

CYLINDER HEAD:

Material: Pearlitic or Nodular Graphite Cast Iron / Cast Steel.

Properties:

- Must be of sufficient strength to withstand the gas load at maximum pressure.
- Resist bending and be symmetrical in shape.
- Have a rate of thermal expansion compatible with adjacent parts and transfer heat readily.

Design Features:

- The cylinder head / cover forms the top part of the combustion space.
- The head is of intricate design.
- The cover lands on the top of the cylinder liner flange and is secured to the cylinder block by a number of cover studs and nuts. These are tightened hydraulically to maintain a gas-tight seal under fluctuating pressure and temperature conditions.
- The cover must also locate & support all the valves required to operate the engine together with securing studs.
- Large two-stroke engine covers are machined from solid steel forging drilled to give bore cooling.
- They are circulated with fresh water from the jacket cooling system which maintains moderate temperatures and allows intensive cooling of exhaust valve seating while making separate fuel valve cooling unnecessary.
- Four-stroke engine covers are usually formed from a casting, which may be of pearlitic or nodular graphite cast iron, or in some cases cast steel.

Cylinder Head Problems:

- Cracking → Due to overheating, casting strain.
- Burning → Due to flame impingement.
- Distortion → Due to uneven tightness of holding down studs.
- Deposits & Corrosion → Due to excessive scaling from untreated water.

Hot Corrosion:

- Vanadium Pent-oxide (V_2O_5) melting point 690°C and is a corrosive liquid.
- Complex of Sodium (Na), & Vanadium (V) salts melting point 559°C and is a corrosive liquid.
- At high temperature slag deposits on the valve seat, rock, casing and on cylinder head.
- When temperature reaches at this melting point, slag melts and creates hole at this place.
- This type of burning of exhaust valve and cylinder head is called hot corrosion.

EXHAUST VALVE:

Exhaust Valve Material:

- Valve Seat → Stellite material
- Valve Lid → Nitride/Nitronic
- Valve Spindle → Nimonic material
- Valve Cage → Pearlitic cast iron
- Valve guide → Pearlitic cast iron
- Valve Bush → Bronze

Material Properties:

- High tensile strength & creep resistance properties.
- Resistance at high temperature properties.
- Resistance to high temperature corrosion.

Exhaust Valve Improved Design:

- Bore cooling for efficient cooling system (as low as 327°C at full load).
- Valve rotational mechanism.
- Heat and corrosion resistant material used.
- Hydraulic push rod with controlled valve-lifting speed.
- Air spring (or increase number of spring with improved material) to reduce valve bouncing.
- Guide bush is sealed by pressurized air.
- For less obstruction of gases, use valve seat angle 30° instead of 45° .

Cause of Exhaust Valve Burning:

- Continuous overloading of engine or particular unit.
- Poor combustion (or after burning) of fuel due to dirty fuel injectors, incorrect fuel injection pressure, incorrect fuel temperature, late fuel injection timing, air starvation, water or impurities in fuel.
- Valve not closing properly due to incorrect tappet clearance or starvation of closing air supply.
- Insufficient cooling water supply may cause the valve to overheat.
- Hot corrosion due to bad quality fuel, which contains high vanadium, sodium etc.
- Unsuitable material used.

Indication of Exhaust Leaking:

- Indicates high exhaust temperature in that unit.
- Indicates low compression pressure and low peak pressure in the indicator diagram.
- Low compression pressure and low peak pressure can be a cause of shortage of air supply, but in that case, scavenge air or supercharging air pressure will increase abnormally.



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