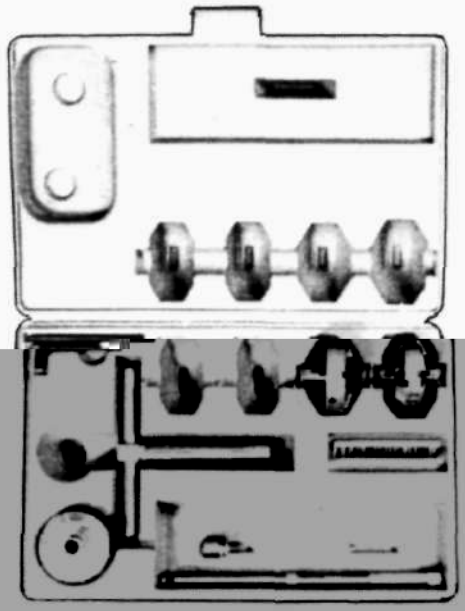
SCANIA

service **587 061**

Valve seat cutter

This cutter is easy to use and replaces methods such as grinding and lapping. It requires no machines; the cutting is done manually.

The bits, made of carbide steel, can be set for various diameters. Finishing is not necessary. The cutter is a less expensive alternative to 587 277.



Basic equipment:

Cutters

Qty	Ø	Angles	No. of bits
1	55.5	20°	5
1	50.8	60°	5
1	50.8	30°/45°	5/5

Pilot, Ø95mm, length 213 mm, complete with cone, expander and nut
Turning handle with adapter
Hex key for bits
Hex key for cutter centre
Turning pin for pilot
Brush for cleaning
Storage box

3018-587 415 EN © Saab-Scania AB, Scania Division, Service (834) 1988

Tool for machining grooves in cylinder heads and cylinder liner seats in cylinder blocks

The tool consists of a ring-shaped electromagnet in wich a bit spindle holder with feeder (0.01 mm) is carried.

The tool is turned by hand with a therefore intended crank. Necessary bits are included.

The tool is supplied in a wooden box.
See figure 1.

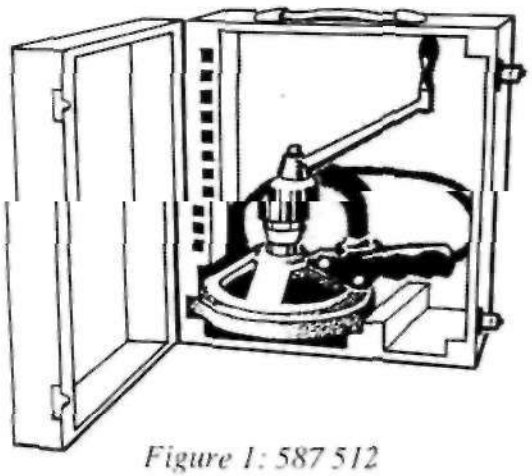


Figure 1: 587 512

With this equipment, liner seats can be machined individually to correct dimension with an accuracy of approx. 0.01 mm.

It is also possible to machine single liner seats with the engine installed. In this case, an extra ring is needed that is placed between the cylinder block plane and the electromagnet. See figure 2.

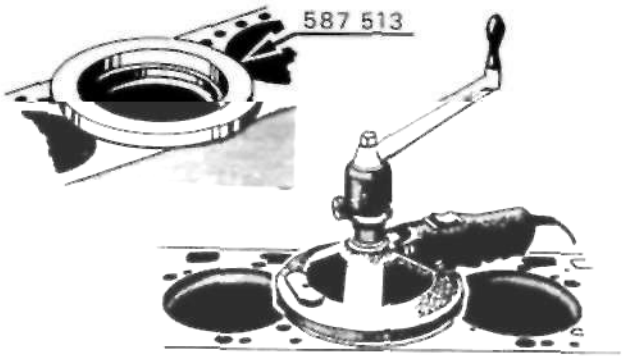


Figure 2: 587 513

For machining sealing grooves in cylinder heads there is an additional equipment kit. See figure 3 and 4.

Using this kit, grooves can be made in cylinder heads for 8, 9, 11 and 14 engines.

