Evaluation (Enter number from 4, 3, 2, 1) :\_\_\_\_\_\_\_\_\_

**Meets ASE Task:** (A1-B-3) P-1 Clean and visually inspect a cylinder head for cracks; check gasket surface areas for warpage and surface finish; check passage condition.

**Cylinder Head Flatness Measurement**

Name:\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_

Date:\_\_\_\_\_\_\_\_\_\_\_\_\_

Time on Task:\_\_\_\_\_\_\_\_\_\_\_\_\_

Make/Model/Year:\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_

VIN:\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_

Page 85

**[ ]  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? \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_

 \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_