

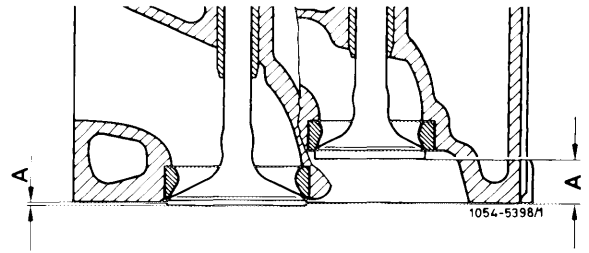
## 01–418 Facing cylinder head parting surface

### Data

Total height of cylinder head	84.8–85.0
Minimum height upon machining	84.0
Permissible unevenness of parting surfaces	in longitudinal direction 0.08
	in transverse direction 0.0
Perm. deviation in parallel of upper parting surface in relation to lower parting surface in longitudinal direction	0.1
Roughness	0.006–0.014
Test pressure with air under water in bar gauge pressure (atü)	2

### Valve spacing in relation to cylinder head parting surface

Engines	115.923/926		115.951	
	115.938/939		115.954	
Minimum distance A with new valves and new valve seats	intake	–0.2	+0.1	
	exhaust	–16	–16	
Maximum distance A with refinished valve seats and reground valves	intake	–1.5	–0.9	
	exhaust	–17	–17	



### Facing

- 1 Face parting surface of cylinder head.
- 2 Refinish valve seats until minimum distance A is attained.
- 3 Check timing (05–215).

