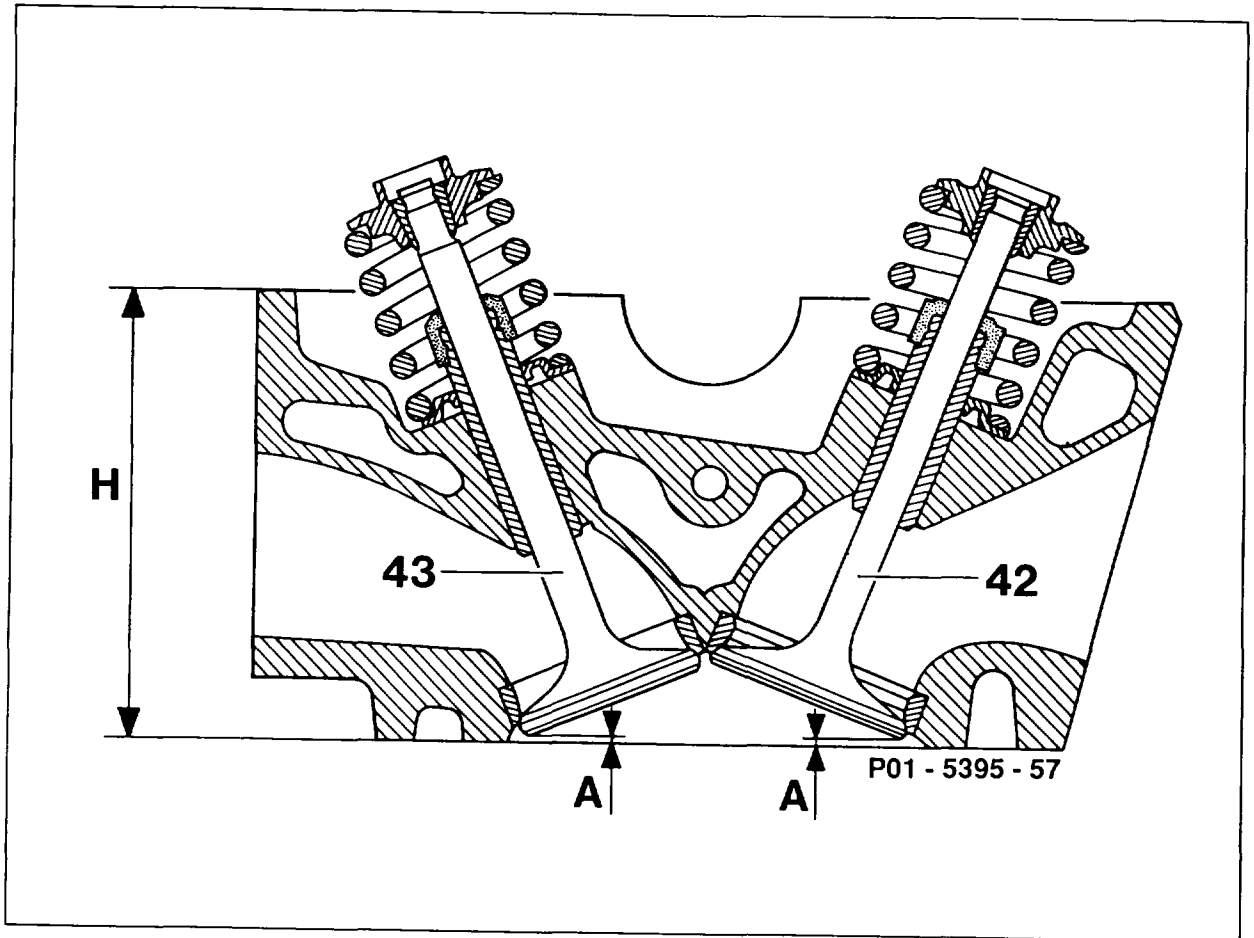


01-4180 Checking, facing cylinder head contact surface

Preceding work:
Valves removed.

Operation no. of operation texts and work units or standard texts
and flat rates
01-7162



Reference size (H)	measure and note.
Cylinder head contact surface	face, pay attention to note.
Sharp edges on combustion chamber edge	slightly chamfer.
Reference size (H)	measure once again, determine stock removal.
Valve clearance (A) between valve retainer and cylinder head contact surface	measure.
Valve seats	machine up to minimum size (A) (05-2910).
Timing	check (05-2150).

Data

Overall height "H" of cylinder head		89.9 – 90.0
Minimum height after machining ¹⁾		89.5
Permissible deviation from flatness of contact surface	in longitud. dir.	0.08
	in transverse dir.	0.0
Permissible deviation of parallelism of top to bottom contact surface in longitudinal direction		0.1
Peak-to-valley height		0.003 – 0.010

¹⁾ The stock removal at the cylinder head and at the crankcase of an engine must together be not more than 0.5 mm (see 01-1200).

Commercially available tool

Surface grinding machine with grinding device for light-alloy surfaces

Note

Only machine cylinder head contact surface if porous or damaged points are found or if the measurement reveals an impermissible deviation of flatness in longitudinal direction of more than 0.2 mm.



The top cylinder head contact surface must not be machined otherwise the basic bores of the camshaft bearings will be altered.

If cracks are suspected (internal loss of coolant), the cylinder head must be pressure-tested.