

Valve Seat Cut, Cylinder Head (Z 22 SE, Z 20 LET)

Special service tools required:

Valve Seat Cutter Set **KM-340-G, KM-340-100**

Note: For use of Valve Cutter Set, consult the accompanying instructions.

The guide drift is identical for the intake and exhaust sides.

Valve stem Ø	Guide Drift
5 mm	KM-340-30, KM-340-100-3
6 mm	KM-340-27, KM-340-100-4
7 mm	KM-340-7
8 mm	KM-340-23

Angle	Cutter
	for Petrol Engines
15°	KM-340-26, -28
30°	KM-340-11, -12, -13, -29, KM-340-100-1
45°	KM-340-11, -12, -13, -29, KM-340-100-2
60 °	KM-340-26, -28



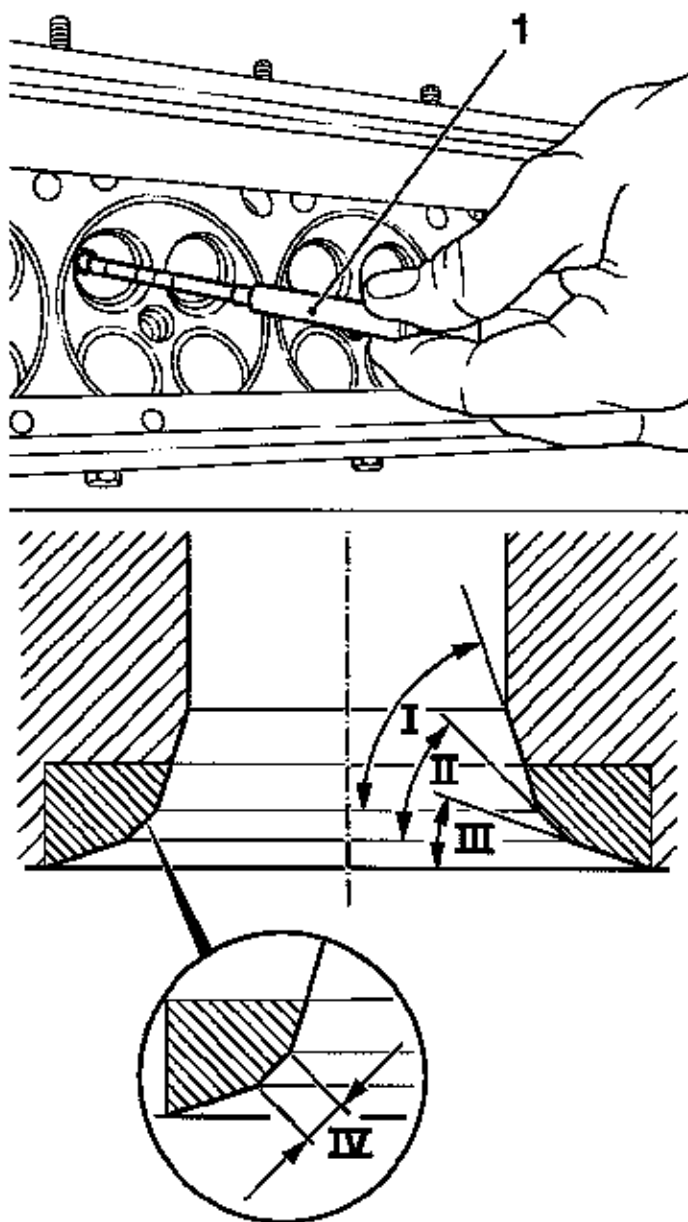
Install

Insert guide drift (1) from valve cutter set in the valve guide and tension. Ensure that the guide drift is inserted to 2 - 3 mm from the stop only. Ensure that the valve guides are OK. These are used to hold the guide drift.

Procedure

Sequence of operations:

