

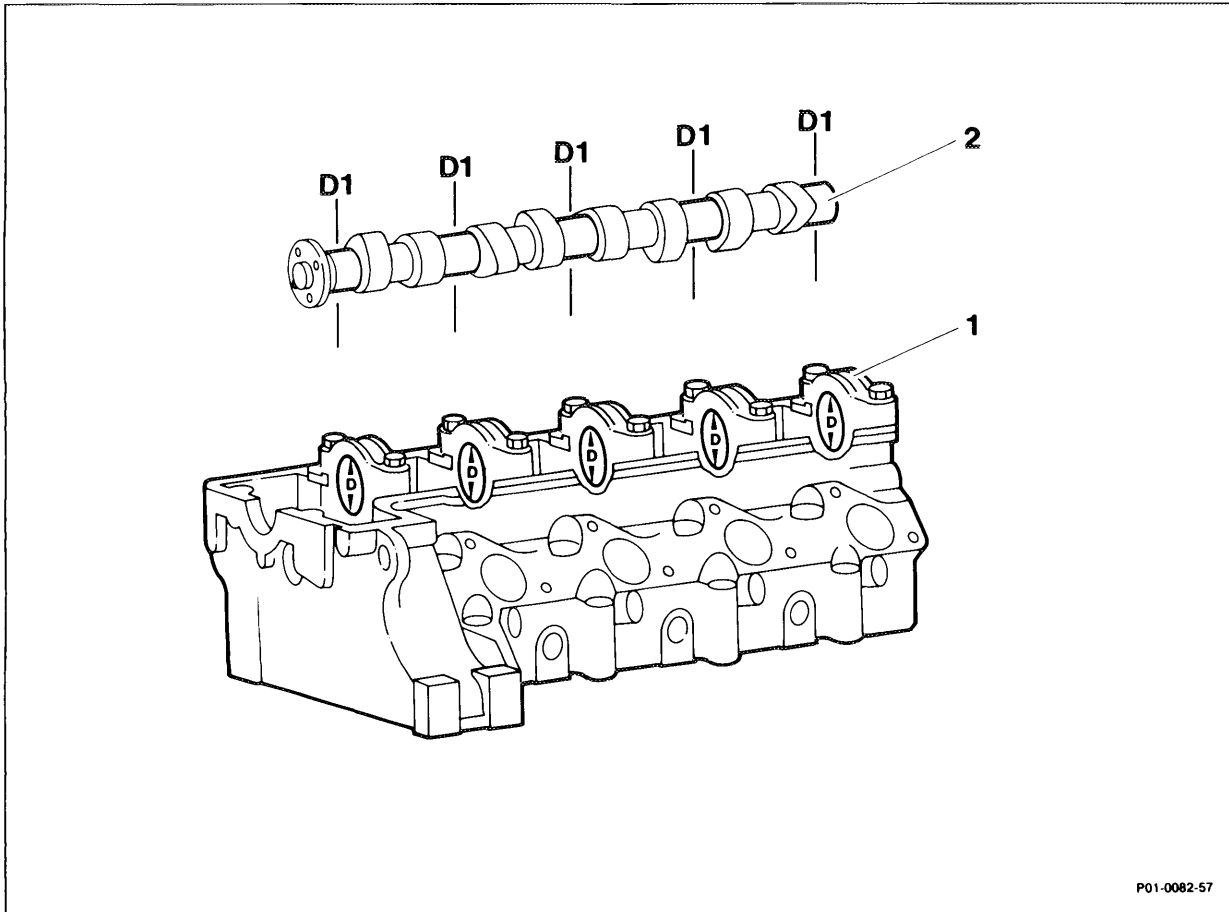
01-419 Boring out camshaft bearing bores (repair stage)

Preliminary operations:

Cylinder head removed (01-415).

Camshaft removed (05-220).

Valves removed.



P01-0082-57

Camshaft bearing caps (1) remove, install, 25 Nm.

Camshaft bearing basic bores (D) measure.

Note

It is only possible to rebores the camshaft bearing bores once to max. 0.5 mm oversize. Observe repair stage dimensions.

Camshaft bearing basic bores (D) bore out according to operating instructions for tool used.

Caution!

When boring ensure that the mating surface at the rear of the cylinder head cover and the mount for the sealing plate at the front are not damaged.

After boring remove burrs on mating surfaces of camshaft bearing caps (1) and mating surfaces on cylinder head.

Note

Edges with burrs can lead to poor lubrication during engine operation resulting in bearing damage.

Install new camshaft (2) with oversize bearing journals (D1), code for oversize camshaft (05-215 or 05-220).

Data, camshaft bearings

Standard dimension	Camshaft bearing diameter D	30.95 – 31.04	
	Journal diameter D1	29.934 – 30.95	
Repair stage	Camshaft bearing diameter D	31.45 – 31.54	
	Journal diameter D1	31.434 – 31.45	
Camshaft bearing bores	Roughness	0.003 – 0.006	
	Permissible out-of-round	0,012	
		New value	Wear limit
Bearing play	radial	0.050 – 0.091	0.15
	axial	0.030 – 0.100	0.15

Note

If bearings have seized or are scored deeply, the camshaft bearings in the cylinder head can only be rebored once to a maximum of 0.5 mm oversize. After reboring replace damaged camshaft with new camshaft with oversize bearing journals.

Special tool

