

Data	Intake valve	Exhaust valve	
Valve retainer dia.	39.7—39.9	34.1—34.3	
Valve stem dia.	9.92—9.94		
Valve length	131.5		
Code number on stem end	E 617 00	A 617 00 27	
Filled-in sodium	without	with	
Valve seat plating	valve seat nitride-hardened		
Height "h" of valve retainer	when new	2.54	2.49
	limit value	2.0	2.0
Adjusting angle for machining valves	30° + 15'		
Permissible runout at valve stem and valve seat max.	0.03		
Valve shaft wear (wear limit)	0.05		

Conventional tools

Valve cone grinder or valve cone machining tool	e.g. made by Matra-Werke GmbH D-6000 Frankfurt/Main 8 e.g. made by Hunger, D-8000 München
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Note

Exhaust valves are filled with sodium.

When scrapping valves, pay attention to safety rules. Do not melt valves filled with sodium, since there is a risk of explosion, and do not use such valves for making tools (punch, etc.), without first removing filled-in sodium.

Be careful when removing sodium from valve, since sodium mixed with water and watery solutions reacts heavily explosive, while the resulting hydrogen gas may cause fires.

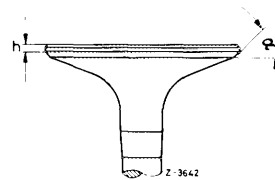
Sodium from cut-up or broken-up valves can be neutralized in a mixture comprising 2 liters of spirit of alcohol and 1 liter of water put into a vessel and placed in the open air.

Valves filled with sodium can be collected and shipped for neutralizing to: Garantieprüfstelle Werk Stuttgart-Untertürkheim.

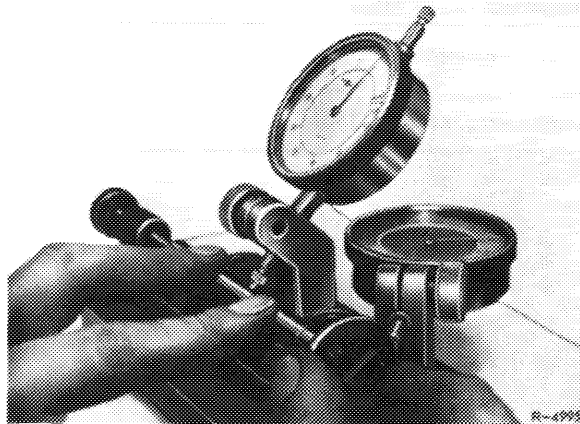
Checking and machining

1 Clean valves and check visually.

Valves with a burnt valve retainer, with insufficient height "h" of valve retainer and valves with worn out or scored valve stem should be replaced.



2 Measure runout on valve stem. If runout exceeds 0.03 mm, replace valve.



3 Machine valve seat.

Refer to operating instructions of machining tool and make sure of a 30° adjusting angle.

4 Measure runout on valve seat and height "h" of valve retainer.

As soon as the limit values are attained, replace valve.

