

01-472 Facing camshaft housing

Data

Total height of new camshaft housing	104.8-105.0
Min. height after machining	104.0
Permissible deviation from parallel between upper and lower parting surface in longitudinal direction	0.1
Mean height of roughness of parting surfaces	0.006-0.014

Conventional tools

Surface grinding machine with milling equipment for light alloy surfaces	e.g. made by Ruaro u. Fi., Schio/Italy Scledum, type RTY
Knife-edged straightedge approx. 750 mm long	

Note

The camshaft housing may only be faced, if mechanical damage is visible on the mating surfaces.

A distorted camshaft housing will align with the cylinder head when tightened.

Only 0.4 mm may be machined off of the camshaft housing mating surfaces to the cylinder head or cylinder head cover. The same amount of material must be removed from the bearing surfaces for the gaskets at the spark plugs (2) as was machined from the mating surface to the cylinder head cover (1).

If the camshaft housing was faced, the timing must be adjusted (05-215).

