

Machining the cylinder head mating face

Checking cylinder head for distortion

Using a feeler gauge and ruler or straight edge, check the cylinder head mating face for distortion.

Admissible distortion of the mating face:
0.05 mm

Distorted cylinder heads may be repaired by machining the mating face. Admissible distortion after machining: 0.03 mm.

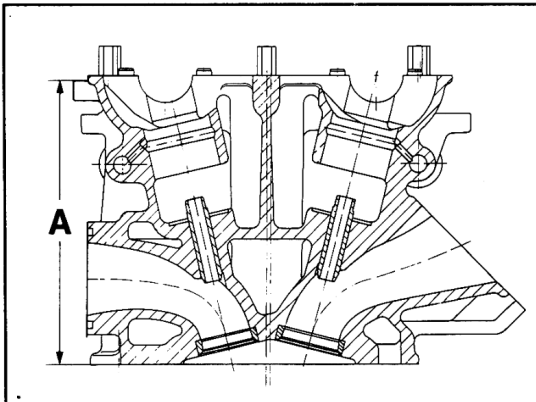
Machining the cylinder head

Reface cylinder head mating face only until the surface is level. Max. wear limit: 146,6 mm

Note for refacing the mating face:
Max. roughness = 0,015 mm

If the new-dimension tolerance is exceeded during machining, a cylinder head gasket with a thickness of 1.4 mm must be fitted.

New dimension A = 147 ± 0.1 mm
Wear limit A = 146.6 mm



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Machining dimension and identification of the cylinder head

New dimension : 147 ± 0.1 mm
Gasket : 1.1 mm
Identification : none

Refacing dimension : 146.8...146.6 mm
Gasket : 1.4 mm
Identification : N

Identification „N”

To be applied on the exhaust side between cylinder nos. 2 and 3, on the boss below the mating surface of the cylinder head cover.

Height of stamped character „N” 6 mm