Technical Instruction

## Spark plug adjustment tool for plugs with hook electrodes



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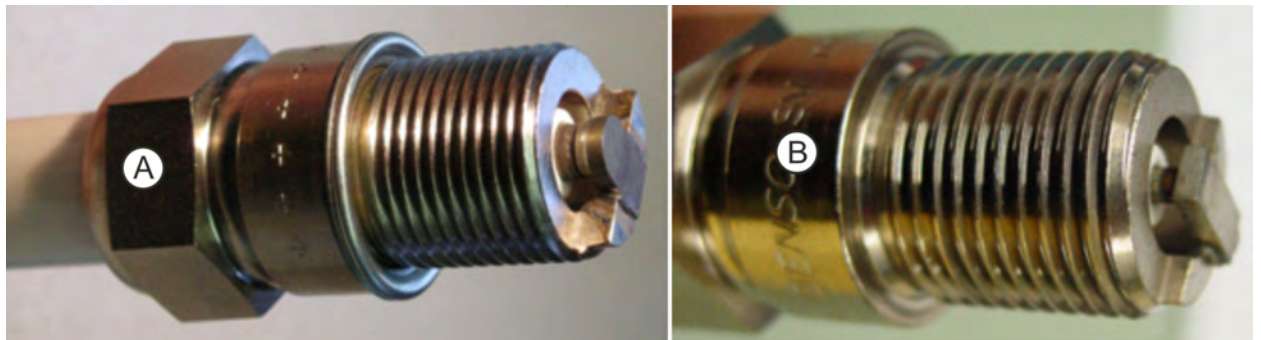
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## 1 Scope

This Technical Instruction applies to all spark plugs with hook electrodes used in INNIO Jenbacher GmbH & Co OG Type 6 and 9 engines (e.g. P603 or Denso 518).



Ⓐ P603 spark plug

Ⓑ 518 spark plug

## 2 Purpose

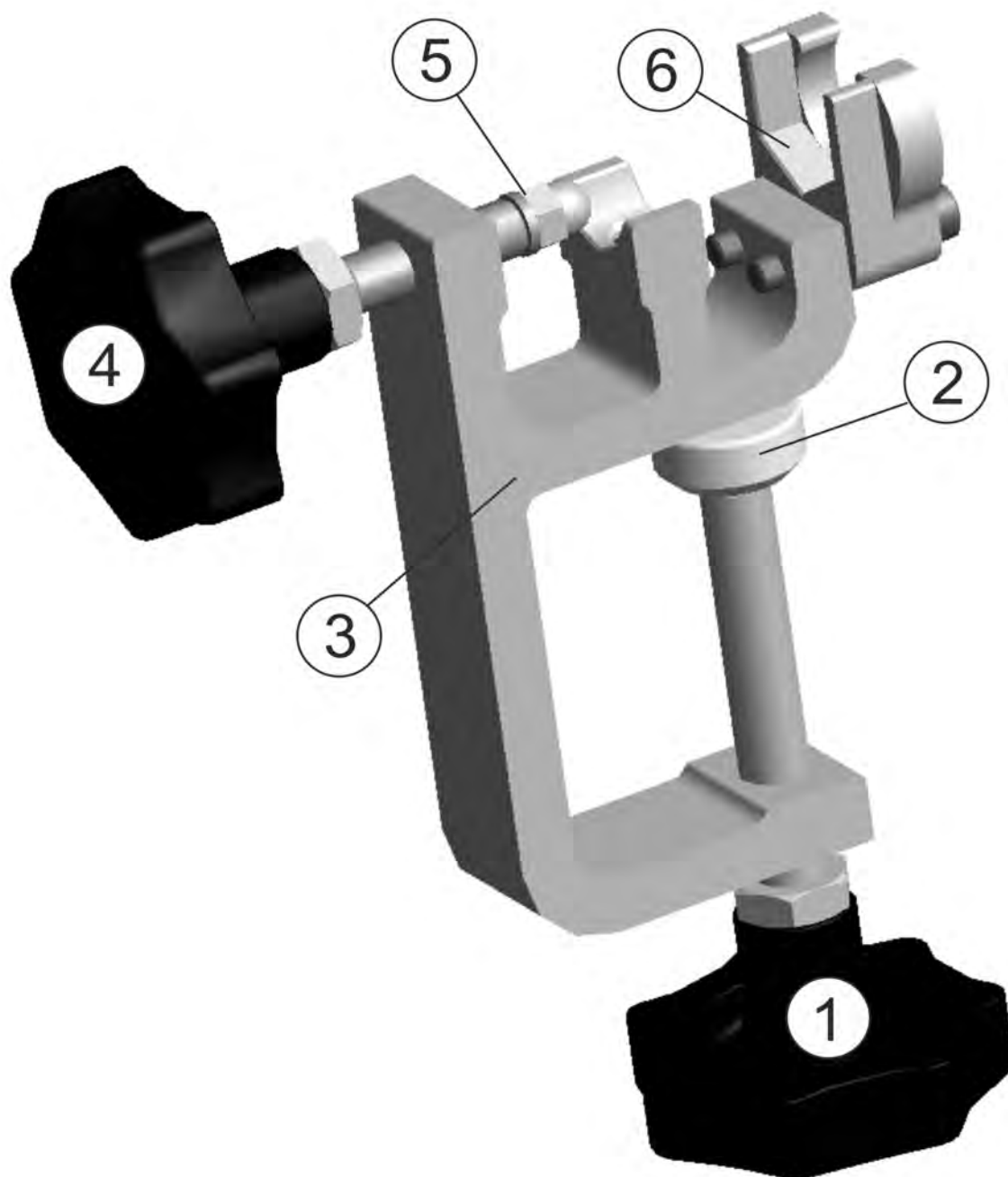
This Technical Instruction describes how to correctly adjust spark plugs with hook electrodes.

