

## Machining the cylinder head mating surface

### Checking the cylinder head for distortion

Check the sealing surface of the cylinder head for distortion using a feeler gauge and straightedge.

Distortion limit of mating surface:  
0.05 mm. Warped cylinder heads may be repaired by machining the mating surface. Admissible distortion after machining: 0.03 mm

### Machining the cylinder heads

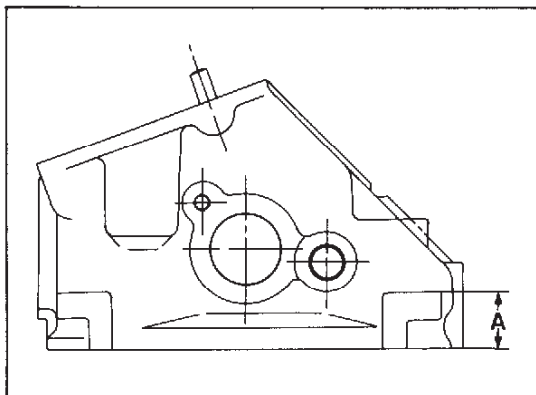
As a rule, both cylinder heads must be machined by the same amount to ensure correct seating of the regulator housing.

Machine sealing surface of the cylinder head only until a straight surface is obtained.  
Max. wear limit: 23.6 mm.

Note for machining of the sealing surface:  
Max. roughness = 0.015 mm

If machining causes the actual value to be below the tolerance applicable to new parts, use a 1.4 mm thick cylinder head gasket (available from the parts service) when fitting the cylinder head.

New-part size  $A = 24 \pm 0.1$  mm  
Wear limit  $A = 23.6$  mm



### Note

When machining the sealing surface facing the combustion chamber, also check the mating surface on the camshaft end and machine if required.

Admissible distortion of camshaft mating surface

when checking: 0.1 mm  
after machining: 0.03 mm

Before machining the mating surface facing the camshaft housing, check dimension "A" to avoid unnecessary work.

Plug oil passage of check valve before machining. Remove roll pins.

### Cylinder head refacing dimensions and identification

New dimension	: $24 \pm 0.1$ mm
Gasket	: 1.1 mm
Identification	: none

Refacing dimension	: 23.8 to 23.6 mm
Gasket	: 1.4 mm
Identification	: N

### Identification: N

Engrave at cylinder 1 and 4 as well as 5 and 8, respectively.

Height of "N" character: 10 mm

