

01-4300 Cleaning, sealing oil longitudinal galleries in cylinder head

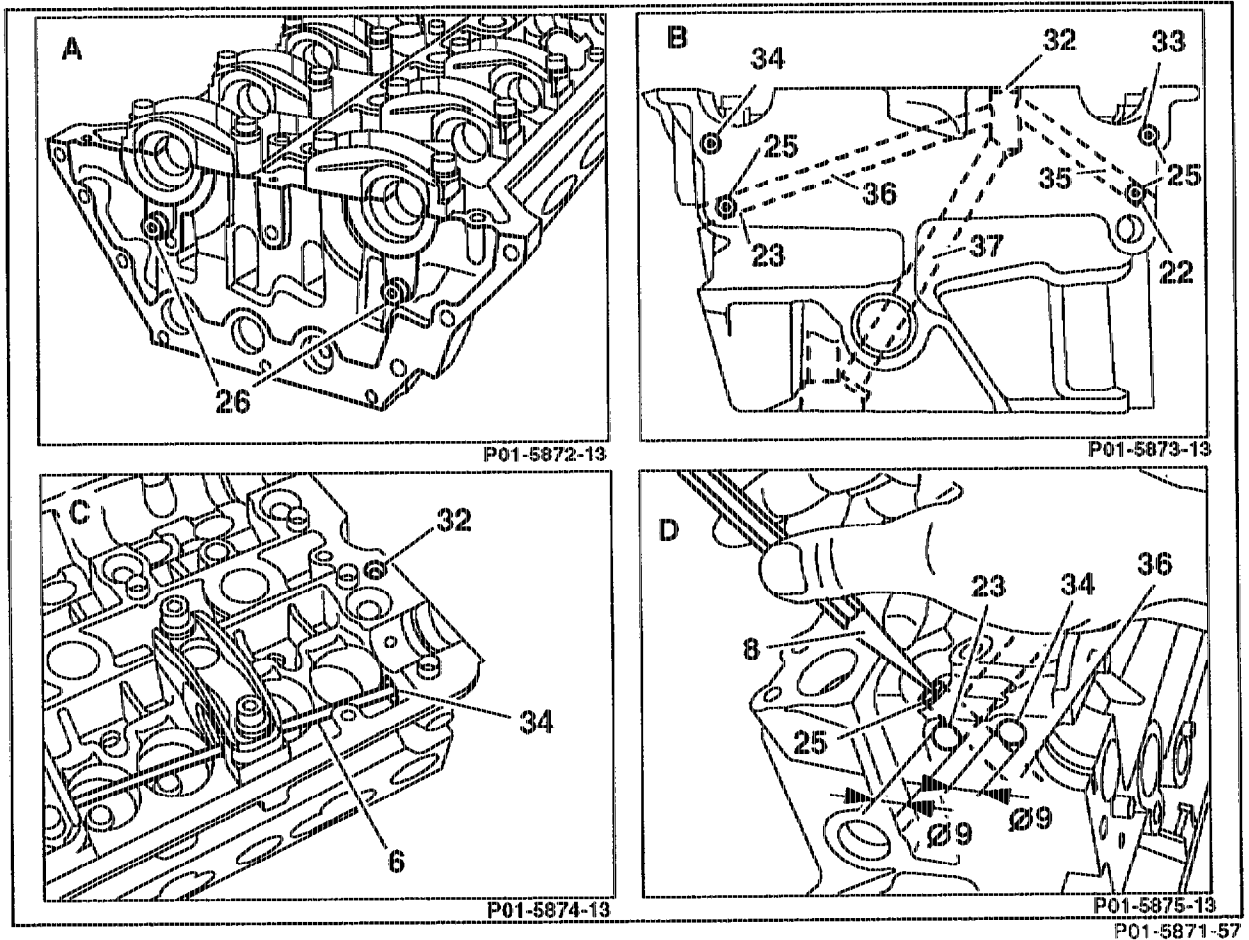
Preceding work:

Cylinder head removed (01-4150).

