

Action code: AT FIRST OPPORTUNITY

Reaming of valve guide after replacement

SL2021-716/JOHP
September 2021

Concerns

Owners and operators of
MAN four-stroke engines.

Type:

Marine: L16/24, L21/31, L27/38,
L23/30H, L23/30H Mk2, L23/30H Mk3,
L28/32H

Stationary: L16/24S, L21/31S, L27/38S,
L23/30S, L28/32S, V28/32H, V28/32S

Propulsion: L21/31, L27/38, L23/30A,
L28/32A, V28/32A

Dual Fuel: L23/30DF, L28/32DF

Reference:

Work card 505-01.20.

Description 500.35.

Work card 505-01.10.

Dear Sir or Madam

This service letter provides important information on the need for reaming of the valve guide after replacement.

The valve guide must be reamed to ensure that it has the correct dimension when installed in the cylinder head.

The procedure is described in Work card:

- 505-01.20 Replacement of valve guide.

After reaming of the valve guide, the diameter must not exceed the tolerance described in Description:

- 500.35 Data for pressure and tolerances.

After replacing the valve guide, the valve seat must be reconditioned in accordance with the Work card:

- 505-01.10 Reconditioning of valve spindle seat and valve seat ring.

A reamer for valve guides is not a part of the standard tool kit. The appropriate reamer can be ordered from MAN Energy Solutions using the Plate Item number shown in the table on the next page.

Yours faithfully


Mikael C. Jensen

Vice President
Engineering


Lars Danefeld Sønderby

Senior Manager,
Production Support



Reamer for valve guide

Engine type	Plate / Item no.
L16/24	P52002-09 / 748
L23/30	P52002-12 / 748
L21/31	P52002-10 / 748
L27/38	P52002-11 / 748
L/V28/32	P52002-14 / 748 P62002-02H / 748

Should you have any queries, our Technical Service will be pleased to be of assistance:

MAN Energy Solutions

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