

V - CONTROLLI E RIPARAZIONI

Le norme si riferiscono a motori aggiornati alla data di pubblicazione del Manuale.
Controllare eventuali modifiche nella raccolta delle Circolari Tecniche.

TESTE

Non smontare la testa a caldo per evitare deformazioni. Disincrostarne i depositi carboniosi e controllare il piano d'appoggio sul cilindro. Se deformato smerigliare sul cilindro sino al ritrovamento del piano.

LEVA DECOMPRESSIONE

Se prevista vi è una leva decompressione (A - Fig. 13) su ogni testa. Controllare l'integrità dell'anello tenuta e che la camma d'alzata non sia usurata. Il diametro del perno deve essere $11,95 \pm 11,97$ mm. e l'altezza della camma $10,4 \pm 10,5$ mm. Per valori diversi sostituire il perno, rimboccolando la sede sulla testa.

BILANCIERI

Togliere il tappo sul perno. Immergere il perno in un bagno di petrolio o solvente. Asportare con una punta metallica le morchie nei condotti. Rimontare il tappo. Il gioco tra perno e fori bilancieri è $0,03 \pm 0,06$ mm. Sostituire i pezzi usurati se il gioco supera $0,1$ mm. Se la superficie a contatto con lo stelo valvola è usurata sostituire il bilanciere.

VALVOLE - GUIDE - SEDI

Dopo smontaggio e disincrostazione con spazzola metallica controllare le valvole e sostituirle se i funghi sono deformati, incrinati o usurati.

Per riadoperare valvole leggermente usurate ripristinare la fascia d'appoggio sulla sede mediante rettificatrice valvole a 45° .

Dimensioni guide, valvole e sedi dopo montaggio nella testa, mm. (Fig. 14):

Quota	Nominale	Limite
A	$8,03 \pm 8,05$	0,15 (gioco)
B	$7,98 \pm 8,00$	
C	$0,60 \pm 0,80$	0,40
D	$1,40 \pm 1,60$	2,00
S	$1,30 \pm 1,50$	0,90

Osservare che l'interno delle guide sia esente da rigature, tracce d'ingranamento o depositi carboniosi. Procedere alla pulizia con spazzolino metallico e benzina e controllare il gioco come da tabella. Le guide possono essere sostituite con altre di diametro esterno maggiorato $0,5$ mm. procedendo come segue:

- Togliere le guide usurate agendo con un punzone dal cielo della testa.
- Alzare gli alloggiamenti nella testa.
- Rettificare le guide maggiorate ad un diametro esterno superiore di $0,05 \pm 0,06$ mm. rispetto agli alloggiamenti.
- Riscaldare la testa in forno a $160 \pm 180^\circ\text{C}$.
- Forzare le guide con una pressa o con punzone (Fig. 15).
- Inserire le valvole e controllare che scorrono liberamente nelle guide con gioco $0,03 \pm 0,07$ mm.

V - OVERHAUL / CHECKS

The instructions apply to engines updated to the publication date of the Workshop Manual.
Check for possible modifications in the Service Letter File.

CYLINDER HEADS

Do not remove cylinder head when hot as this would cause deformation. Descal carbon deposits and check mating face on cylinder. If deformed, lap until face is restored.

COMPRESSION RELEASE LEVER

If provided, a pressure release lever is set on each cylinder head (A - Fig. 13). Make certain the O ring is in perfect condition and the eccentric pin is not worn. The pin diameter must be $11,95 \pm 11,97$ mm. and the height of the cam $10,4 \pm 10,5$ mm. For different dimensions replace pin and reset sleeve in the head seat.

ROCKER ARMS

Remove plug from shaft. Dip shaft in bath of oil and solvent. Remove dirt in the ducts with a metal needle. Replace plug. Clearance between rocker arms and shaft should be $0,03$ to $0,06$ mm. If clearance exceeds $0,1$ mm. replace worn parts. If surface contacting valve stem is worn, replace rocker arm.

VALVES - GUIDES - SEATS

After disassembling and descaling with a wire brush, check conditions of valves and replace them if valve heads are deformed, cracked or worn out.

To re-use slightly worn valves, we recommend restoring seat area with a 45° valve grinder.

Dimensions for valves, guides and seats after assembling in cylinder head (Fig. 14), mm.

Dimension	New	Worn Limit
A	$8,03 \pm 8,05$	0,15 (clearance)
B	$7,98 \pm 8,00$	
C	$0,60 \pm 0,80$	0,40
D	$1,40 \pm 1,60$	2,00
S	$1,30 \pm 1,50$	0,90

Check that guides bore has no scores, seizure marks or carbon deposits. Clean with wire brush and gasoline and check clearance from table above. Guides can be replaced with others having a $0,5$ oversize O.D., proceeding as follows:

- Remove worn guides with a punch from cylinder head surface.
- Ream housings in cylinder head.
- Grind oversize guides to an O.D. of $0,05 \pm 0,06$ mm. in excess to the housing dia.
- Heat up cylinder head in oven to $160^\circ \pm 180^\circ\text{C}$.
- Drive in guides with a press or punch (Fig. 15).
- Insert valves and check that they slide freely in guides with $0,03 \pm 0,07$ mm. clearance.

Lombardini 914 Parts Manual

M Tight



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