

Cylinder Head Flatness Measurement

Meets ASE Task: A1 – B-3 – P-1

Name: _____ Date: _____ Time on Task: _____

Make/Model/Year: _____ VIN: _____

Evaluation (Enter number from 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 head(s)
 - a. green bristle discs (coarse – 50 grit)
 - b. yellow bristle discs (medium – 80 grit)
 - c. scraper
 - aluminum cylinder head(s)
 - a. yellow bristle discs (medium – 80 grit)
 - b. white bristle discs (fine – 120 grit)
 - c. 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? _____

