

Installation (ship): Recon

Cylinder head No.: 5461

Engine type: Wartsila 22

Engine No.:

Ordre Nr: P2391

RECONDITIONING OF CYLINDER HEAD

1. Cleaning and washing:

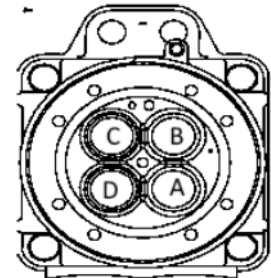
- Sand Blast Machine
- Washing Machine
- Pressure Washing

2. Pressure testing

- Pressure tested air 4 Bar
- Pressure tested water Bar

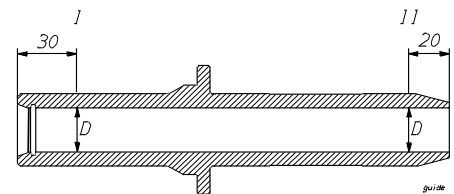
3. Recon of valves and seat rings

	A	B	C	D
Grinding of valves	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
Grinding of valve seat rings	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
Change of valves	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>
Change of valve seat rings	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>
Rotocaps renewed	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
Oversize valve seat			1,5	1
Angle (deg.)	20		30	
Change of valve guides	<input type="checkbox"/>	<input type="checkbox"/>	<input checked="" type="checkbox"/>	<input type="checkbox"/>
Drill of holes	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>



Exh out ↓ ↑ Air in

VALVE GUIDES



Nominal diameter:
Reference diameter:
Deviations in 1/100 mm.

Wear limit:

4. Injection valve sleeve

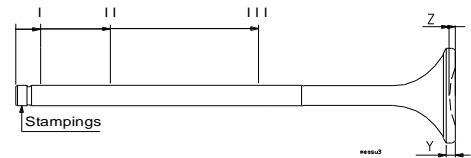
- Valve sleeve renewed
- Valve sleeve reused

INLET	A	I	10	EXHAUST	D	I	10
		II				II	
B	I	10	C	I	New		
		II					

5. Starting valve:

- Visual inspection / cleaning
- Overhaul of starting valve

VALVES



6. Safety valve:

- Visual inspection / cleaning
- Overhaul of safety valve Bar

7. Lapping of sealing surface

Min x Dia valve surface inlet
Min x Dia valve surface Exh
Burn-off area: Z max=
Valve Y – Min
Max Outer Dia valve seat:

Stem stampings	Valve location
	A
	B
	C
	D

8. Machining of sealing surface

0,20/100mm

Reference diameter

Wear limit valve stem

10. Valve spring Inspection

Deviations to be given in 1/100 mm.

11. Valve yoke:
Adjusted

INLET	A	I	New	EXHAUST	D	I	New
		II				II	
B <th rowspan="2">I</th> <td>New</td> <th rowspan="2">C</th> <th rowspan="2">I</th> <td>New</td>	I	New	C	I	New		
		II				II	
C	III		III				
	Z		Z				
	Y		Y				
	Y		Y				

12: Tightening with torque:

- Injection valve
- Starting valve
- Rocker arm
- Safety valves