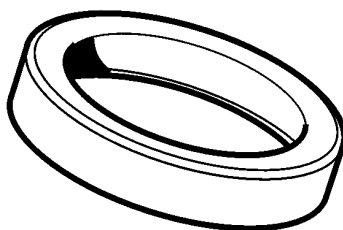


This Service Bulletin replaces SB 211-63, "Valve Seat, Replacement" dated 9.2007, publication no. PV776-20179577.

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Valve Seat, Replacement (One)
D11F, D13F, D16F

Valve Seat, Replacement (One)



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T2020015

Note: Information is subject to change without notice. Illustrations are used for reference only and may differ slightly from the actual vehicle being serviced. However, key components addressed in this information are represented as accurately as possible.

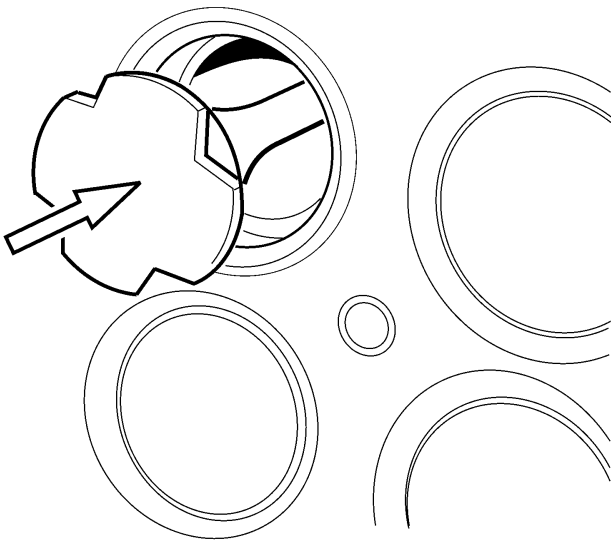
2149-03-05-01 Valve Seat, Replacement (One)

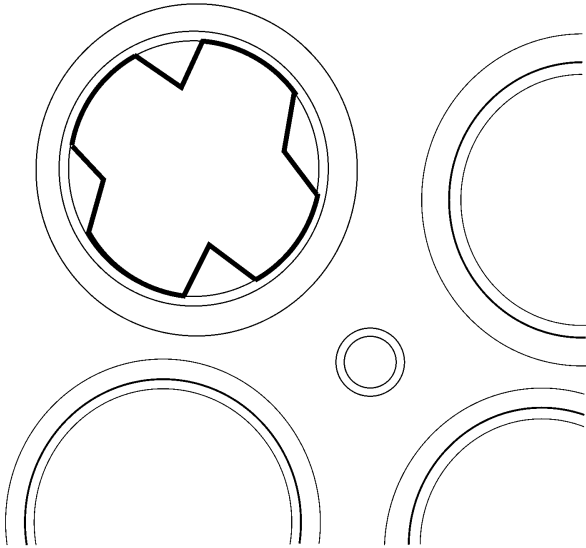
You must read and understand the precautions and guidelines in Service Information, group 20, "General Safety Practices, Engine" before performing this procedure. If you are not properly trained and certified in this procedure, ask your supervisor for training before you perform it.

Note: There are different variants of valves and valve seats. These variants cannot be combined. Later inlet valve variants are most easily identified by the fact that they are magnetic, and by checking the part number. Exchange cylinder heads are of the later variant with non-magnetic inlet valves.