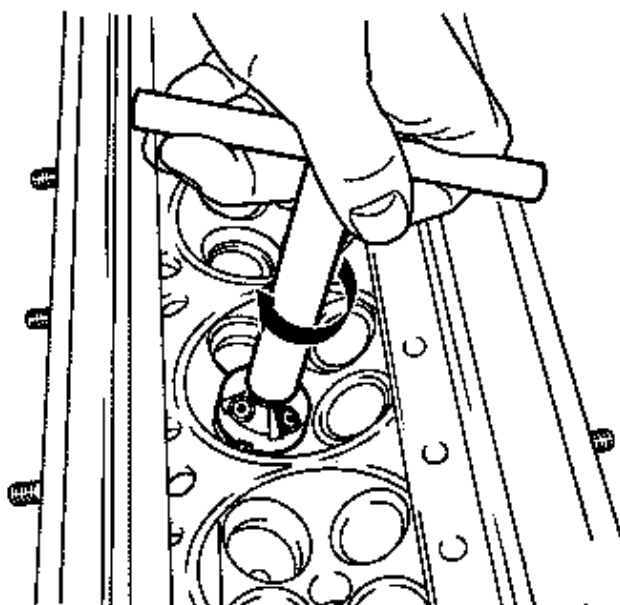
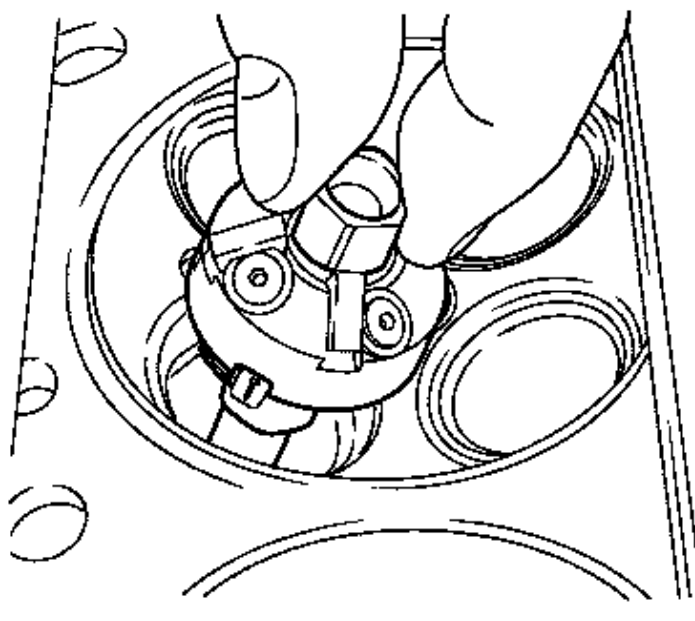
- I Lower correction angle
- II Valve seat angle
- III Upper correction angle
- IV Valve seat width

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Slide the cutter over the guide drift at the specified angle. Install turning knob.

Procedure

Cut valve seats and correction angle clockwise exerting light pressure.

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Release guide drift (1) and remove from valve guide. The valve seat contact pattern is checked using a new valve and blue ink.

- I. Lower correction angle
- II. Valve seat angle
- III. Upper correction angle
- IV. Valve seat width

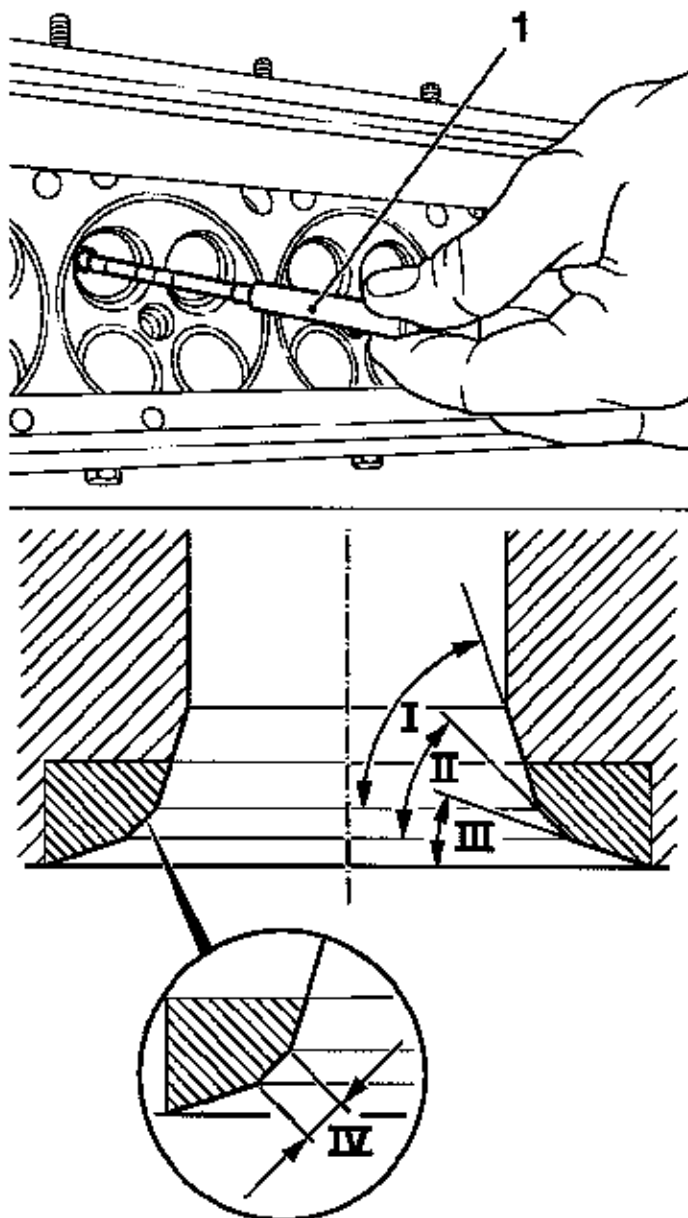
The valve width dimensions can be found in the "Technical Data".

After cutting the valve seat, the valve indentation/installation height of valves must be checked.

**Clean**

Clean cylinder head after completing operations.

The valves must be ground and ground-in before installation.

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