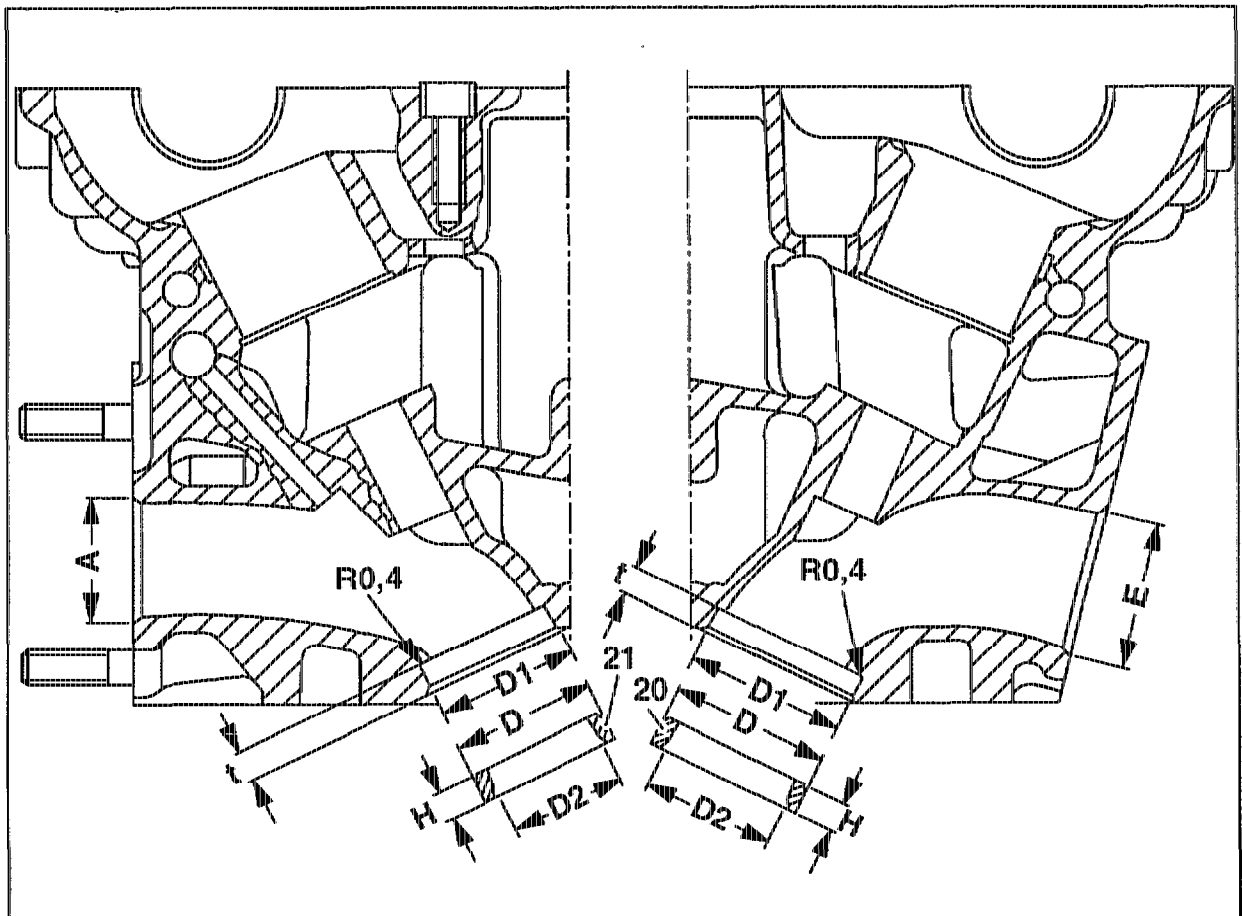


05-2900 Replacing valve seat rings

Preceding work:
Valve guides inspected (05-2845)

Operation no. of operation texts and work units or standard texts
and flat rates



P05-5500-57

Valve seat rings (20 and 21)	turn out with ring seat turning tool.
Operating instructions of tool manufacturer	note.
Basic bore diameter (D1)	measure with internal measuring instrument.
Valve seat rings (standard size or repair size) ...	select according to overlap.
If repair size	machine basic bore.
If repair size	seat ring bore matching valve seat ring, pay attention to overlap.
Valve seat ring	cool with liquid nitrogen and insert with a suitable drift.
Valve seats	machine (05-2910).

Engine		119.960/970/972/974	
Bore of valve seat ring		Inlet	Exhaust
D1	Standard size cylinder head	39 H6	34 H6
D	Standard size valve seat ring	39.1 to 39.09	34.1 to 34.09
Repair size			
D1	Repair size cylinder head	40.2 H6	35 .2 H6
D	Repair size valve seat ring	40.3	35.3
t		7.8 to 7.9	
D2		38.47	25.6

Engine		119.971/975/980/981/982/985	
Bore of valve seat ring		Inlet	Exhaust
D1	Standard size cylinder head	36 H6	34 H6
D	Standard size valve seat ring	36.1 to 36.09	34.1 to 34.09
Repair size			
D1	Repair size cylinder head	37.2 H6	35 .2 H6
D	Repair size valve seat ring	37.3	35.3
t		7.8 to 7.9	
D2		35.47	33.47

Commercially available tools

Cylinder head clamping device	e. g.	Hunger 81375 München Order no. 221.60.000
Ring seat turning tool	e. g.	Hunger 81375 München Size 2, order no. 220.03.110
Valve seat turning tool (size 2)	e. g.	Hunger 81375 München Type VDSN 1/45/30 Order no. 236.03.308
Test kit for valve seats	e. g.	Hunger 81375 München Order no. 216.93.300
Internal measuring instrument (range 35 – 100 mm)	e. g.	Mahr, 73730 Esslingen Order no. 844 N
External micrometer (range 25 – 50 mm)	e. g.	Mahr, 73730 Esslingen Order no. 40 S H