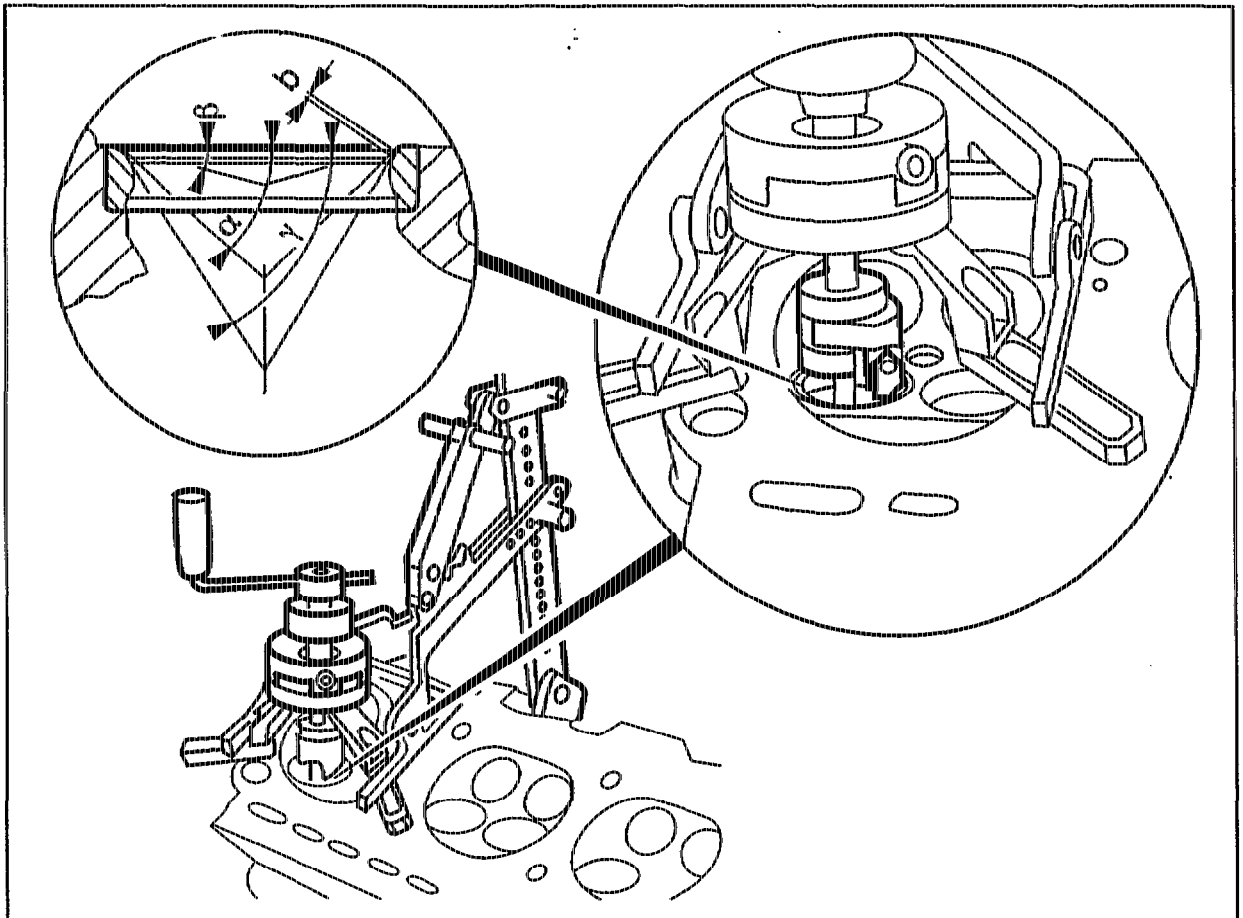


05-2910 Machining valve seat rings

Preceding work:
Valve guides inspected (05-2845)

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



P05-5456-57

Valve seats machine.

Note

Pay attention to operating instructions of tool manufacturer.

Use *SERDI* shape turning tool number 41196.

Use Hunger turning tool number 23m or 24m.

Dimensions maintain as stated in table.

Leaktightness check with valve installed.

Valve seat width (b) measure.

Note

If necessary, correct valve seat width (b) with correction angles (Hunger) 23m and 24m (angles α and β).

Valves insert and measure clearance from valve stem end to camshaft bearing base (see 01-480).

Data	Inlet valve, exhaust valve
Valve seat width (b)	0.90 – 1.10 mm
Valve seat angle (α)	45°
Correction angle at top (β)	30°
Correction angle at bottom (γ)	60°
Permissible radial runout of valve seat	0.03 mm

Commercially available tools

Valve seat turning tool	e. g.	SERDI GmbH Bregenzstr. 69 88131 Lindau
Shape turning tool	e. g.	SERDI GmbH Bregenzstr. 69 88131 Lindau Order no. 41196
Cylinder head clamping device	e. g.	Hunger 81375 München 70 Order no. 221.60.000
Valve seat turning tool	e. g.	Hunger 81375 München 70 Model VSDN 1/45/30 Order no. 236.03.308
Test set for valve seats	e. g.	Hunger 81375 München 70 Order no. 216.93.300
Turning tools for valve seat and correction angles (β) and (γ) 23m 24m	e. g.	Hunger 81375 München 70 Order no. 216.64.235 Order no. 216.62.170