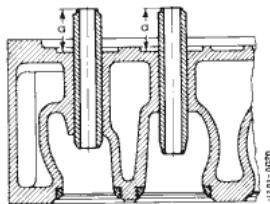
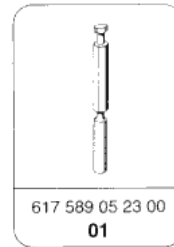
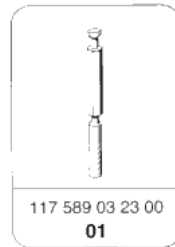
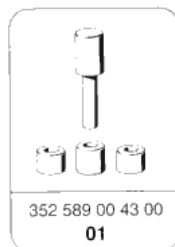
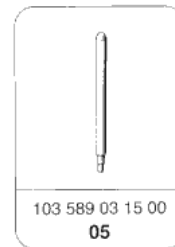
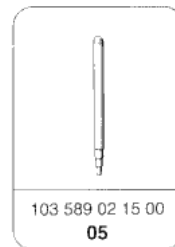


Technical data

Valve guides

Valve guide	Repair stage mm	Outside dia. mm	Bore in cylinder head mm	Interference fit mm	Inside \varnothing mm	Length mm	Distance "a" from valve guide to support of valve spring
1 Inlet	Normal	15,046 15,028	15,018 15,000	+ 0,010 to + 0,046	9,022 9,000	72 ¹⁾	17,5 – 0,5 ¹⁾ 
2 Exhaust	Repair stage I	15,246 15,228	15,218 15,200		10,022 10,000	68 ¹⁾	

1) Valve guides, shortened, with groove for retrofitting valve stem seals.

