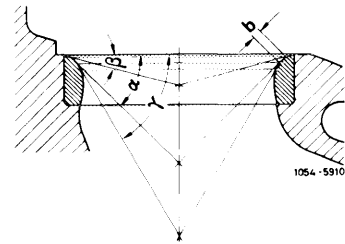




Data	Intake	Exhaust
Valve seat width $b$	1.3-2.0	1.5-2.0
Valve seat angle $\alpha$	45°	
Correction angle top $\beta$	15°	
Correction angle bottom $\gamma$	60°	
Permissible runout of valve seat	0.04	



**Special tools**

Magnetic finger for valve cone halves		116 589 06 63 00
Plug gauge 9 mm dia.		117 589 03 23 00

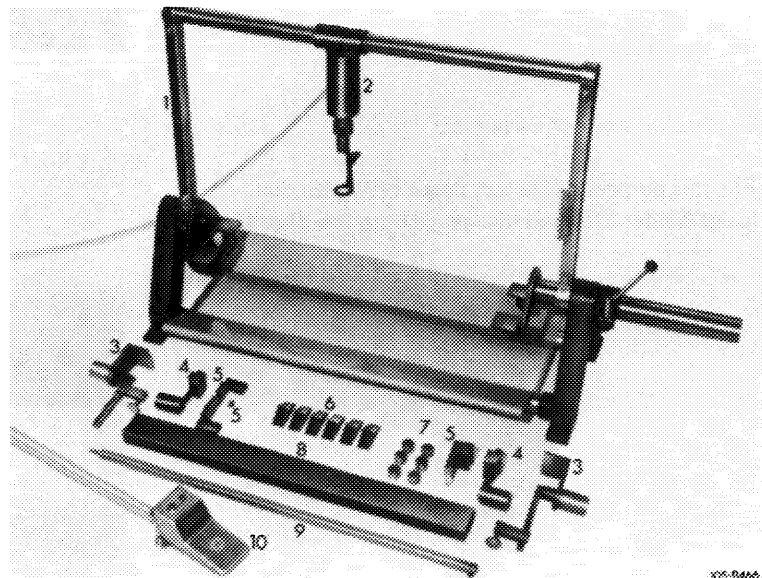
**Conventional tools**

Cylinder head clamping device	e.g. Rothenberger, D-6233 Kelkheim
Valve seat turning tool	e.g. Hunger, D-8000 München Type VDSNL 1/45/30, order No. 236.03.308
Test set for valve seats	e.g. Hunger, D-8000 München Order No. 216.93.300
60° correction tool No. 13 for correction angle bottom	e.g. Hunger, D-8000 München Order No. 216.64 622

**Note**

Clamp cylinder head into clamping device for disassembling and machining.

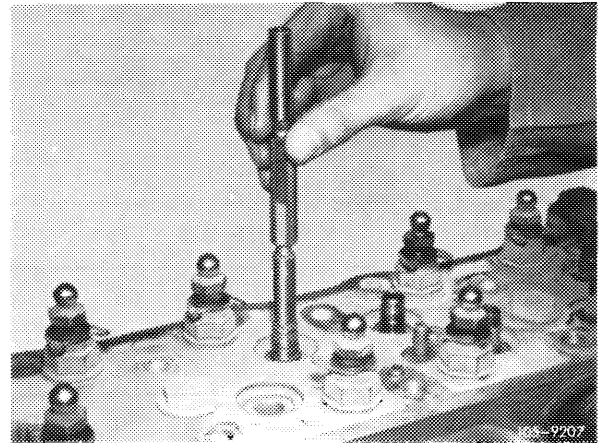
Machine valve seats with valve seat turning tool, with valve seat grinder or with valve seat cutter.



## Machining valve seats

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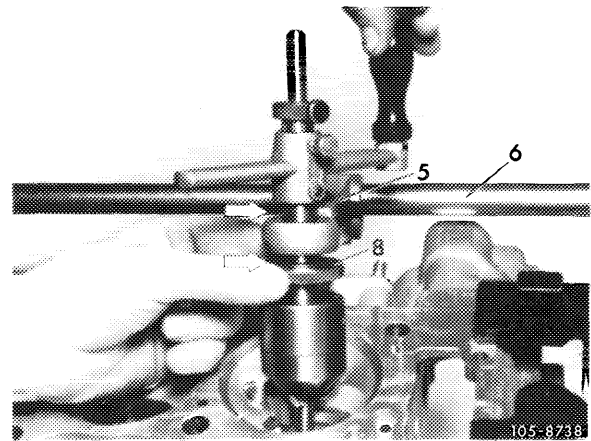
1 Check valve guides and replace if required (05-285).



2 Machine valve seats (see operating instructions of machine tool manufacturer).

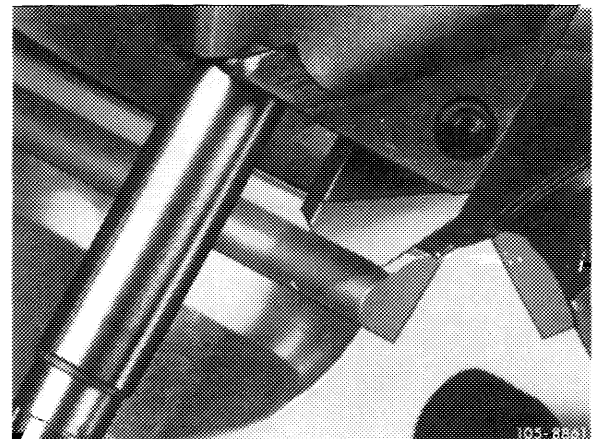
### Caution!

Loosen pilot only after the runout of the valve seat has been checked (item 3).



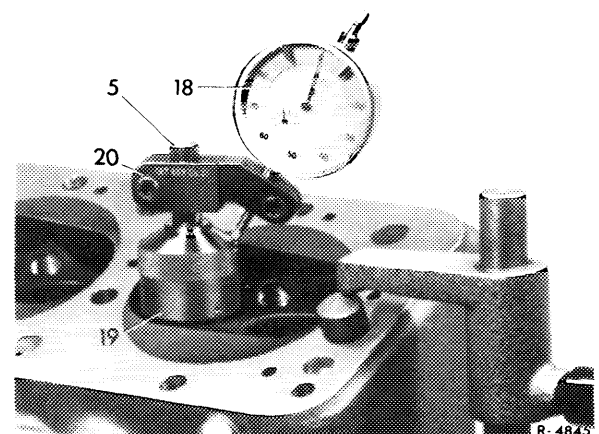
### Caution!

Do not turn down the bead at the lower end of the valve seat.



3 Check runout of valve seat.

For this purpose, slide test sleeve (19) with dial gauge holder (20) and dial gauge onto the pilot (5).



- 5 Pilot
- 18 Dial gauge
- 19 Test sleeve
- 20 Dial gauge holder

4 Measure valve seat width „b“ and correct at top with 15° and at bottom with 60° if required.

When machining with the Hunger turning tool, use the 60° correction steel No. 13 for the lower valve seat correction.

5 Observe valve springs and valve spring preload (05–260).