1
Grind four (4) "V" slots into the old valve to allow for the seat and valve to be welded together.

2
Insert the valve into the seat to be removed.

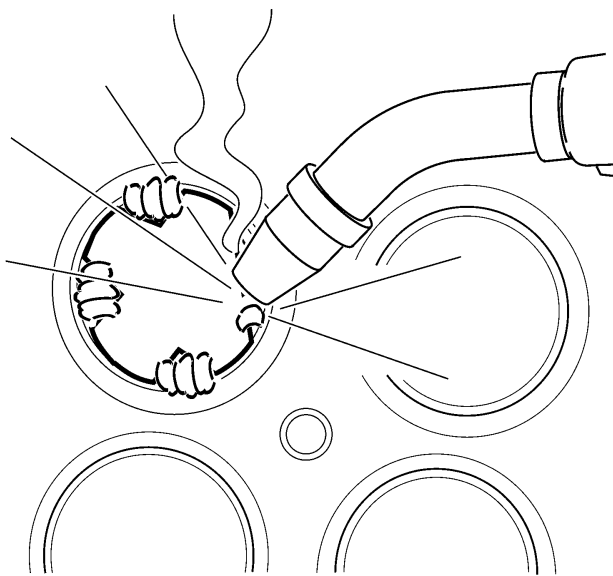




W2006311

3

Note: Only experienced welders should attempt this procedure. Use caution to cover the cylinder head to prevent damage while welding.

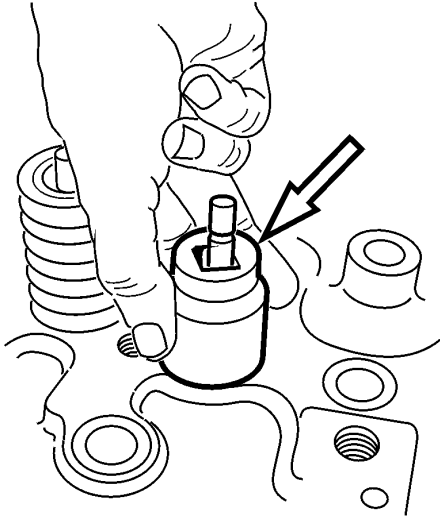


W2006312

4

Weld a small bead on all four (4) "V" slots on the valve to secure valve and seat together.

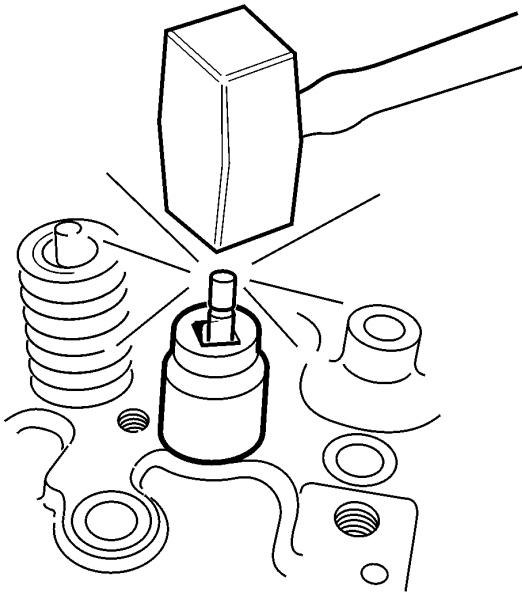
- 5**
Cover the valve stem guide with the proper size and length socket to protect guide from damage.



T2020012

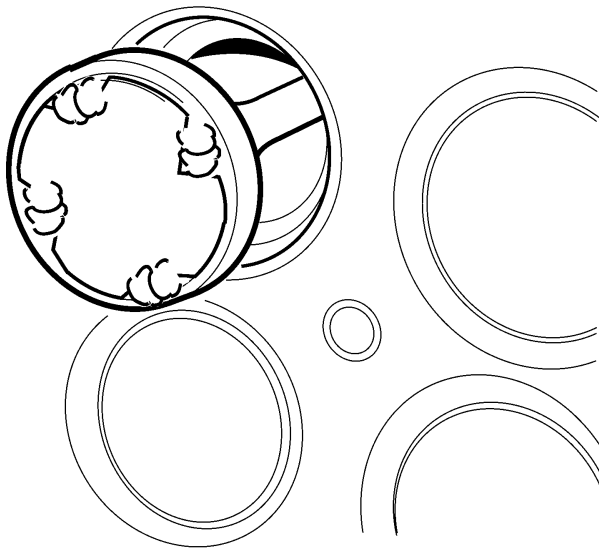
- 6**
Carefully tap out the old seat.

