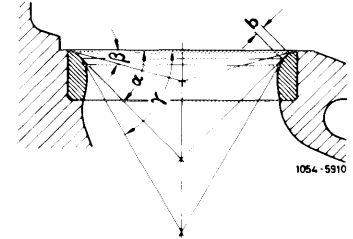
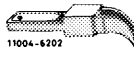
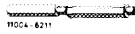


05-291 Machining valve seat

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 lift for valve cone half		116 589 06 63 00
Plug gauge 9 mm dia. for intake valve guides		117 589 03 23 00
Plug gauge 11 mm dia. for exhaust valve guides		117 589 04 23 00

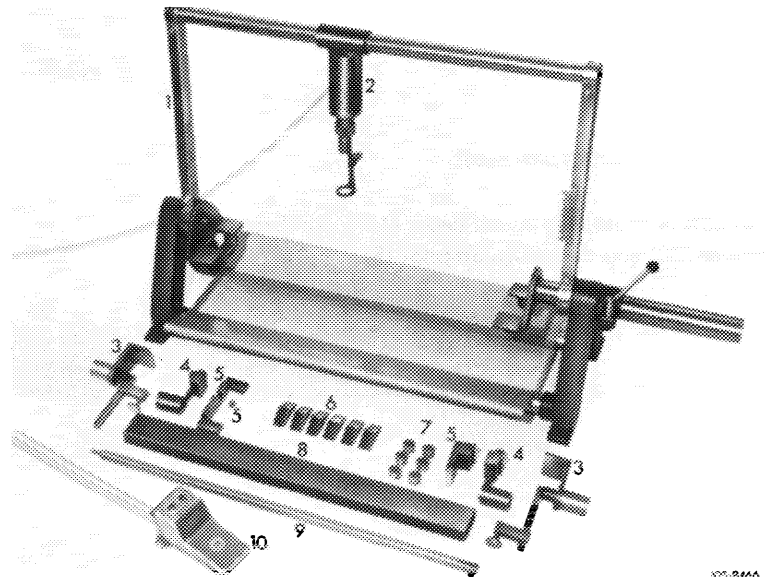
Conventional tools

Cylinder head clamping device	e.g. Rothenberger, D-6233 Kelkheim order No. 29900
Valve seat machining 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 bit No. 13 for correction angle, bottom	e.g. Hunger, D-8000 München order No. 216.64.622

Note

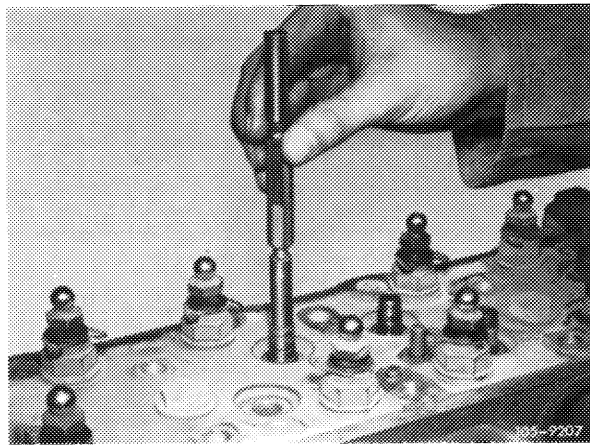
Clamp cylinder head for disassembly and machining into clamping device.

Refinish valve seats with valve seat machining tool, valve seat grinder or valve seat milling tool.



Machining valve seat

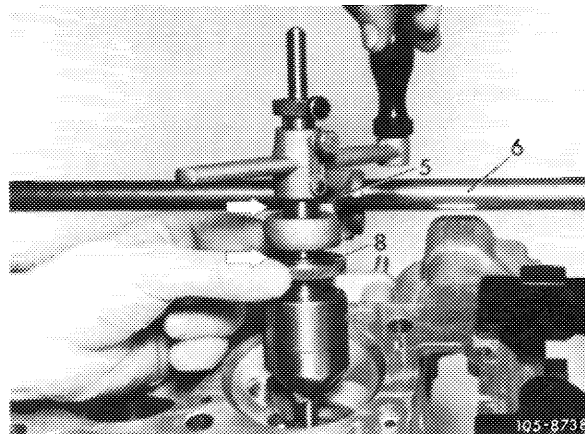
1 Check valve guides and renew, if required (05–285).



2 Machine valve seats (refer to operating instructions of tool manufacturer).

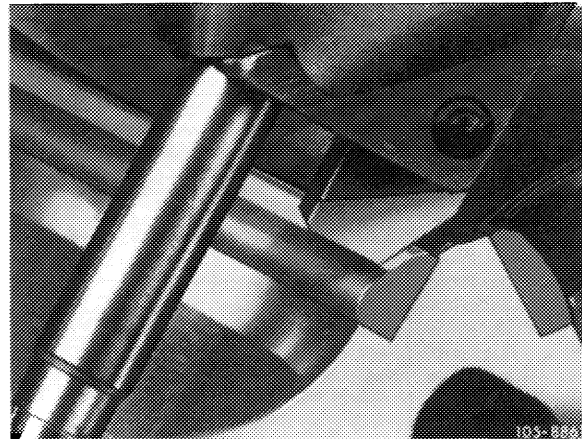
Attention!

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



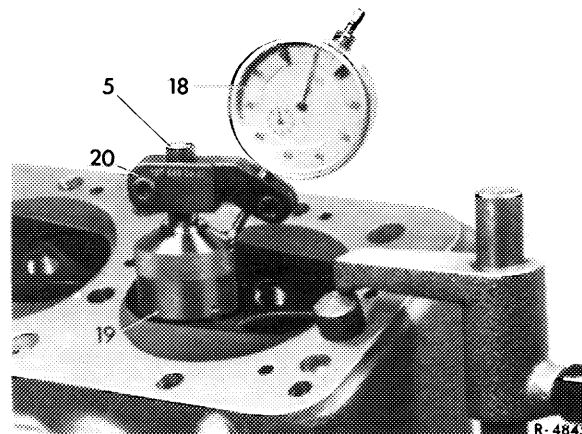
Attention!

Do not machine bead on lower portion of valve seat.



3 Check runout of valve seat.

For this purpose, slip check sleeve (19) with dial gauge holder (20) and dial gauge on pilot (5).



- 5 Pilot
- 10 Dial gauge
- 19 Check sleeve
- 20 Dial gauge holder

4 Measure valve seat width "b" and correct to 15° at top and 60° at bottom, if required.

When machining with machining tool made by Hunger, use correction tool bit No. 13 for 60° bottom valve seat correction.

