



P01.30-0310-09

	Remove/install		
1	Remove valves		AR05.30-P-3511B
	Checking		
2	Clean valves and carry out a visual inspection	Valves with scorched valve disk, with insufficient height (h) of valve disk or with used or scored valve stem, should be replaced.	*BE05.30-P-1002-01B
3	Measure concentricity at valve stem and valve seat	Replace, if necessary ↓ Disposal of sodium-filled valves	*BE05.30-P-1009-01B OS05.30-P-0001-01A
	Machining		
4	Machine valve seats	Valve grinding machine Observe operator's manual for machining tool and adjustment angle.	*BE05.30-P-1002-01B *BE05.30-P-1003-01B *BE05.30-P-1008-01B
5	Once again measure stroke at valve stem and valve seat	Replace valve if the stroke is too large or the height is (h) is too small	*BE05.30-P-1009-01B
6	Replace valve, check for leaks	Vacuum testing unit	
7	Install in the reverse order		

Check values for valves

Number	Designation			Engine 604.91, 605.91, 606.91 up to 10/94	Engine 604.91, 605.91, 606.91 as of 11/94	Engine 605.96, 606.96
				BE05.30-P-1001-01B	Valve disk dia. (D)	Exhaust
		Intake	mm	28.90 to 29.10	28.90 to 29.10	28.90 to 29.10
		See picture		-	-	-
BE05.30-P-1002-01B	Height of valve disk (h)	Exhaust	mm	1.0 to 1.2	1.0 to 1.2	1.0 to 1.2
		Intake	mm	1.0 to 1.2	1.0 to 1.2	1.0 to 1.2

		See picture	-	-	-	
BE05.30-P-1003-01B	Valve seat angle (α)	Exhaust	\sphericalangle°	45° -15'	45° -15'	45° -15'
		Intake	\sphericalangle°	45° -15'	45° -15'	45° -15'
		See picture		-	-	-
BE05.30-P-1004-01B	Valve stem dia. (D 1)	Exhaust	mm	5.955 to 5.97	6.955 to 6.97	6.955 to 6.97
		Intake	mm	5.960 to 5.975	5.960 to 5.975	5.955 to 5.97
		See picture		-	-	-
BE05.30-P-1005-01B	Valve seat armor plating without \Rightarrow 1 with \Rightarrow 2	Exhaust		1	1	2
		Intake		-	-	1
BE05.30-P-1006-01B	Sodium filling without \Rightarrow 1 with \Rightarrow 2	Exhaust		1	1	2
		Intake		-	-	1
BE05.30-P-1007-01B	Length of valve (L)	Exhaust	mm	105.5 to 105.9	105.5 to 105.9	105.5 to 105.9
		Intake	mm	105.2 to 105.6	105.2 to 105.6	105.2 to 105.6
		See picture		-	-	-
BE05.30-P-1008-01B	Width of valve seat	Exhaust	mm	1.9	1.9	1.9
		Intake	mm	1.9	1.9	1.9
BE05.30-P-1009-01B	Concentricity of valve seat to valve stem	Exhaust	mm	≤ 0.03	≤ 0.03	≤ 0.03
		Intake	mm	≤ 0.03	≤ 0.03	≤ 0.03
BE05.30-P-1010-01B	Identification on end of stem	Exhaust		A 606 05/06	A 606 05/07	A 606 13
		Intake		E 606 11	E 606 11	E 606 11