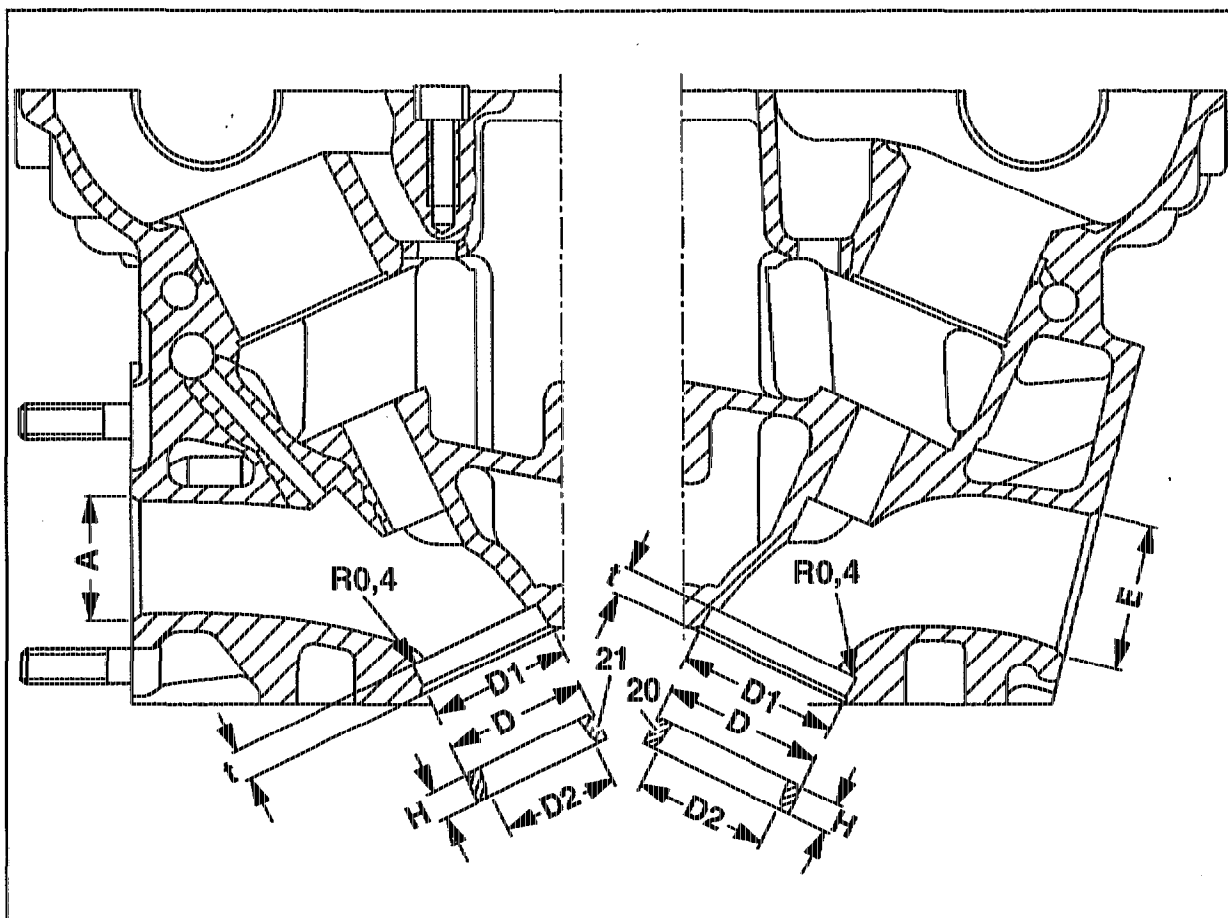


05-2900 Replacing valve seat rings

Preceding work:
Valve guides examined (05-2845)

Operation no. of operation texts and work units or standard texts
and flat rates:



P05-5500-57

Valve seat rings (20 and 21)	remove with ring seat turning tool.
Operating instructions of tool manufacturer	observe.
Basic bore diameter (D1)	measure with internal measuring instrument.
Valve seat rings (standard size or repair size) ...	select according to overlap.
If repair size	machine basic bore.
If repair size, seat ring bore matching valve seat ring	pay attention to overlap.
Valve seat ring	cool with liquid nitrogen and insert with a suitable drift.
Valve seats	machine (05-2910).

Data in mm

Bore of valve seat ring		Inlet	Exhaust
D1	cylinder head standard size	36 H6	32 H6
D	valve seat ring standard size	36.1 to 36.12	32.1 to 32.12
Repair size			
D1	cylinder head repair size	37.2 H6	33.2 H6
D	valve seat ring repair size	37.3	32.3
t		5.6 to 5.9	
D2		30	25.6

Commercially available tools

Cylinder head clamping device	e. g.	Hunger 81375 München Order no. 221.60.000
Ring seat turning tool	e. g.	Hunger 81375 München size 2, order no. 220.03.110
Valve seat turning tool (size 2)	e. g.	Hunger 81375 München Model VDSN 1/45/30 Order no. 236.03.308
Inspection set for valve seats	e. g.	Hunger 81375 München Order no. 216.93.300
Internal measuring instrument (range 35 – 100 mm)	e. g.	Mahr, 73730 Esslingen Order no. 844 N
External micrometer (range 25 – 50 mm)	e. g.	Mahr, 73730 Esslingen Order no. 40 S H