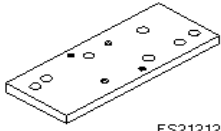


Valve Guide - Ream (One) (Valve Removed) (21 233 4)

Special Tools



ES21212

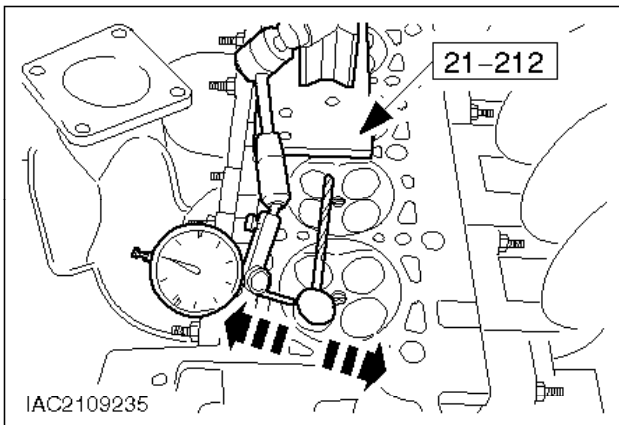
21-212 Mounting plate

Proprietary Tools

Adjustable reamer, diameter 7 - 7,5 mm

Workshop Equipment

Dial indicator gauge with magnetic fixture



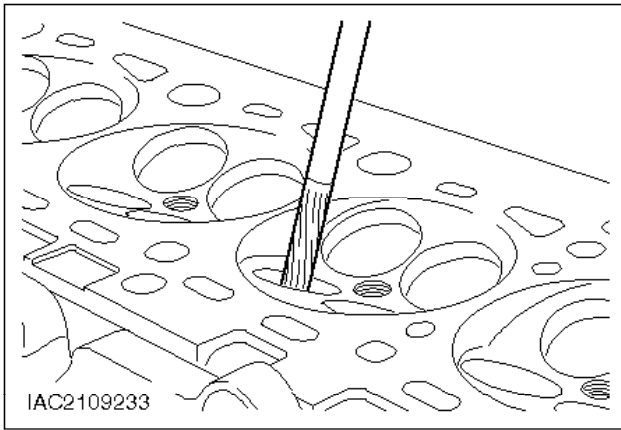
Rework

1. Fit mounting plate 21-212 and the dial indicator gauge.
2. Insert a 7 mm drill bit between the valve seat ring and the valve head.
3. Check the valve stem/valve guide clearance.
 - Permitted valve stem/valve guide clearance measured at the valve head: Inlet 0,06 - 0,21 mm, Exhaust 0,12 - 0,29 mm.

Note:

The dial indicator gauge must be at 90° to the valve stem.

- Position the plunger of the dial indicator gauge on the edge of the valve head.
 - Measure the valve stem clearance by moving the valve sideways back and forth.
 - If necessary install a new valve and/or rework the valve guide as described in the next step.
4. Detach the dial indicator gauge and the mounting plate and remove the drill bit.



CAUTION:

After reaming the valve guide, recut the valve seat ring as described in «Operation No. 21 231 9» and renew the valve.

Note:

Use drilling oil for lubrication.

- ⌚ 5. Ream the valve guide.

Note:

The specified clearance must be achieved to prevent the valve from sticking.

- Ream the valve guide to the appropriate oversize in several stages using the adjustable reamer (see General Specifications).
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