

Cylinder Head Flatness Measurement

Meets NATEF Task: (A1-B-2) Clean and visually inspect a cylinder head for cracks; check gasket surface areas for warpage and surface finish; check passage condition. (P-1)

Name _____ Date _____ Time on Task _____

Make/Model/Year _____ VIN _____ Evaluation: 4 3 2 1

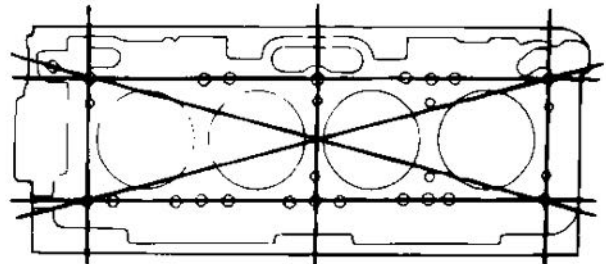
_____ 1. What is the maximum allowable out-of-flatness according to factory specifications?

_____ 2. Thoroughly clean the fire deck surface of the cylinder head using the appropriate cleaning method:

- **cast iron cylinder heads**
 bristle discs:
 - a. green (coarse – 50 grit)
 - b. yellow (medium – 80 grit)
 scraper

- **aluminum cylinder heads**
 bristle discs:
 - a. yellow (medium – 80 grit)
 - b. white (fine – 120 grit)
 plastic or wooden scraper

_____ 3. Use a precision straight edge and a feeler (thickness) gauge to check for warpage, distortion, bend and twist by checking in five places.



_____ 4. Maximum thickness of feeler gauge that could be placed between the straight edge and the head is _____ inches.

OK _____ NOT OK _____

_____ 5. What is the necessary action? _____
