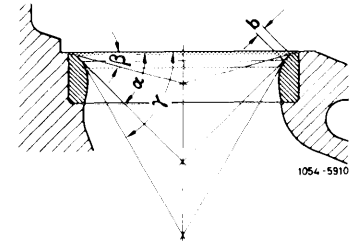
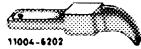



Data	Intake	Exhaust
Valve seat width b	1.3-2.0	1.5-2.0
Valve seat angle α	45°	
Correction angle top β	15°	
Correction angle bottom γ	60°	
Permissible runout of valve seat	0.04	



Special tools

Magnetic finger for valve cone halves		116 589 06 63 00
Plug gauge 9 mm dia.		117 589 03 23 00

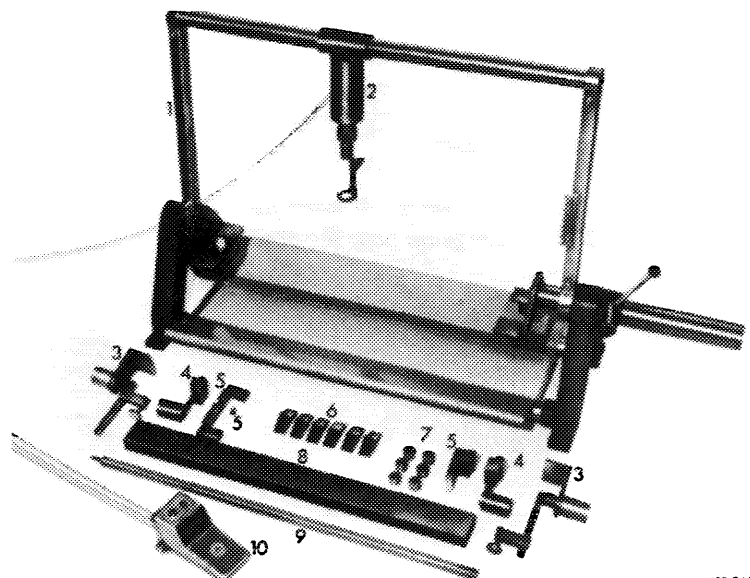
Conventional tools

Cylinder head clamping device	e.g. Rothenberger, D-6233 Kelkheim
Valve seat turning tool	e.g. Hunger, D-8000 München Type VDSNL 1/45/30, order No. 236.03.308
Test set for valve seats	e.g. Hunger, D-8000 München Order No. 216.93.300
60° correction tool No. 13 for correction angle bottom	e.g. Hunger, D-8000 München Order No. 216.64 622

Note

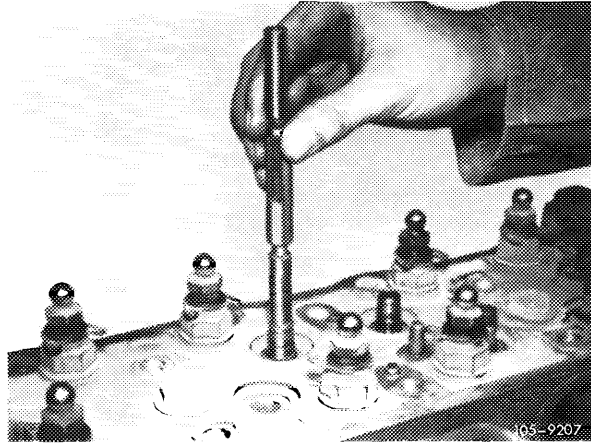
Clamp cylinder head into clamping device for disassembling and machining.

Machine valve seats with valve seat turning tool, with valve seat grinder or with valve seat cutter.



Machining valve seats

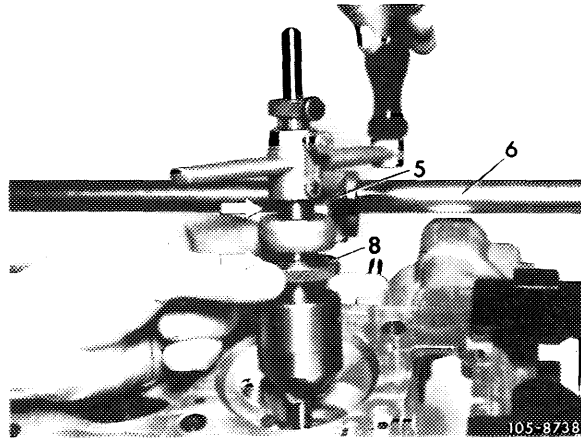
1 Check valve guides and replace if required (05-285).



2 Machine valve seats (see operating instructions of machine tool manufacturer).

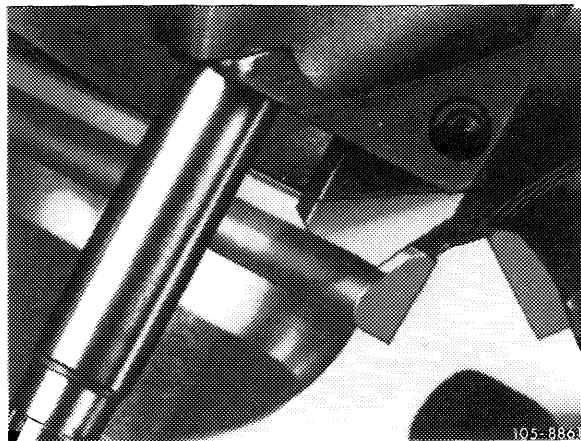
Caution!

Loosen pilot only after the runout of the valve seat has been checked (item 3).



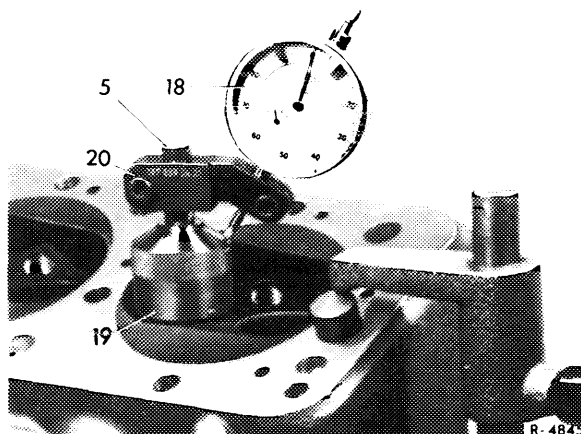
Caution!

Do not turn down the bead at the lower end of the valve seat.



3 Check runout of valve seat.

For this purpose, slide test sleeve (19) with dial gauge holder (20) and dial gauge onto the pilot (5).



- 5 Pilot
- 18 Dial gauge
- 19 Test sleeve
- 20 Dial gauge holder

4 Measure valve seat width „b“ and correct at top with 15° and at bottom with 60° if required.

When machining with the Hunger turning tool, use the 60° correction steel No. 13 for the lower valve seat correction.

5 Observe valve springs and valve spring preload (05–260).

