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Valves on which the dimension  $h$  of the valve-head is less than 0.8 mm in the case of the inlet valve and 1.5 mm in the case of the exhaust valve, must be replaced.

3. If the valve stem is mushroomed at the foot "a", it can be re-ground on a valve cone grinder.

The minimum permissible hardness of the surface "a" is 55 HRC.

4. The type and part number of the valves is stamped on the end of the stem.

## B. Testing Valve Springs

The valve springs should be tested either with Spring Test Gage 000 589 00 65 or with some other suitable spring tester. After measuring the free length  $L$ , the loads  $P_1$  and  $P_2$  for the lengths  $L_1$  and  $L_2$  must be measured in the case of each spring. If the permissible load tolerances are exceeded, the faulty spring must be replaced.

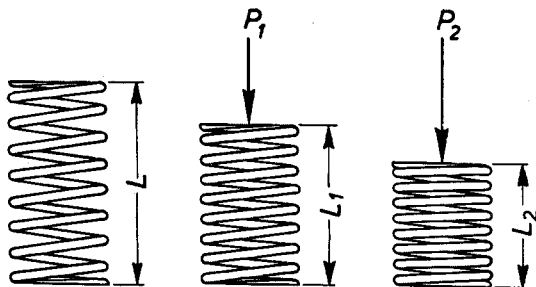


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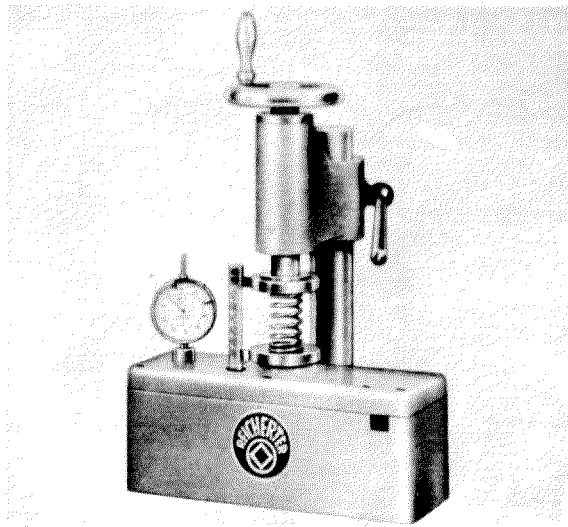


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### Testing Table for Valve Springs

	External diameter	Spring wire section	Length L free	Length $L_1$ Load $P_1$ depressed		Length $L_2$ Load $P_2$ under final load	
	mm	mm	mm	mm	kg	mm	kg
Inner spring	20.7	2.6	42	34.2	8.9	25.7	$18.6^{+2}_{-1}$
Outer spring	30.6	4	42	38.4	23.1	29.9	$45.9^{+4.5}_{-2.2}$