

## Valve Guide, Ream (Z22 SE, Z20 LET)

Special service tools required:

Reamer Set KM-805. (Z20 LET).

Reamer Set KM-6022. (Z22 SE)



### Measure

Preconditions: The valve guide and valve are measured. Valve stem play is determined. See "Valve Stem Wear, Measure (Z22 SE, Z20 LET)"

### Caution

Oversize valves may already be fitted in production.

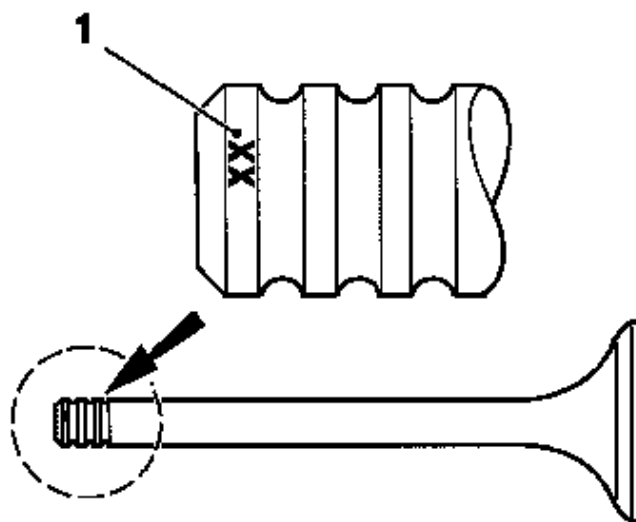
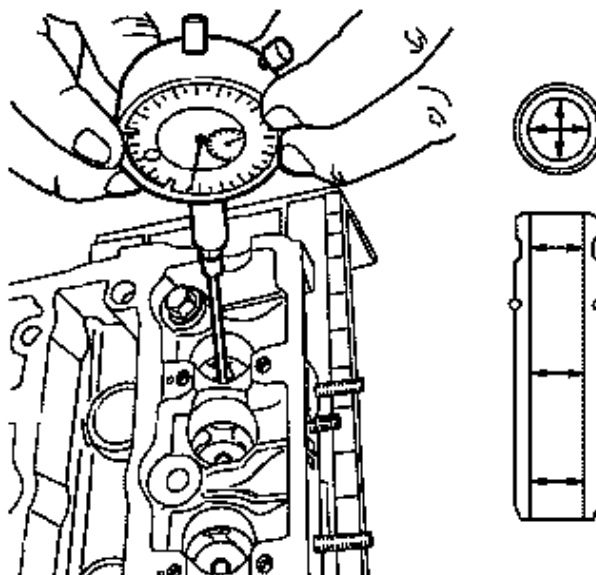


### Inspect

Oversize identification:

Markings (code numbers/letters) are located on valve guide and valve stem end.

The oversize identifications (1) can be found in the "Technical Data" – "Cylinder Head (Z22 SE)" or "Technical Data (Z20 LET)".



L 6716

Survey of Relevant Reamers:

Valve guide diameter in mm	6 mm
0.012 (Oversize) (Z22 SE)	KM-6022
0.075 (Oversize) (Z20 LET)	KM-805

**Caution**

Reamers have a left-hand twist and must always be screwed both in and out clockwise. Never turn the reamers backwards (anti-clockwise). The shavings produced during material removal would become trapped and destroy the cutting edges.

**Procedure**

Ream valve guide from upper side of cylinder head to next oversize.

Screw reamer evenly into the valve guide exerting light pressure. Visually inspect the valve guide after reaming (chatter marks). The old identification must be obliterated (if present), and a new identification must be embossed.

**Clean**

Residual material must be removed from the valve guides and cylinder head after reworking.