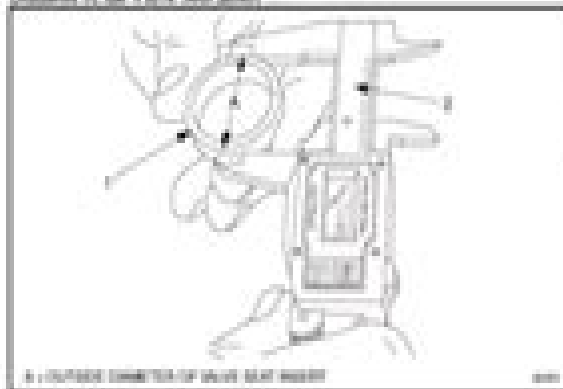


1. Valve Seat Inset 2. Measuring Device

Figure 10. Measuring the Weight of the Valve Seat Inset

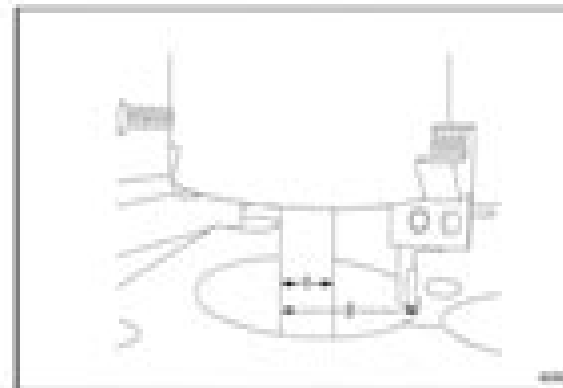
6. Measure the outside diameter of the valve seat inset. See Figure "Measuring the Outside Diameter of the Valve Seat Inset".



1. Valve Seat Inset 2. Measuring Device

Figure 11. Measuring the Outside Diameter of the Valve Seat Inset

7. Calculate the machining adjustment. See Figure "Determining the Machining Adjustment".



1. Pilot Hole Diameter (P) 2. Machining Adjustment (M)

Figure 12. Determining the Machining Adjustment



8. Choose the repair stage corresponding to the size of the outside diameter of the valve seat inset (Dimension "B" listed in Table "Repair Stage Specifications"), as measured in the previous step.

Repair Stage to Cylinder Head - Outside Diameter of Valve Seat Inset

	(See Figure 10)		(See Figure 11)	
	Inlet	Exhaust	Inlet	Exhaust
	mm (in.)	mm (in.)	mm (in.)	mm (in.)
Standard	11.000-11.020 (41.000-40.921)	11.075-11.095 (40.811-40.918)	11.075-11.095 (40.811-40.918)	11.075-11.095 (40.811-40.918)
Machined	(1.178-1.179) (1.175-1.176)	(1.1985-1.1991) (1.1775-1.1779)	(1.1985-1.1991) (1.1775-1.1779)	(1.1985-1.1991) (1.1775-1.1779)
Machined 1	11.000-11.020 (41.000-40.921)	11.075-11.095 (40.811-40.918)	(1.1985-1.1991) (1.1775-1.1779)	(1.1985-1.1991) (1.1775-1.1779)
Machined 2	(1.1985-1.1991) (1.175-1.198)	(1.1925-1.1929) (1.1905-1.1909)	(1.1985-1.1991) (1.1775-1.1779)	(1.1985-1.1991) (1.1775-1.1779)
Machined 3	11.000-11.020 (41.000-40.921)	11.075-11.095 (40.811-40.918)	(1.1985-1.1991) (1.175-1.198)	(1.1985-1.1991) (1.1775-1.1779)
Machined 4	(1.1985-1.1991) (1.194-1.195)	(1.4004-1.4008) (1.3975-1.3976)	(1.1985-1.1991) (1.175-1.198)	(1.1985-1.1991) (1.1775-1.1779)

Table 12. Repair Stage Specifications

Note: Choose the repair stage corresponding to the size of the outside diameter of the valve seat inset (Dimension "B" listed in Table "Repair Stage Specifications"), as measured in the previous step.

8. Measure the diameter of the pilot (P). See Figure "Determining the Machining Adjustment".
9. Add the diameter of the pilot to the valve seat inset and divide by two. Use the formula: $M = (A + P) / 2$. Example: If the valve seat inset is 1.178 inches, and the diameter of the pilot is 0.571 inches, $M = (1.178 + 0.571) / 2 = 1.851 / 2 = 0.926$ inches.

Mbe 9service Manual

Lei Huang



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