

F. Machining Valve Seats in Cylinder Head

For Models 180 a, 180 b, 190 SL, 220 a, 219, 220 S, and 220 SE this procedure is the same as described for Model 190.

Machining Dimensions for Valve Seats in Cylinder Head

| Model | 180 a, 180 b, 190 190 b, 190 SL | 220 a, 219 220 S, 220 SE |
|--|---|-----------------------------|
| Valve seat width | 1.25—1.75 | 1.25—2 |
| Valve seat angle in cylinder head | 90°—30' | |
| Permissible out-of-round of valve seat | 0.05 | |
| Backing-off of valve seat | 120° or 150°, or with backing-off cutter minimum 0.1 | |

Permissible Depth of Valve Disk in Relation to Cylinder Head Separating Surface

Models 180 a, 180 b, 190, 190 b, 190 SL, 220 a, 219, 220 S, and 220 SE

| for new valve seats | | | | for reconditioned valve seats | | | |
|------------------------------------|---------|------------------------|---------|-------------------------------|---------|---|---------|
| Minimum distance for new valves | | for reground valves | | for new valves | | Maximum distance for reground valves | |
| Inlet | Exhaust | Inlet | Exhaust | Inlet | Exhaust | Inlet | Exhaust |
| 0.8 | 16 | 1.3 | 16.8 | 1.8 | 17.2 | 2.3 | 18 |