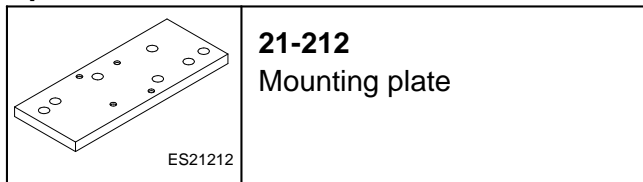


## Valve Guide – Ream (one) (valve removed) (21 233 4)

### Special Tools

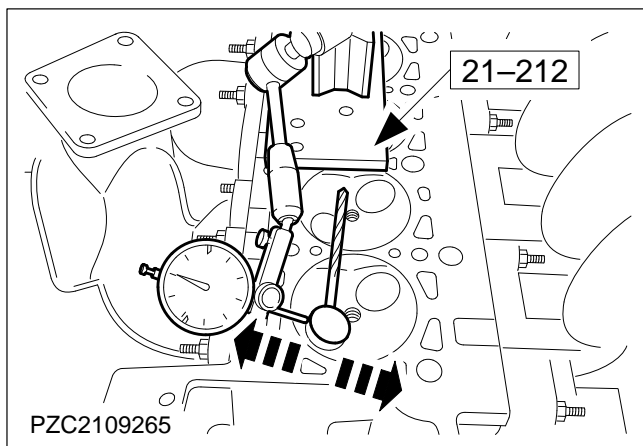


### Proprietary Tools

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

Gauge with magnetic mounting	
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### Re-machining

1. Attach mounting plate 21-212 and the dial indicator.
2. Insert a 7,0 mm drill bit between the valve seat insert and the valve head.
3. Measure valve stem/valve guide clearance.

- Permissible valve stem clearance, measured at the valve head: intake 0,06 - 0,21 mm, exhaust 0,12 - 0,29 mm.

**NOTE:** The gauge must be at 90° to the valve stem.

- Place the feeler of the gauge on the edge of the valve head.
- Determine the valve stem clearance by moving the valve to and fro.
- If necessary, renew the valve and/or re-machine the valve guide as described in relevant step.

4. Remove gauge and clamping plate, remove drill.



**CAUTION:** After reaming the valve guide, re-mill the valve seat insert as described in Operation 21 231 9 and renew valve.

**NOTE:** Lubricate with drilling oil.

5. Ream valve guide.

**NOTE:** The specified clearance must be achieved to prevent valve sticking.

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