Note: Use caution when tapping on the valve stem. Do not damage the stem. The stem must be clean and free of burrs to prevent damage to the valve guide. If necessary, repair and clean the stem.



T2020013

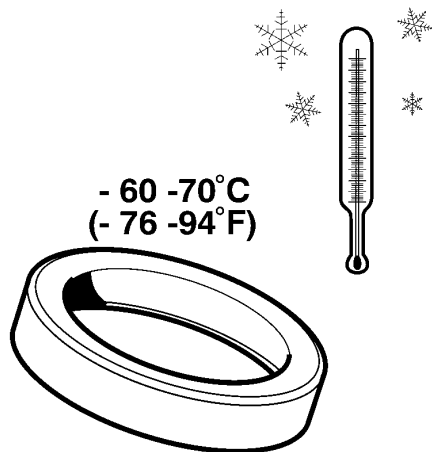
7



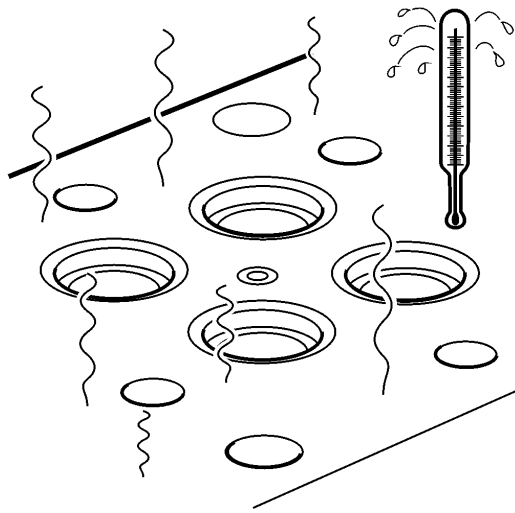
W2006313

8

Using caution, position the new seat on a block of dry ice. Allow seat to remain on ice for several minutes to obtain the proper temperature to allow the seat to shrink.

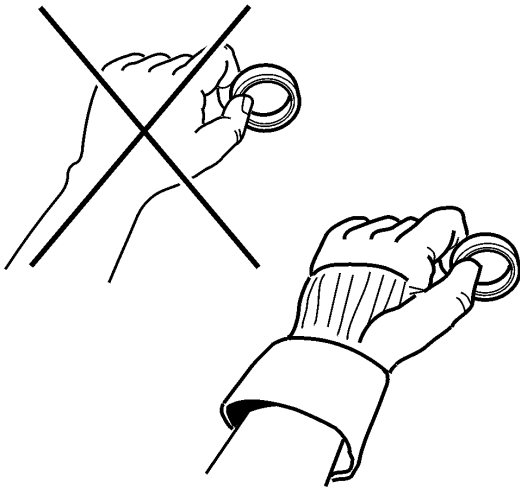


W2006316



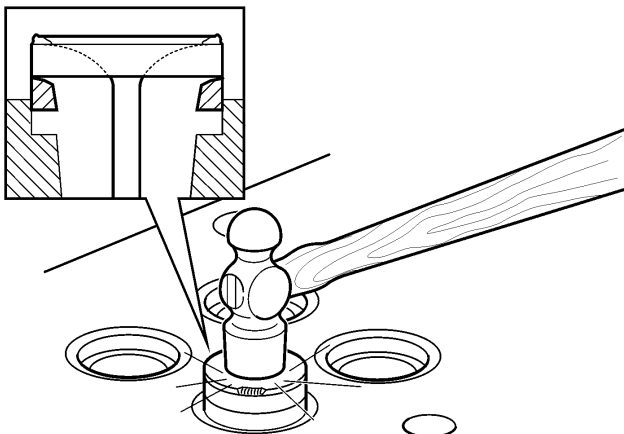
T2020034

9
Using a heat gun, apply heat to cylinder head around area where seat will be installed.



T2020033

10
Using protective gloves, carefully position the new seat into place.



T2022228

11
Use the old valve and seat to tap the new seat into the head until the seat bottoms.

Note: The valve and valve seat cannot be machined.