

01-418 Facing cylinder head mating surface

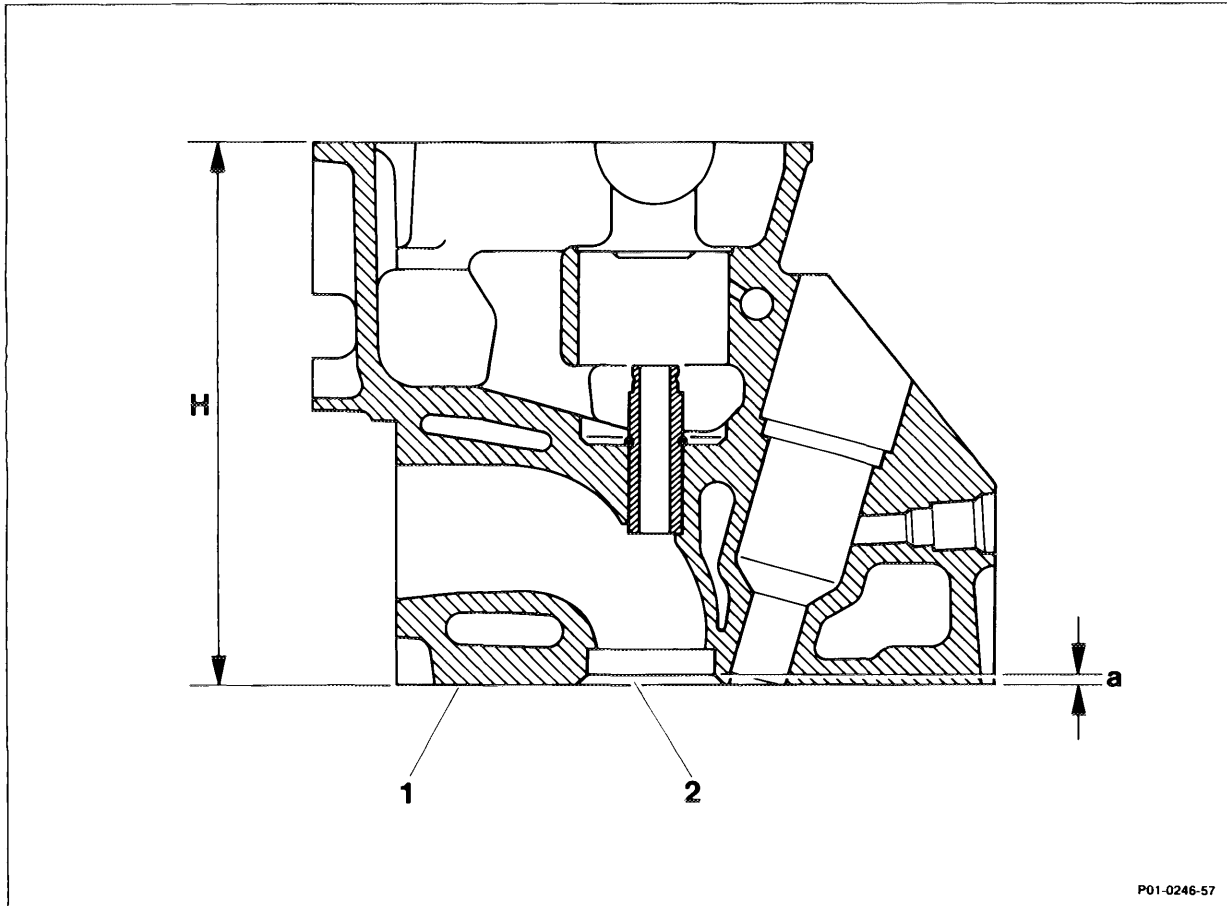
Preliminary operations:

Valves removed.

Valve guides checked (05-285).

Prechambers removed (01-417).

Cylinder head pressure-tested (01-420).



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Mating surface (1) plane according to operating instructions of tool manufacturer.

Note

Observe permissible minimum height (H) and machining data.

Valve seats (2) refinish until minimum interval (a) is reached (05-291).

After assembly check engine timing (05-215).

Data

Total height of cylinder head in mm ¹⁾		142.9 – 143.1
Minimum height (H) after machining in mm		142.4
Material removal per facing operation in mm		0.5
Permissible unevenness of mating surface in mm	in longitudinal direction	0.08
	in transverse direction	0.0
Permissible deviation in parallel of upper mating surface in relation to lower surface in longitudinal direction in mm		0.1
Roughness in mm		0.004
Test pressure with air under water in bars gauge pressure in mm		2
Minimum distance (a) (recess) with new valves and new valve seats in mm	Intake	- 0.1 to - 1.0
	Exhaust	
Max. distance (a) (recess) with new valves and machined valve seats in mm	Intake	- 1.0
	Exhaust	

1) It is not permissible to machine the upper mating surface of the cylinder head.

Commercially available tools

Cylinder head clamping fixture	e.g.	Hunger, D-8000 München 70 Order No. 211.60.000
Valve seat machining tool, model VDSNL 1/45/30	e.g.	Hunger, D-8000 München 70 Order No.
Testing set for valve seats	e.g.	Hunger, D-8000 München 70 Order No. 216.93.300
65° correction blade No. 13 for bottom correction angle	e.g.	Hunger, D-8000 München 70 Order No. 216.64.622