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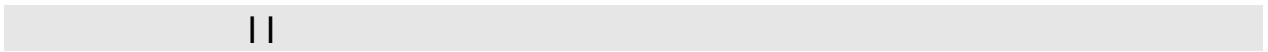
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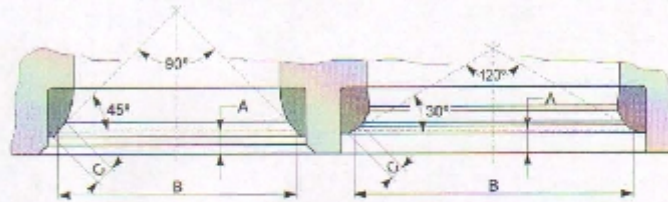
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ADJUSTMENT VALUES

4.5.2 4-valve cylinder heads and valves

Thickness of cylinder head gasket	
Before installation, approx.	1.55 to 1.75 mm
Installed and tightened	1.163 to 1.297 mm
Cylinder head height	
Normal	114.0 mm -0.1
Minimum	112.9 mm
Surface roughness of cylinder head/crankcase mating surface	0.008 to 0.016 mm
Valve seat angle	
D 28.. engines with 4-valve cylinder heads	
Intake	30° or total \angle 120°
Exhaust	45° or total \angle 90°



Theoretical valve seat in the cylinder head

Intake	A = 3.58 mm +0.1 B = \varnothing 44 mm C = 1.50 mm +0.5
Exhaust	A = 4.00 mm +0.1 B = \varnothing 44 mm C = 1.50 mm +0.5

Valve lag

Intake	0.60 mm
Exhaust	0.81 mm

Valve stem diameter ①

Intake	8.970 mm \pm 0.007
Exhaust	8.957 mm \pm 0.007

Conical face ②

Intake	2.50 mm +0.5
Exhaust	2.50 mm +0.5

Valve seat (= grinding face)

Intake	1.50 mm +0.5
Exhaust	1.50 mm +0.5

Valve head diameter ③

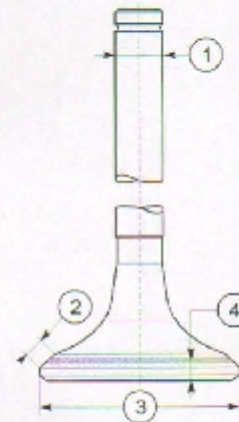
Intake	46.0 mm +0.1
Exhaust	46.0 mm +0.1

Valve head height ④

Intake	2.78 mm \pm 0.1
Exhaust	3.19 mm \pm 0.1

Wear limit

Wear limit	0.5 mm less than basic dimension
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3	108625105	HIDROMOTOR, HIDROPOGONA VENTILATORA IK	0.511.725.021		20

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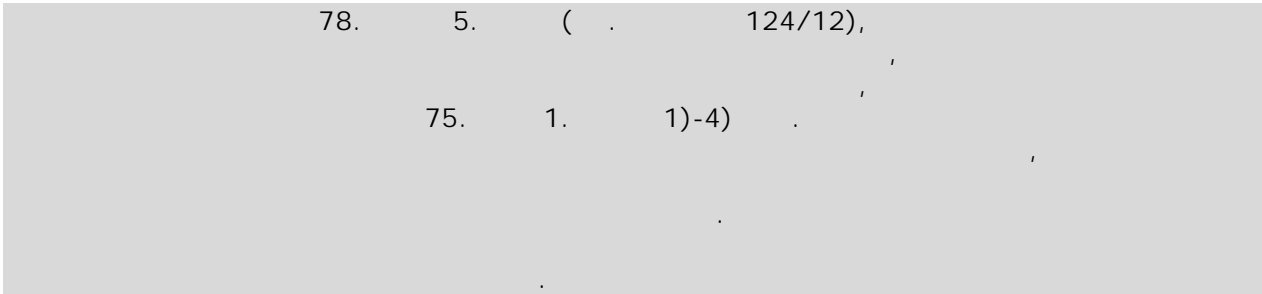
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