

## F. Machining Valve Seats in Cylinder Head

For Models 180 a, 180 b, 190 SL, 220 a, 219, 220 S, and 220 SE this procedure is the same as described for Model 190.

### Machining Dimensions for Valve Seats in Cylinder Head

Model	180 a, 180 b, 190 190 b, 190 SL	220 a, 219 220 S, 220 SE
Valve seat width	1.25—1.75	1.25—2
Valve seat angle in cylinder head	90°—30'	
Permissible out-of-round of valve seat	0.05	
Backing-off of valve seat	120° or 150°, or with backing-off cutter minimum 0.1	

### Permissible Depth of Valve Disk in Relation to Cylinder Head Separating Surface

Models 180 a, 180 b, 190, 190 b, 190 SL, 220 a, 219, 220 S, and 220 SE

for new valve seats				for reconditioned valve seats			
Minimum distance for new valves		for reground valves		for new valves		Maximum distance for reground valves	
Inlet	Exhaust	Inlet	Exhaust	Inlet	Exhaust	Inlet	Exhaust
0.8	16	1.3	16.8	1.8	17.2	2.3	18