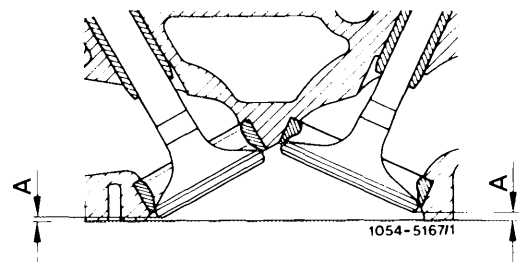


## 01-418 Facing cylinder head mating surface

### Data

Total cylinder head height			93.9-94.0
Min. height after machining			93.1
Permissible unevenness of mating surfaces	in longitudinal direction		0.08
	in cross direction		0.0
Permissible deviation in parallel of upper mating surface to lower mating surface in longitudinal direction			0.1
Peak to valley height			0.010
Pressure test with air under water in bar gauge pressure			2
Minimum distance A with new valves and new valve seats, cylinder head parting surface not machined	Minimum distance A with new valves and new valve seats, cylinder head parting surface 0.4 mm milled off		
Intake	3.3		2.9
Exhaust	Valve retainer dia. 37 mm	0.6	0.2
	Valve retainer dia. 39 mm	0.04	0.36 standout
Max. distance A with new valves and machined valve seats, cylinder head parting surface not machined	Max. distance A with new valves and machined valve seats, cylinder head parting surface 0.4 mm milled off		
Intake	4.2		3.8
Exhaust	Valve retainer dia. 37 mm	1.5	1.1
	Valve retainer dia. 39 mm	0.94	0.54
Max. distance A is reduced by the same dimension by which the cylinder head parting surface has been machined down.			



## Conventional tools

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Surface grinding machine with milling equipment for light alloy surface

e.g. made by Ruaro u. Fi., Schio/Italy  
Sledum, type RTY

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Knife-edged straightedge approx. 750 mm long

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## Facing

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Only 0.4 mm material can be machined off of the cylinder head at the mating surfaces to the crankshaft and camshaft housing.

A distorted cylinder head must always be faced on both mating surfaces.

Machine valve seats until the permissible distance A between the valve head and cylinder head mating surface is reached.

The timing must be adjusted, if a cylinder head mating surface is faced (05–215).

