

01-418 Facing cylinder head parting surface

Data

Reference dimension H when new	60
Minimum dimension after removing material allowance	59.75 ¹⁾
Permissible deviation from flat of parting surface when new or after machining ²⁾	in longitudinal direction 0.08
	in transverse direction 0.0
Roughness	0.006-0.014
Pressure test with air under water in bar gauge pressure	2

¹⁾ The material allowance on cylinder head and on cylinder crankcase of one engine should together not exceed max. 0.5 mm (refer to 01-120).

²⁾ Face cylinder head parting surface only in the event of porous or damaged spots. A slightly distorted parting surface will adapt again to cylinder head when tightened.

Conventional tools

Service grinder with milling attachment
for light alloy surface

e. g. Scledum, Typ RTY
Foaro u. Fi. Schio, Italy

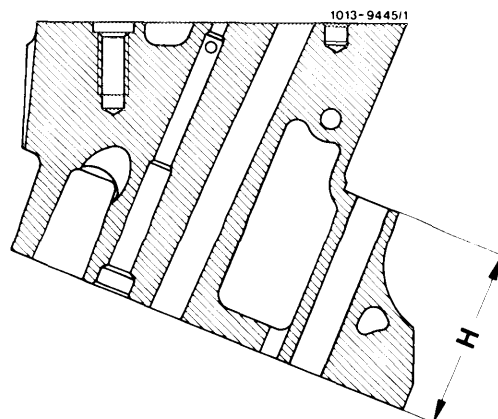
Straightedge approx. 500 mm long

Note

Face cylinder head parting surface only in the event of porous or damaged spots.

Facing

- 1 Measure reference dimension H and note.
- 2 Face cylinder head parting surface.
- 3 Measure again, determine material removal (allowance) and note.



4 Introduce valve, measure distance between valve stem end and cylinder head and note.

5 Refinish valve seats according to material removal on cylinder head.

6 Check timing (05–215).