## 3 Personal Protective Equipment

Wear your personal protective equipment when adjusting spark plugs. This includes:

- Safety glasses
- Safety shoes
- Gloves

## 4 Tool design

*Spark plug adjustment tool part no. 9011882*

① Hand wheel for securing the tool	④ Hand wheel for adjusting the electrode gap
② Clamp for the tool base	⑤ Adjustment pin
③ Tool base	⑥ Recess for spark plug hexagon

## 5 Operation

### 5.1 Preparing the tool

The tool must be securely mounted on a bench or other stable work surface before being used to adjust spark plugs. If the spark plug has to be adjusted in situ on the engine, the Type 6 is fitted with a upper step plate near the cylinder heads.

To secure the tool to a stable work surface, first undo the clamp ② with the hand wheel ① until the clamp can fit over the work surface. As soon as the tool base ③ is seated and stable on the work surface, secure the tool with the hand wheel ①.



### 5.2 Adjusting the electrode gap

#### 5.2.1 Preparing the spark plug

Before placing the spark plug in the tool, remove the joint ring on the plug.



© Sealing ring

### 5.2.2 Placing the spark plug in the tool

Before the spark plug is placed in the tool, check whether it is damaged in any way and whether enough precious metal remains to allow continued use. If there is any damage or insufficient electrode material, dispose of the spark plug.

To place the spark plug in the tool, first retract the adjustment pin ⑤ by turning the hand wheel ④ anticlockwise until the spark plug can be carefully placed in the recess for the hexagon ⑥. Do not damage the ceramic body of the spark plug. The electrodes of the spark plug will be pointing towards the adjustment pin and the electrode gap must remain easily accessible. Hold the spark plug with a magnet from underneath to prevent it tilting.



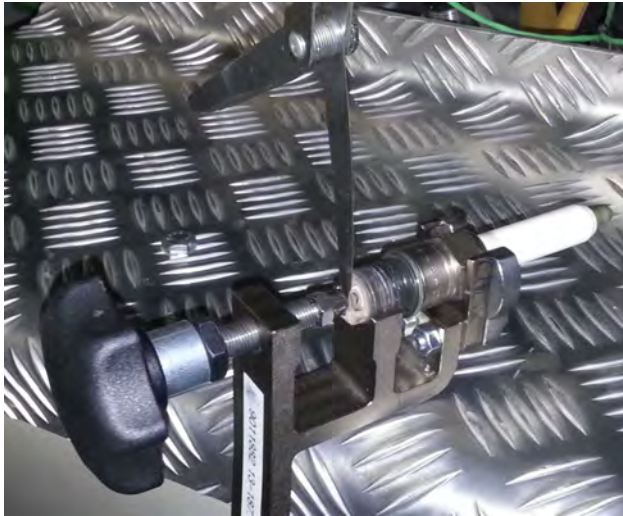
### 5.2.3 Adjusting the electrode gap

Slide a feeler gauge with a 0.28 mm gap between the electrode and turn the hand wheel ④ clockwise until the feeler gauge jams. The important point here is to hold the feeler gauge so that this pressure on it can be felt, which is best done by moving the feeler gauge slightly. Then turn the hand wheel back slightly to relieve the load on the electrode carrier and check the adjusted electrode gap. This should be between 0.28 mm and 0.32 mm.

If the electrode gap is still incorrectly set, repeat the adjustment process.

**Never exert any uncontrolled pressure on the centre electrode, as excessive force will damage the spark plug.**





#### 5.2.4 Removing the spark plug from the tool

To remove the spark plug retract the adjustment pin ⑤ by turning the hand wheel anticlockwise until the plug can be removed from the tool. Take care to ensure that the ceramic body of the spark plug is not damaged.

#### 5.2.5 Fitting a new joint ring

Fit a new joint ring to the spark plug immediately after setting the electrode gap. Do not forget this under any circumstances.

## 6 Revision code

### Revision history

Index	Date	Description / Revision summary	Expert Auditor
4	11.04.2019	GE durch INNIO ersetzt / GE replaced by INNIO	<b>Opoku</b> <i>Pichler R.</i>
3	22.01.2015	Anwendungsbereich und Zweck neu hinzu. Tlnr. des Nachstellwerkzeuges angeführt / new section scope / purpose and part number of spark plugs adjustment tool	<b>Bilek</b> <i>Kraus Markus</i>
2	29.01.2014	Grundlegende Überarbeitung / Fundamental revision	<b>Bilek</b> <i>Kraus Markus</i>
1	29.08.2012	Erstausgabe / First release Grundlegende Überarbeitung / Fundamental revision	<b>Bilek</b> <i>Kraus Markus</i>