Camshafts removed (05-2200).

Bucket tappets removed (05-2110).

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

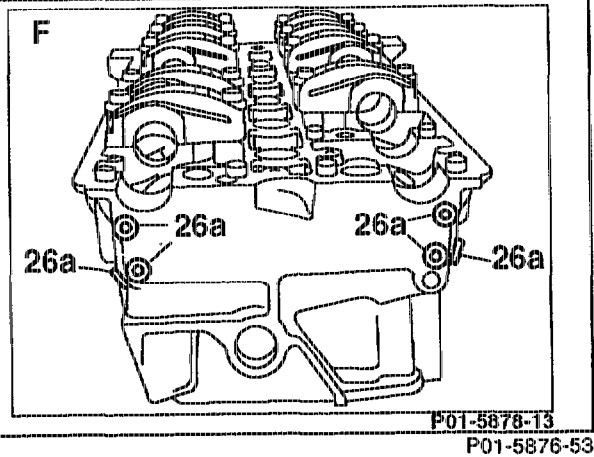
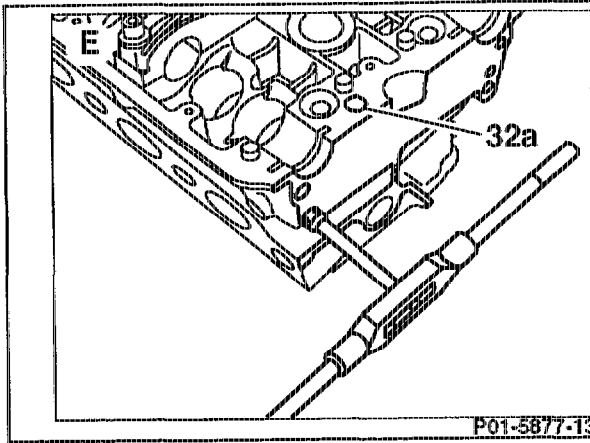


- 25 Steel ball, 8 mm dia.
 22 Oil gallery, bucket tappets oil supply, exhaust side, 7.85 mm dia.
 23 Oil gallery, bucket tappets oil supply, inlet side, 7.85 mm dia.
 33 Oil outlet gallery, exhaust side, 7.85 mm dia.

- 34 Oil outlet gallery, inlet side, 7.85 mm dia.
 35 Oil transverse gallery, exhaust side, 7.85 mm dia.
 36 Oil transverse gallery, inlet side, 7.85 mm dia.
 37 Oil riser gallery, cylinder head

- Screw plugs (26) with seals
 Steel balls (25) in oil galleries (22), (23), (33) and (34)
 Plug (32)
 Oil galleries (22, 23, 33 and 34) at rear
 Steel balls (25) at side
 Steel balls (25)
 Oil galleries (35) and (36) at side

- unscrew, screw on (15 Nm) (Fig. A).
 knock out with round bar (6) dia. 6 × 700 mm from the front (Figs. B and C).
 prise out with a screwdriver (Fig. C).
 widen dia. 9 × 8 mm deep (Fig. D).
 knock in with a punch (8) into oil galleries (22) and (23) (Fig. D).
 knock out from front with round bar (6).
 widen dia. 9 × 8 mm deep.



- M10 × 1 thread
- Oil longitudinal galleries and all holes
- Bolt head contact surface at oil galleries (35 and 36) at side
- New plug (32a)

- New plug (32a)
- Screwplugs (26a)
- part no. 000 908 01 00 02 with seals
- part no. 007 603 01 01 03

- tap in oil galleries (Fig. E).
- carefully clean.

- face.
- coat around circumference with Loctite high strength 270, 002 989 93 71 10 (Fig. E).
- knock in flush with suitable drift (Fig. E).

- screw in (15 Nm) (Fig. F).

Special tool

