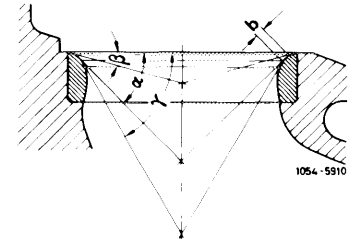
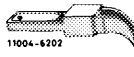
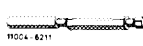


## 05-291 Machining valve seat

Data	Intake	Exhaust
Valve seat width b	1.3-2.0	1.5-2.0
Valve seat angle $\alpha$		45°
Correction angle top $\beta$		15°
Correction angle bottom $\gamma$		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

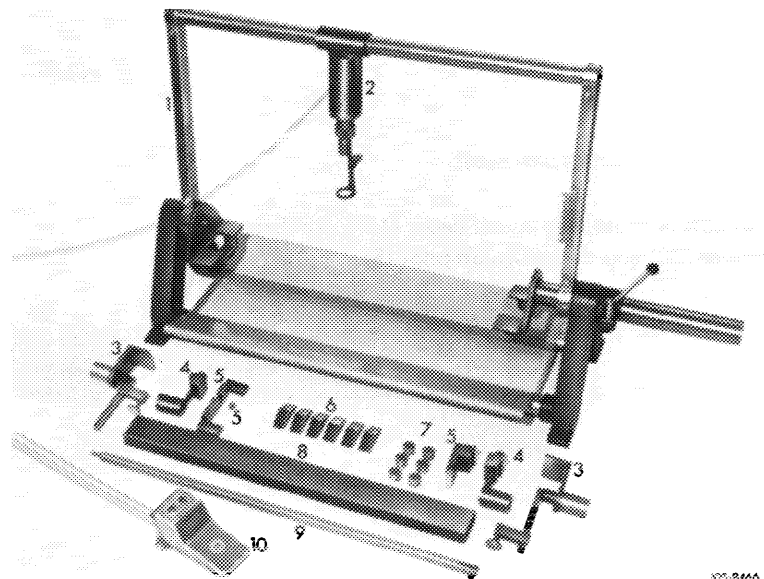
### Conventional tools

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

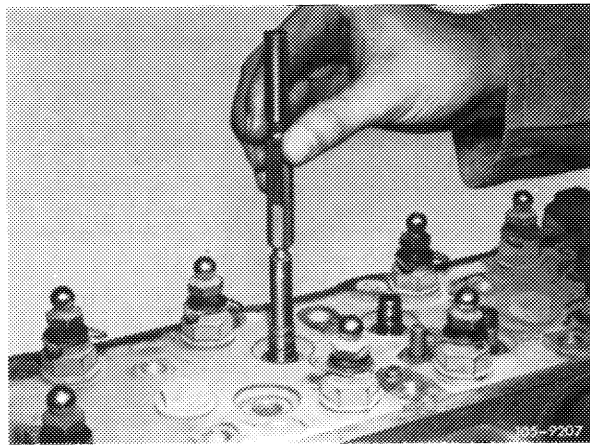
Clamp cylinder head for disassembly and machining into clamping device.

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



## Machining valve seat

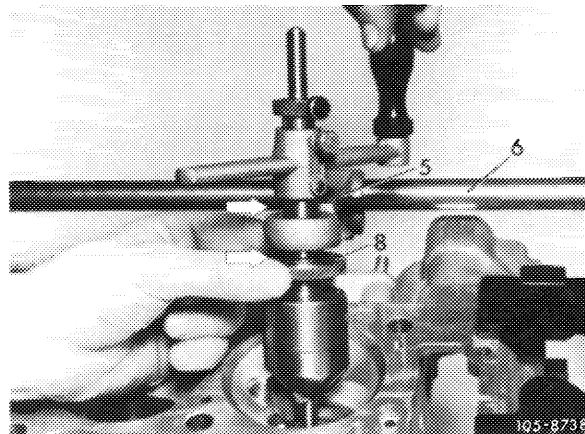
1 Check valve guides and renew, if required (05–285).



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

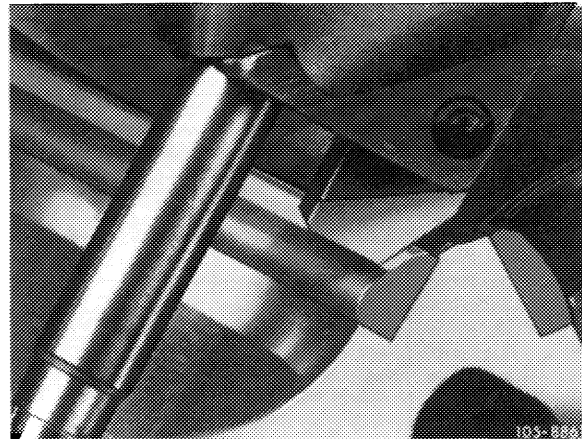
### Attention!

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



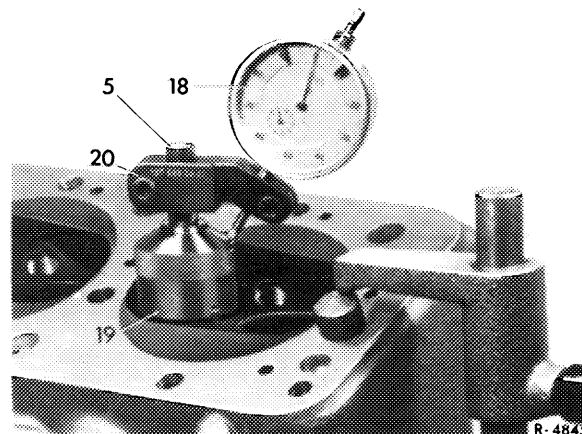
### Attention!

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.