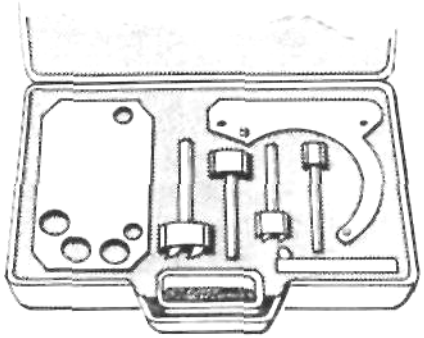


Figure 3: 587 595 (included in 587 514)

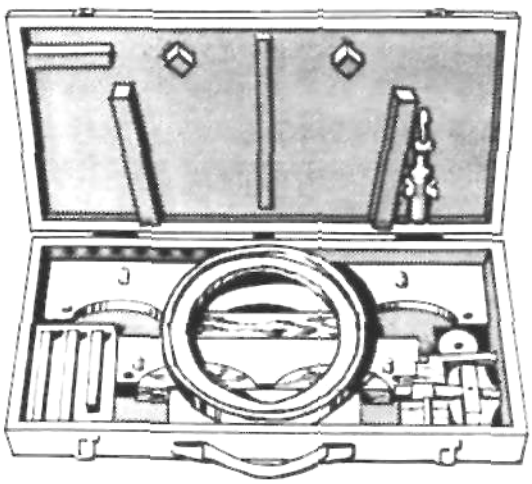


Figure 4: 587 514

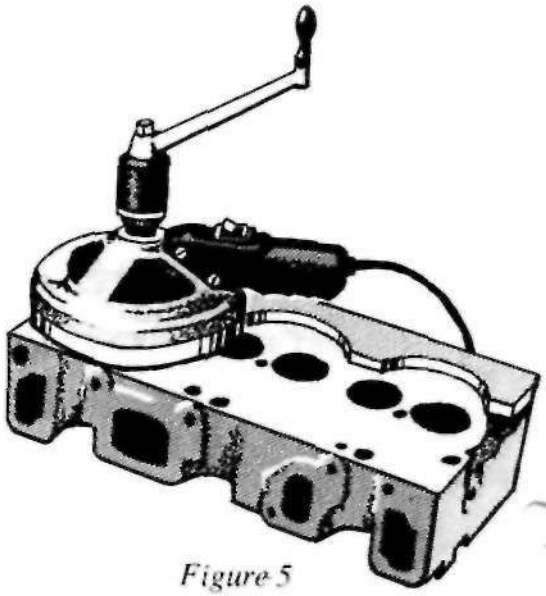


Figure 5

For example of machining grooves in an 11 enginge cylinder head, see figure 5.

For a suitable tool for removing guide pins in engine blocks, see 587 470.

The tools as per above are ordered under the following tool numbers:

587 272	Complete tool consisting of 587 512, 587 513 and 587 514
587 512	Liner seat cutter. See figure 1.
587 513	Spacing ring for machining one liner seat. See figure 2 . (Addition to 587 512).
587 514	*Grooving tool for cylinder heads* for 8, 9, 11, and 14 engines. See figure 3 and 4.
587 595	Grooving tool for cylinder head for 9 engine (included in 587 514). See figure 3.

Spare cuttning tools (not included)

For 587 512 and 587 272

587 926	Cutting tool for cylinder lining seats Ø 97 - 132 mm.
587 927	Cutting tool for cylinder lining seats Ø 130 - 170 mm.

For 587 514 (Grooving tool)

587 928	For 14 engines
587 929	For 11engines
587 930	For 8 engines
587 931	For 9 engines

587 277

Issue 2

Tool for machining valve seat angles and positions for valve seats in cylinder heads

The tool consists of a robust electromagnet, to wich a ball-suspended, lockable spindle with bit holder is attached. The spindle with the bit is turned by hand with a crank. On the spindle there is a feeder. In the spindle bottom part a pilot is screwed, that fits accurately in each valve guide.

With the bits that are enclosed, it is possible to machine valve seats as well as the counterbore seats. The tool is simple and fast to work with and gives very good results.

The tool with accessories is supplied in a storage box.

Accessories and spare cutting tools, see overleaf.