Special tools 

X7

Test

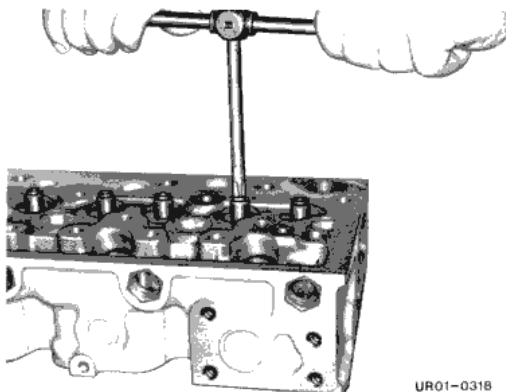
01/146

1 Disassemble cylinder head, see 5.1/1 (K 04).

01/147

2 Clean valve guide, remove oil carbon residues.

B 000 589 10 53 00
000 589 11 53 00

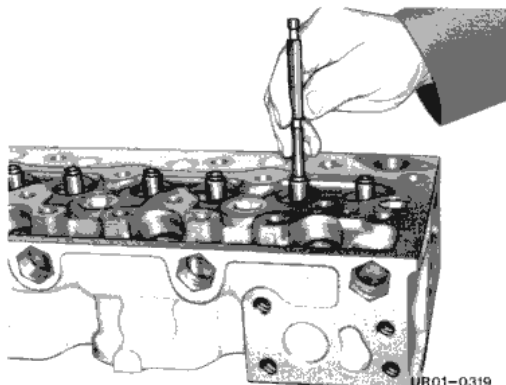


UR01-0318

01/148

3 Check bore.

B 117 589 03 23 00
617 589 05 23 00



UR01-0319

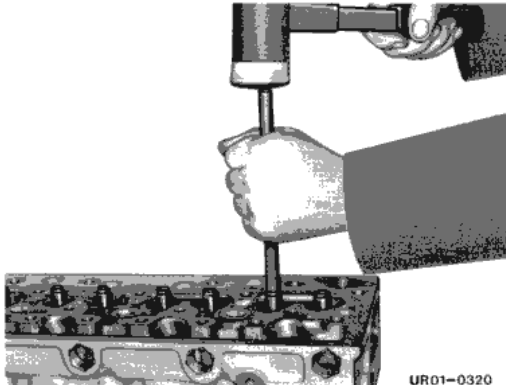
X9

Exchange

01/149

1 Drive out valve guide.

B 103 589 02 15 00
103 589 03 15 00



UR01-0320

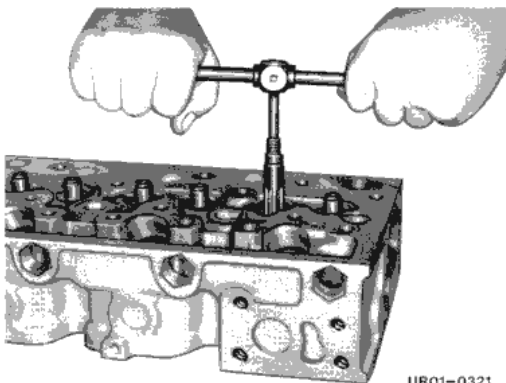
01/150

2 Clean and check basic bore in cylinder head.

01/558

3 If valve guides of the repair stage must be installed, the basic bore is to be reamed to the repair stage.

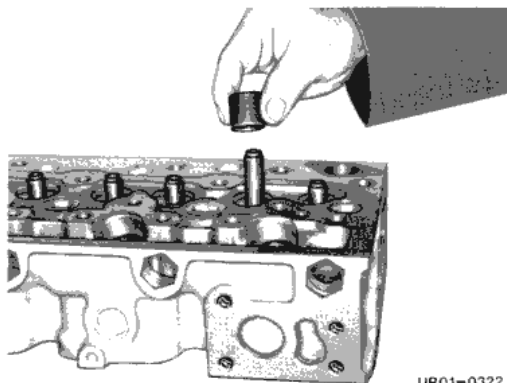
B 000 589 18 53 00




UR01-0321

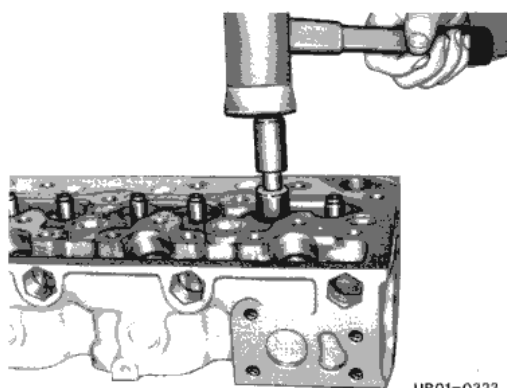
.T
01.26.1/2
6.1/2

- 01/152 **4** Select valve guide so that specified interference fit of + 0,010 to + 0,046 mm is maintained.
- 01/153 **5** Heat cylinder head in a hot water bath to 80°C.
- 01/154 **6** Coat new valve guide with graphite oil and position in cylinder head bore.
- 01/819 **7** Slide spacer sleeve from special tool onto valve guide.
- 01H251 **Note:** The spacing of the valve guides up to the contact surface, valve spring of 17,5 – 0,5 mm is maintained by the corresponding spacer sleeve.




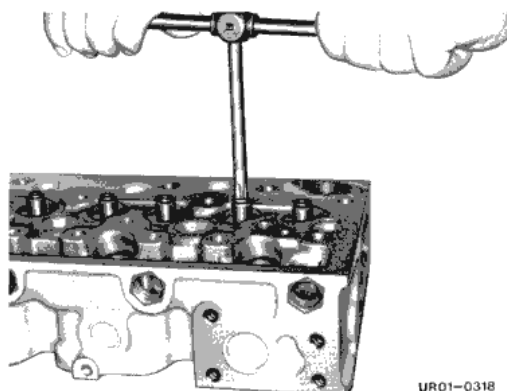
UR01-0322

- 01/156 **8** Knock valve guide in.
 352 589 00 43 00




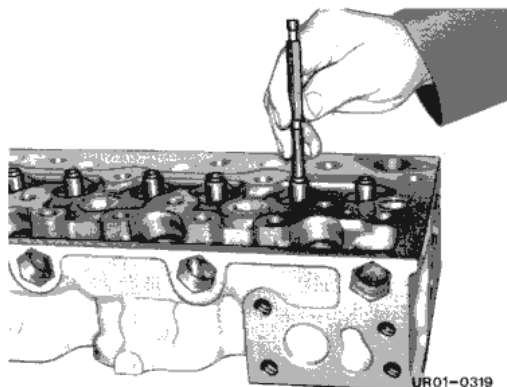
UR01-0323

- 01/157 **9** Ensure valve guide are firmly seated. Knock out loose valve guides and replace with valve guides with larger outer diameter.
- 01/158 **10** Ream inside diameter of valve guide.
 000 589 10 53 00
 000 589 11 53 00



UR01-0318

- 01/159 **11** Check inside diameter of valve guide.
 117 589 03 23 00
 617 589 05 23 00
- 01/160 **12** Assemble cylinder head, see 5.1/1 (K 04).



UR01-0319