

Figure 05-13/1

Measures of valves (see Job No. 05-0).

1. Check out-of-true of valves at the valve disc and the valve stem on a valve tester (see Figure 05-13/2). Press the valve firmly against the backrest during measuring operation. The valve disc and the valve stem must run concentrically. The permissible max. deflection is 0.03 mm.

With a micrometer, check the wear of the valve stem. Replace the valves if the valve stem is worn or the valve head is distorted or shows cracks.

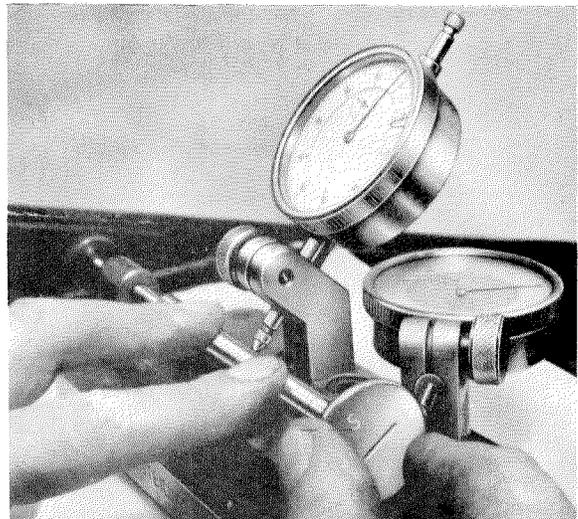


Figure 05-13/2

2. Grind the valve cone on a valve seat grinder to an angle of  $90^\circ + 30'$  without chatter marks (see Figure 05-13/3).

Valves, on which the height "h" is too small, must be replaced (see Figure 05-13/1 and Job No. 05-0).

3. If the valve stem of the valves of the OM 636 is mushroomed at the valve end "a" (see Figure 05-13/1), it can be re-ground on a valve grinder.

With the OM 621 do not fail to regrind the cap nut (7) (see Figure 05-11/4).

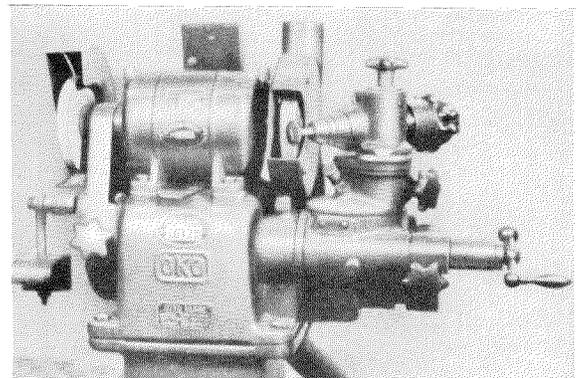


Figure 05-13/3

4. The designation and part number of the valves is marked at the stem end.