



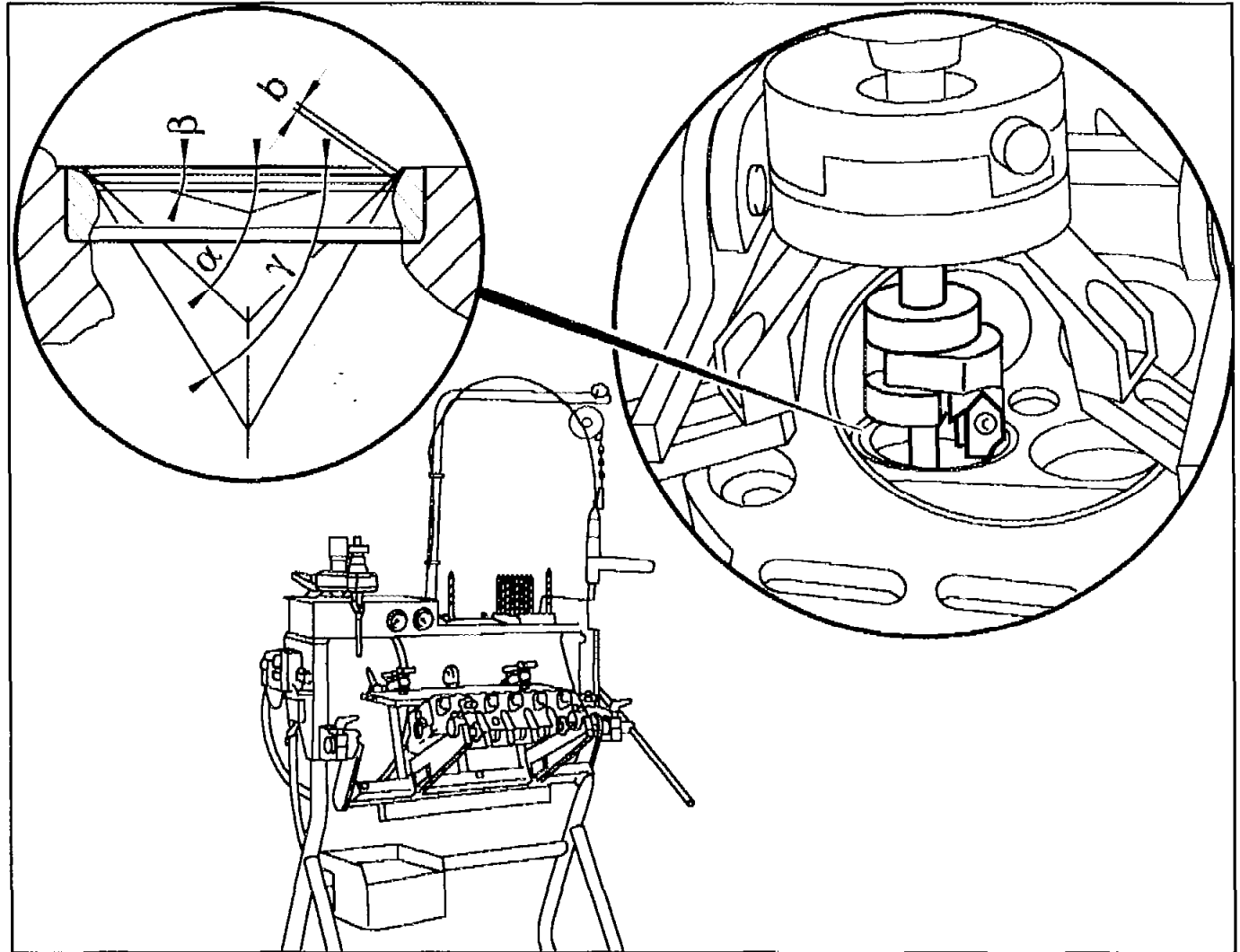
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

AR05.30-P-4511B

Machining valve seat rings

14.10.96

ENGINE 604, 605, 606 /



	Removing, installing		
1	Remove valves		AR05.30-P-3511B D5
2	Inspect valve guide	If necessary, after inspecting ↓ replace valve guide	AR05.30-P-3731A J5
3	Machine valve seats	 Pay attention to operating instructions of the tool manufacturer. Maintain the dimensions stated in the test and setting data.  	BE05.30-P-1014-03B WH58.30-Z-1023-05A WH58.30-Z-1011-05A
4	Inspect valve seat for leaks		
5	Measure valve seat width	If necessary, correct width of valve seat (angle γ)	
6	Insert valve, inspect for leaks		WH58.30-Z-1051-13A
7	Measure distance from valve stem end to base of camshaft bearing or amount by which valve stands back to cylinder head	 Valve stem end to base of camshaft bearing For this purpose, insert \varnothing 5 mm round bar centrally into base of camshaft bearing and measure dimension with caliper gage.  Measure amount by which valve stands back relative to cylinder head	BE01.30-P-1009-02A AR05.30-P-4100-01A D17

		ⓘ If the minimum dimension is not reached, it is no longer possible to achieve correct valve clearance compensation ↓ replace valve seat rings	AR05.30-P-3831A	A6
8	Install in the reverse order			

Test data of valve seat rings

Number	Designation	Engine 604, 605, 606		
BE05.30-P-1014-03B	Valve seat width (b)	Inlet	mm	1.0–1.5
		Exhaust	mm	0.8–1.5
		Fig. see		AR05.30-P-4510-01A
BE05.30-P-1015-03B	Valve seat angle (α)	Inlet	Δ°	45°-15'
		Exhaust	Δ°	45°-15'
		Fig. see		AR05.30-P-4510-01A
BE05.30-P-1016-03B	Correction angle (γ)	Inlet	Δ°	15 ± 15'
		Exhaust	Δ°	25 ± 15'
		Fig. see		AR05.30-P-4510-01A
BE05.30-P-1017-03B	Radial runout of valve seat	Inlet	mm	0.03
		Exhaust	mm	0.03

**Test data of cylinder head**

Number	Designation	Engine 604, 605, 606
BE01.30-P-1008-02A	Distance (a) with new valves and new valve seat rings	Exhaust valve mm 1.3–1.7
		Inlet valve mm 1.3–1.7
		Fig. see AR01.30-P-7162-01A
BE01.30-P-1009-02A	Distance from valve stem end up to base of camshaft bearing (T)	mm 23.7–24.2
		Fig. see AR01.30-P-7162-01A

Commercially available tools (see Workshop Equipment Manual)

Number	Designation	Make (e.g.)	Order number
WH58.30-Z-1023-05A	Valve seat turning tool	Serdi Bregenzerstr. 69 D-88131 Lindau	SP 1050
WH58.30-Z-1011-05A	Forming cutting tool	Serdi GmbH Bregenzer Str. 69 D-88131 Lindau	41288
WH58.30-Z-1051-13A	Vacuum tester	Serdi GmbH Bregenzer Str. 69 D-88131 Lindau	SL1009