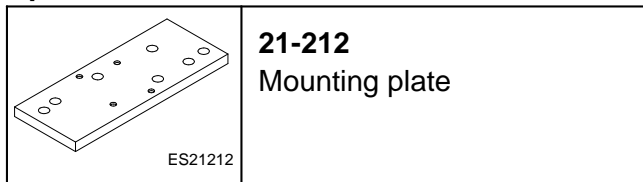


Valve Guide - Ream (one) (valve removed) (21 233 4)

Special Tools

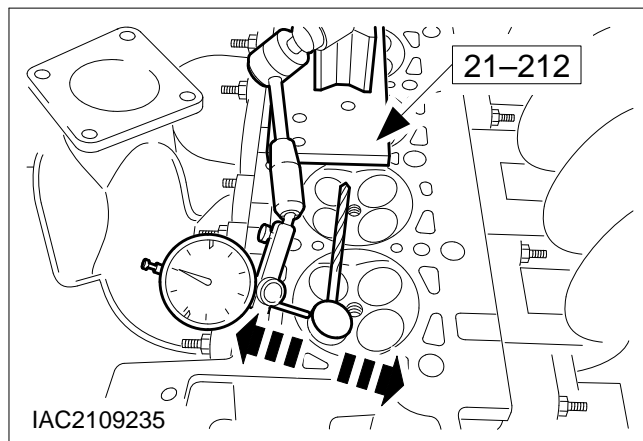


Proprietary Tools

Adjustable reamer $\varnothing 7 - 7,5$ mm
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Workshop Equipment

Dial indicator gauge with magnet holder	
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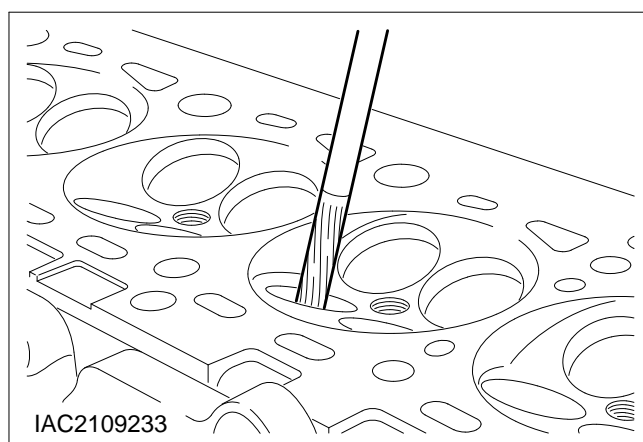


Rework

1. Install the mounting plate and dial indicator gauge.
2. Insert a 7,0 mm \varnothing drill between the valve seat ring and valve head.
3. Check the valve stem / valve guide clearance.
 - Permitted valve stem / valve guide clearance measured at valve head:
inlet 0,06 – 0,21 mm,
exhaust 0,12 – 0,29 mm.

NOTE: The dial indicator gauge must be at right angles to the valve stem.

- Put the feeler of the dial indicator gauge onto the valve head edge.
 - Measure the valve stem clearance by moving the valve from side to side.
 - If necessary, renew the valve, and/or rework the valve guide as in sub-operation 5.
4. Remove the dial indicator gauge, mounting plate and drill.



CAUTION: After reaming the valve guide, re-cut the valve seat as in Operation Number 21 231 9 and renew the valve.

NOTE: Lubricate with drilling oil.

5. Ream the valve guide.

NOTE: The specified clearance must be reached to prevent the valve from seizing.

- Ream the valve guide in several stages with an adjustable reamer to the appropriate oversize (see Technical Data).