

Installation (ship): Sulzer
 Engine type: Sulzer

Cylinder head No.: Vms Recon 3109
 Engine No.:

Ordrenr: 11662

RECONDITIONING OF CYLINDER HEAD

1. Cleaning and washing:

- Sand Blast Machine
- Washing Machine
- Pressure Washing

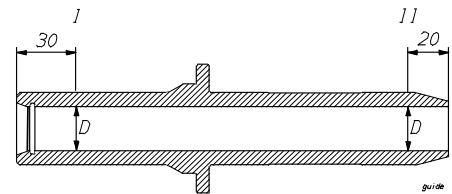
2. Pressure testing

- Pressure tested air 4 Bar
- Pressure tested water Bar

3. Recon of valves and seat rings

- | | A | B | C | D |
|------------------------------|-------------------------------------|-------------------------------------|-------------------------------------|-------------------------------------|
| Grinding of valves | <input checked="" type="checkbox"/> | <input checked="" type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> |
| Grinding of valve seat rings | <input type="checkbox"/> | <input type="checkbox"/> | <input checked="" type="checkbox"/> | <input checked="" type="checkbox"/> |
| Change of valves | <input type="checkbox"/> | <input type="checkbox"/> | <input checked="" type="checkbox"/> | <input checked="" type="checkbox"/> |
| Change of valve seat rings | <input checked="" type="checkbox"/> | <input checked="" type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> |
| Rotocaps renewed | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> |
| Oversize valve seat | | | | |
| Angle (deg.) | 30 | | 30 | |
| Change of valve guides | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> |

VALVE GUIDES



Nominal diameter: **Wear limit:**
 Reference diameter:
 Deviations in 1/100 mm.

4. Injection valve sleeve

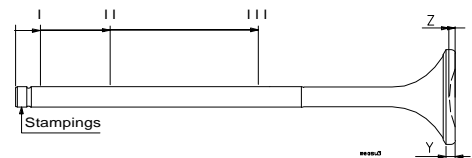
- Valve sleeve renewed
- Valve sleeve reused

INLET	A	I	12	EXHAUST	D	I	9
		II				II	
B	B	I	8	C	C	I	13
		II				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

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Min x dia valve surface inlet
 Min x dia valve surface exh
 Burn-off area: Zmax=
 Valve Y - Min
 Max outer dia valve seat:

8. Machining of sealing surface

- /100mm

Stem stampings	Valve location
	A
	B
	C
	D

9. Rotocap:

- Inspection no overhaul
- Inspection full overhaul

Reference diameter

Wear limit valve stem 23.95 mm

10. Valve spring Inspection

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Deviations to be given in 1/100 mm.

INLET	A	I	19.99	EXHAUST	A	I	New
		II				II	
		III				III	
		Z	0			Z	
		Y	5.9			Y	
B	B	I	19.99	B	B	I	New
		II				II	
		III				III	
		Z				Z	
		Y	5.6			Y	

11. Valve yoke:

- Adjusted

12: Tightening with torque:

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