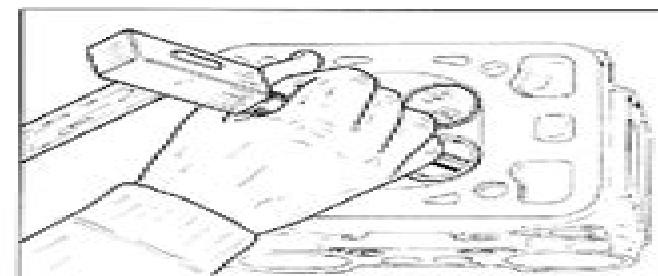




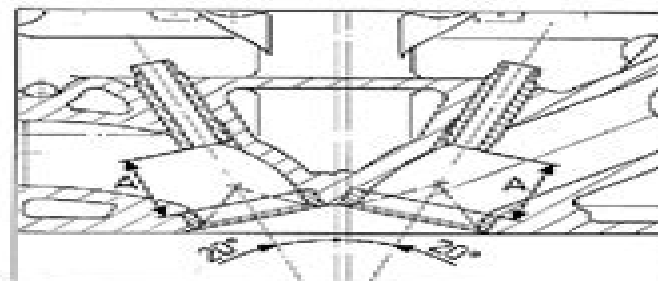
Sostituzione del guidavalvola.

Se necessità sostituire il guidavalvola è necessario riscaldare lentamente ed uniformemente la testa in un forno fino alla temperatura di 200°C e sfilare il guidavalvola utilizzando il punzone **88713.0879**; lasciar raffreddare e controllare le condizioni della sede. Scegliere il guidavalvola più adatto considerando una interferenza di montaggio con la testa di 0,022÷0,051 mm; vengano forniti a ricambio con maggiorazione sul diametro esterno di 0,03, 0,06 e 0,09 mm. Riscaldare nuovamente la testa e raffreddare con ghiaccio-secco il guidavalvola nuovo. Utilizzando gli appositi punzoni **88713.0875** (ASPIRAZIONE) e **88713.0874** (SCARICO) installare il guidavalvola, dopo aver lubrificato la sede, facendo riferimento alla quota riferita alla sezione a lato riportata:
 $A = 25,35 \pm 25,65$ mm (**916**).
 $A = 26,35 \pm 26,65$ mm (**748**).
 Lasciar raffreddare la testa e procedere alla alesatura del foro interno.



Valve guide replacement.

To replace valve guide, heat head in an oven slowly and evenly up to 200°C./392°F., then remove valve guide with punch **88713.0879**. Leave head to cool, then check valve guide seat conditions. If valve guide needs replacement, select a suitable valve guide, considering that interference fit to head should be 0,022÷0,051 mm./0,0008÷0,0020 in. Replacement valve guides are available with outside diameter oversized by 0,03, 0,06 and 0,09 mm. Heat head again and cool replacement valve guide in dry ice. Use suitable punches **88713.0875** (INTAKE) and **88713.0874** (EXHAUST), to install valve guide into the lubricated seat, making sure the dimension given below (see cross-section in figure) is respected:
 $A = 25,35 \pm 25,65$ mm./0,998÷1,009 in. (**916**).
 $A = 26,35 \pm 26,65$ mm./1,037÷1,049 in. (**748**).
 Leave head to cool, then bore the inner hole.



Remplacement du guide-soupape.

Pour remplacer le guide-soupape, adopter la procédure suivante: chauffer lentement et uniformément la tête dans un four jusqu'à 200°C et extraire le guide-soupape en utilisant l'outil **88713.0879**; laisser refroidir, puis contrôler les conditions du siège. Choisir le guide-soupape le plus approprié en tenant compte d'une interférence de montage avec la tête de 0,022÷0,051 mm; ils sont livrés comme pièces détachées avec un diamètre extérieur majoré de 0,03, 0,06 et 0,09 mm. Réchauffer la tête et refroidir le nouveau guide-soupape avec de la neige carbonique. En utilisant les outils **88713.0875** (ASPIRATION) et **88713.0874** (DECHARGE), installer le guide-soupape, après avoir lubrifié le siège, en se référant à la section indiquée sur la figure ci-contre:
 $A = 25,35 \pm 25,65$ mm (**916**).
 $A = 26,35 \pm 26,65$ mm (**748**).
 Laisser refroidir la tête et aléser le trou interne.

Austausch der Ventilführung.

Muß man die Ventilführung austauschen, ist wie folgt vorzugehen: den Zylinderkopf in einem Ofen langsam und gleichmäßig bis auf eine Temperatur von 200°C erwärmen und die Ventilführung unter Anwendung des Stempels **88713.0879** herausnehmen; abkühlen lassen und den Zustand des Sitzes prüfen. Nun die geeignete Ventilführung, unter Berücksichtigung eines Montagebemaßes mit den Zylinderkopf von 0,022÷0,051 mm, wählen. Alle Führungen werden als Ersatzteile mit einem überdimensionierten Außendurchmesser von 0,03, 0,06 und 0,09 mm geliefert. Den Zylinderkopf wieder erwärmen und die neue Ventilführung mit Trockeneis kühlen. Nachdem man den Sitz eingeschmiert hat, die Ventilführungen mit den geeigneten Stempeln **88713.0875** (EINLAß) und **88713.0874** (AUSLAß) montieren; dabei ist sich an die zugehörige Quote des Querschnittes zu halten, siehe Abbildung:
 $A = 25,35 \pm 25,65$ mm (**916**).
 $A = 26,35 \pm 26,65$ mm (**748**).
 Den Kopf abkühlen lassen, dann das innere Loch ausbohren.

Reemplazo guía-válvula.

Para sustituir el guía-válvula es necesario calentar la culata lenta y uniformemente en un horno hasta la temperatura de 200°C y sacar el guía-válvula con el punzón **88713.0879**; dejar que se enfríe y controlar las condiciones del alojamiento. Elegir el guía-válvula más adecuado considerando que la interferencia de montaje con la culata deberá ser de 0,022÷0,051 mm. Los guía-válvulas se suministran como recambio con aumentos del diámetro externo de 0,03, 0,06, 0,09 mm. Calentar otra vez la culata y enfriar con hielo seco el nuevo guía-válvula. Montar los guía-válvulas con la ayuda de los punzones **88713.0875** (ASPIRACION) y **88713.0874** (ESCAPE) después de haber lubrificado el alojamiento refiriéndose al valor de la sección indicado en la figura al lado:
 $A = 25,35 \pm 25,65$ mm (**916**).
 $A = 26,35 \pm 26,65$ mm (**748**).
 Dejar que la culata se enfríe y proceder con el escaariado del agujero interior.

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