Cylinder Head Flatness Measurement

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

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?

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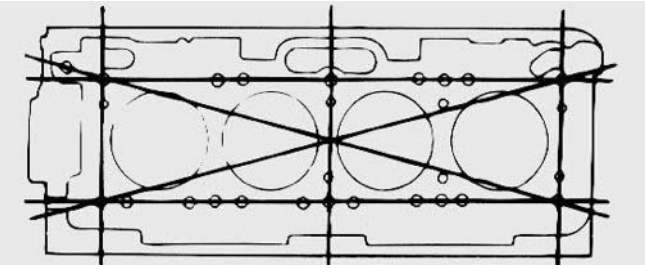
☐ **2.** Thoroughly clean the fire deck surface of the cylinder head using the appropriate cleaning method:

- **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? _____

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