

Valve Milling Cutter



GENERAL

Due to the hardness of the valve seats, they have to be processed with special milling cutters.

The milling cutter set includes the most needed milling cutters for the seating, a milling cutter for the upper and a milling cutter for the lower correction angle.

The objective of processing the valve seats is to clean the sealing surface to adapt one of the seats to the dimensions required by the vehicle manufacturer.

Because of the sealing the valve seat may not be too wide, and because of good heat transfer not too narrow.

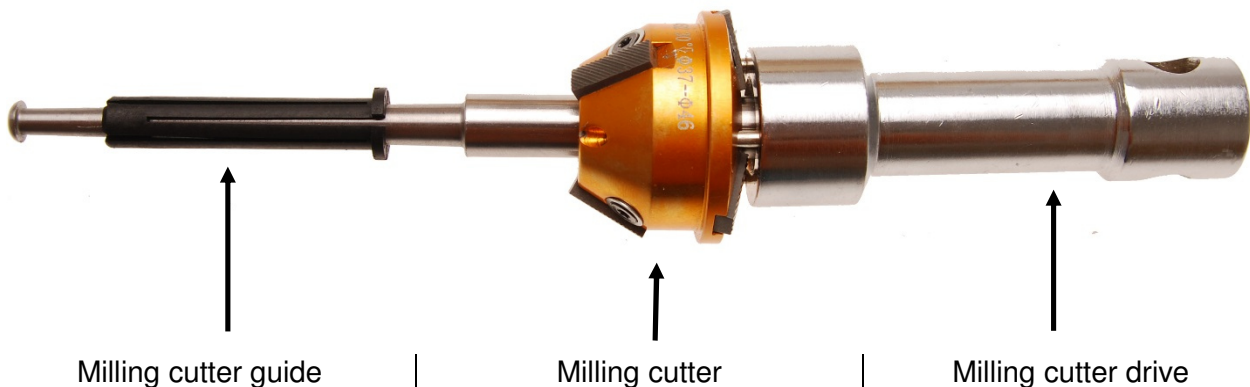
NOTES ON SAFETY

During milling always wear a respiratory protection mask which prevents any inhalation of abrasion deposits e.g. coking, carbon deposits etc..

In case of utilization of compressed air for cleaning, always wear protective goggles in addition.

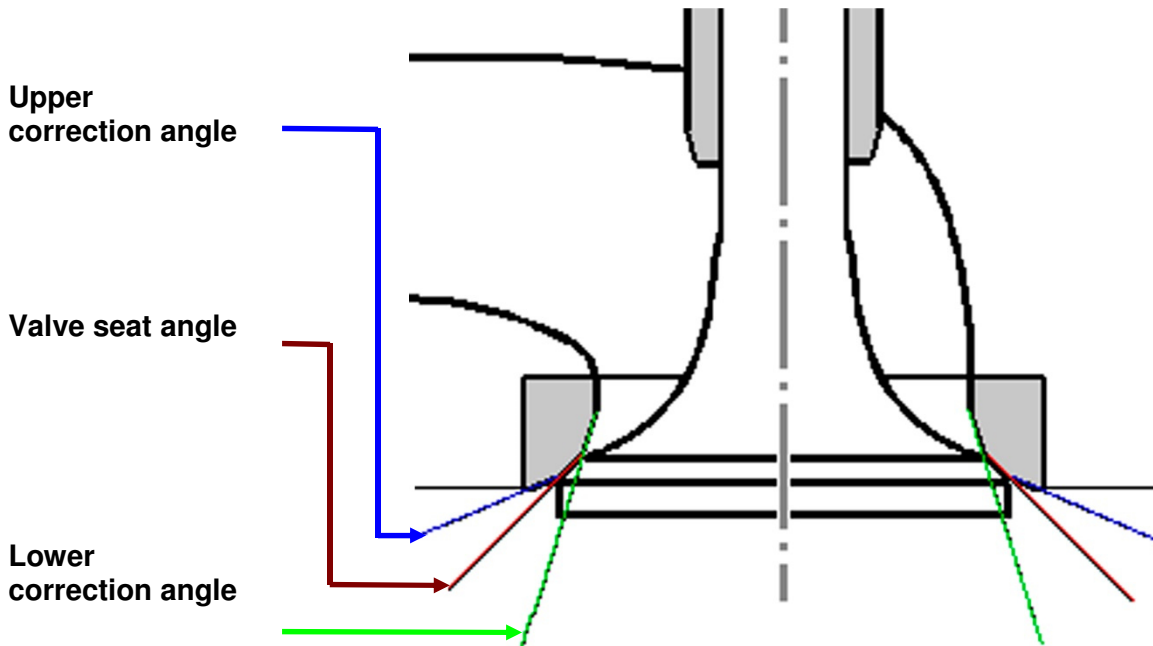
Always note the recommendations of the vehicle manufacturer. Information about valve seating width etc. can be taken from vehicle-specific service literature.

Processing of valve seats should be carried out by a trained specialist only.



Milling cutter guide

This guides the milling cutter exactly centrally with respect to the valve shaft guide.



Milling cutter

In case of the milling of valve seats, milling cutters with different angles are mostly used.

The valve seat can be reprocessed in case of a cylinder head overhaul.

During milling, the pressure is to be applied exactly vertically from above.

Processing is only to be carried out up to the point that a uniform, non-porous seating is achieved without any chatter marks.

In order to carry out corrections, the upper and lower correction milling cutters are employed.

The milling must be implemented uniformly and carefully and only for so long until the valve seat has reached the prescribed width.

Note: As a result of milling the valve seat, it becomes wider; by milling the correction angles, the seat becomes narrower.

Caution:

- Valves must be ground in with an abrasive compound after the processing of the valve seats.
- Check the valve seats for sealing before the installation of the cylinder head.

