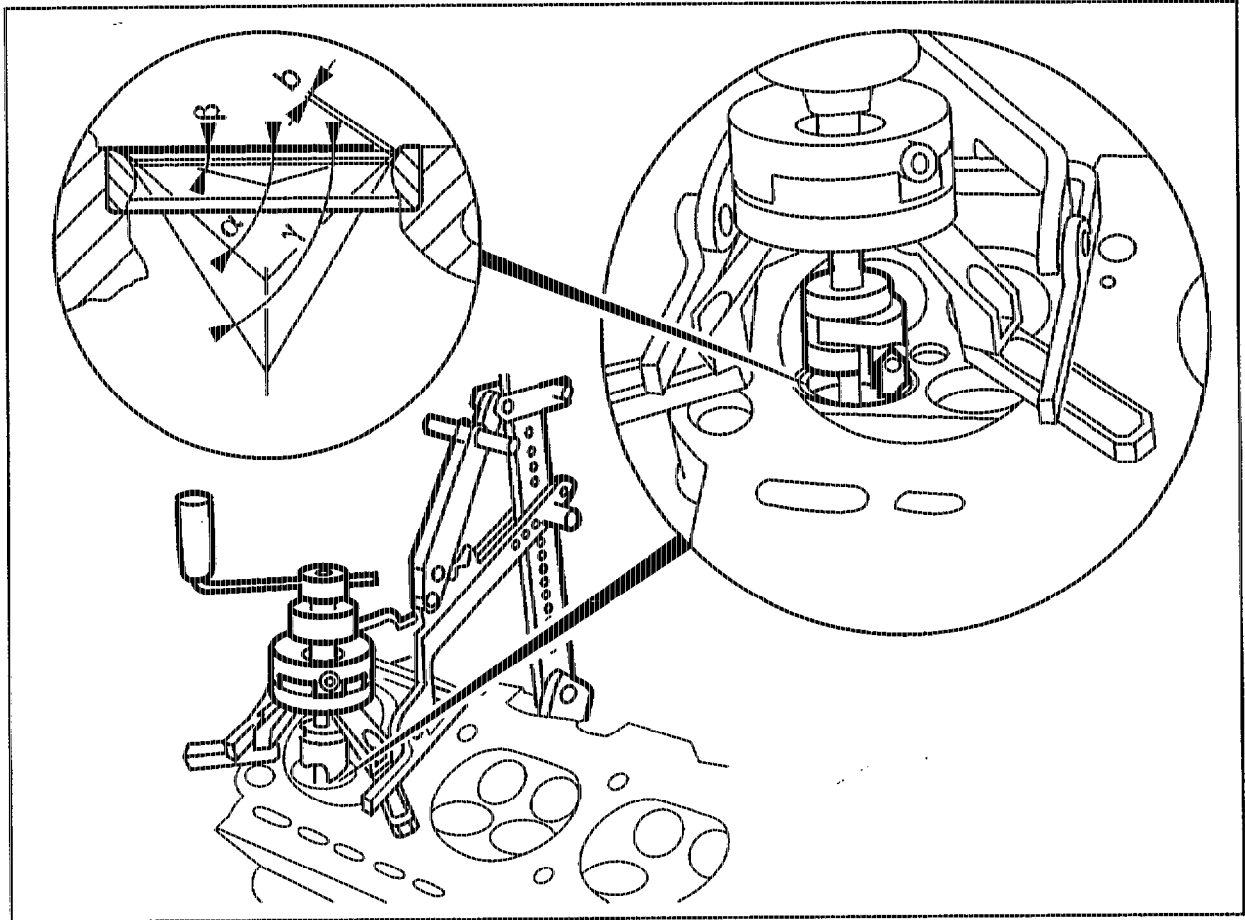


# 05-2910 Machining valve seat rings

Preceding work:  
Valve guides inspected (05-2845)

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



P05-5456-57

Valve seats ..... machine.

**Note**

Pay attention to operating instructions of tool manufacturer.

Use *SERDI* form turning tool no. 41196.

Use Hunger turning tool no. 23m or 24m.

Reference size (T) between valve stem end and base of camshaft bearing .....

measure (see Inspecting, facing cylinder head contact surface 01-4180).



If size "T" is not achieved, no further correct valve clearance compensation exists. In this case, the valve seat or the cylinder head should be replaced.

Dimensions .....

maintain according to table.

Leaktightness with valve installed .....

check.

Valve seat width (b) ..... measure.

**Note**

If necessary, correct valve seat width (b) with correction tools 23m and 24m (Hunger) (angles  $\alpha$  and  $\beta$ ).

Valves ..... insert and measure clearance from valve stem end to base of camshaft bearing (T), see (01-4180).



The valves should always be replaced when performing facing work on cylinder head and re-setting the valve seats.

| Data                                    |         | Inlet, exhaust valve |
|---|---------|----------------------|
| Valve seat width (b)                    | Inlet   | 0.80 – 1.10 mm       |
| Valve seat width (b)                    | Exhaust | 1.00 – 1.20 mm       |
| Valve seat angle ( $\alpha$ )           |         | 45°                  |
| Top correction angle ( $\beta$ )        |         | 30°                  |
| Bottom correction angle ( $\gamma$ )    |         | 60°                  |
| Permissible concentricity of valve seat |         | 0.03 mm              |

**Commercially available tools**

|  |       |  |
|--|-------|--|
| Valve seat turning tool  | e. g. | SERDI GmbH<br>Bregenzstr. 69<br>88131 Lindau                               |
| Form turning tool  | e. g. | SERDI GmbH<br>Bregenzstr. 69<br>88131 Lindau<br>Order no. 41196            |
| Cylinder head clamping device  | e. g. | Hunger<br>81375 München 70<br>Order no. 221.60.000                         |
| Valve seat turning tool  | e. g. | Hunger<br>81375 München 70<br>Type VSDN 1/45/30<br>Order no. 236.03.308    |
| Test kit for valve seats   | e. g. | Hunger<br>81375 München 70<br>Order no. 216.93.300                         |
| Turning tools for valve seat and correction angle ( $\beta$ ) and ( $\gamma$ )<br>23m<br>24m | e. g. | Hunger<br>81375 München 70<br>Order no. 216.64.235<br>Order no. 216.62.170 |