

Data

Reference dimension H when new	59.8-60	
Minimum dimension H after material removal	59.55 ¹⁾	
Unevenness of mating surface when new and after machining	in longitudinal direction	0.08
	in transverse direction	0.0
Roughness of cylinder head mating surface	0.006-0.014	
Test pressure with air under water in bar	2	

¹⁾ The total maximum material removal on both cylinder head and cylinder crankcase of an engine may not exceed 0.5 mm (see 01-120).

Conventional tools

Surface grinder with milling facility for light metal surfaces	e.g. Scedum, type RTY Roaro u. Fi. Schio, Italy
Knife-edge ruler approx. 500 mm long	

Note

Face cylinder head mating surface only when porous or damaged, or if an impermissible deviation of the evenness has been measured in longitudinal direction.

Facing

- 1 Measure reference value H and note down.
- 2 Face cylinder head mating surface. Remove sharp edges around combustion chamber.
- 3 Again measure dimension H. Determine material removed and note down.
- 4 Insert valve and measure distance between valve stem end and cylinder head, note down.
- 5 Remachine valve seats according to the material removed from the cylinder head (05-291).
- 6 Check valve timing (05-215).

