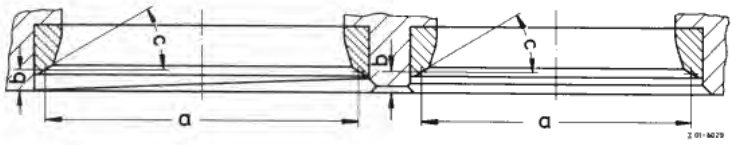
Technical data



Diameter of valve seat ring in new seat rings	a	Inlet	mm	40 ± 0,01
		Exhaust	mm	34 ± 0,01
Reference size	b	Inlet	mm	3,9 + 0,2
		Exhaust	mm	3,9 + 0,2
Valve seat angle	c	Inlet	°	30 or 20[1])
		Exhaust	°	45
Permissible runout of valve seat		Inlet and Exhaust	mm	0,03
Valve offset between cylinder head mating surface and valve disc		Inlet	mm	0,7 to 1,2
		Exhaust	mm	0,7 to 1,2

The valve seats must be renewed if the refacing limit is exceeded during remachining of the valve seat.
1) Valid from installation of "EURO I" engines, refer to **1.1/2** (D 01) or **1.1/3** (E 01).

Special tools

000 589 12 66 00
01

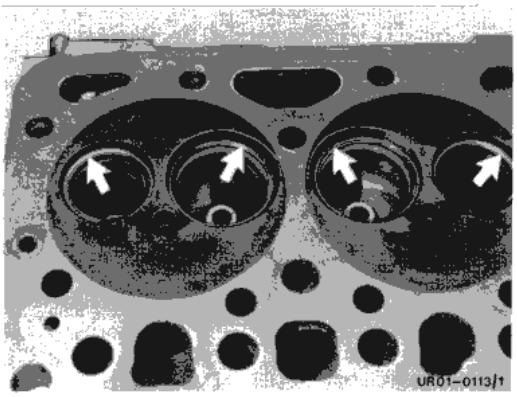
X10 **Refacing**

01/146 **1** Disassemble cylinder head, see **5.1/1** (K 04).

01/161 **2** Check valve guide, exchange if necessary, see **6.1/1** (B 05).

01/163 **3** Check valve seat.

01H044 **Note:** If valve seats show only slight traces of wear, they can be refaced without necessitating replacement of valve seat rings, provided they are not machined below their bottom limit.
See **6.2/1** (G 05) for repair size.



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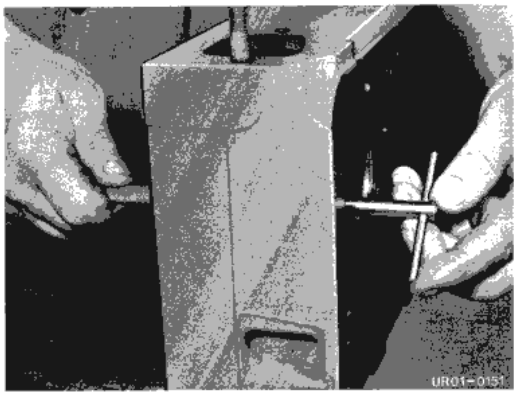
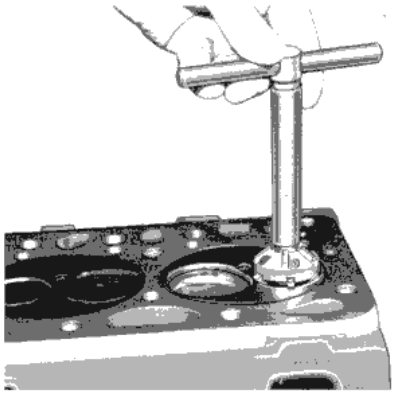
01/175 **4** Insert guide drift in valve guide.

000 589 12 66 00



01/176 **5** Mount hand milling cutters and adjust cutting tools to required seat diameter.

000 589 12 66 00

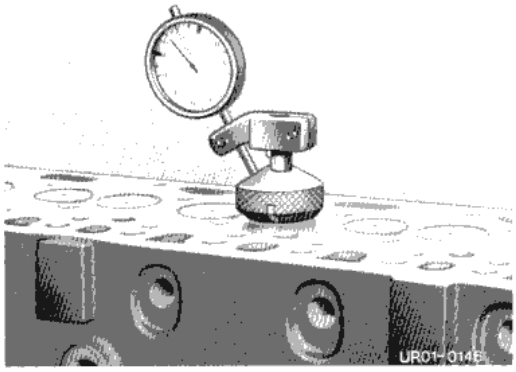


01/177 **6** Reface valve seat, applying gentle pressure.

01/638 **7** Measuring eccentricity of the valve seat. Refer to table **6.2/1** (G 05).

01H125 **Caution:** The test must take place immediately after completing the machining of the valve seat. The guide mandrel must **not** be released or removed beforehand.

01/160 **8** Assemble cylinder head, see **5.1/1** (K 04).



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