

**Data**

Reference dimension H when new	59.8-60	
Minimum dimension H after material removal	59.55 <sup>1)</sup>	
Unevenness of mating surface when new and after machining	in longitudinal direction	0.08
	in transverse direction	0.0
Roughness of cylinder head mating surface	0.006-0.014	
Test pressure with air under water in bar	2	

<sup>1)</sup> The total maximum material removal on both cylinder head and cylinder crankcase of an engine may not exceed 0.5 mm (see 01-120).

**Conventional tools**

Surface grinder with milling facility for light metal surfaces	e.g. Scedum, type RTY Roaro u. Fi. Schio, Italy
Knife-edge ruler approx. 500 mm long	

**Note**

Face cylinder head mating surface only when porous or damaged, or if an impermissible deviation of the evenness has been measured in longitudinal direction.

**Facing**

- 1 Measure reference value H and note down.
- 2 Face cylinder head mating surface. Remove sharp edges around combustion chamber.
- 3 Again measure dimension H. Determine material removed and note down.
- 4 Insert valve and measure distance between valve stem end and cylinder head, note down.
- 5 Remachine valve seats according to the material removed from the cylinder head (05-291).
- 6 Check valve timing (05-215).

