

VALVES AND SEATS

142A. Intake and exhaust valves are not interchangeable and the intake valves on all models seat directly in cylinder head with a face and seat angle of 45 degrees. The exhaust valves seat on renewable ring type inserts with a face and seat angle of 45 degrees. The method of removing the renewable type valve seat inserts is shown in Fig. AC55. Valve seat width is $\frac{3}{16}$ -inch for both the intake and the exhaust. Seats can be narrowed, using 15 and 75 degree stones. Intake and exhaust valves have a stem diameter of 0.3095-0.3100.

Adjust the intake valve tappet gap to 0.010 hot and the exhaust valve tappet gap to 0.019 hot.

VALVE GUIDES AND SPRINGS

142B. Guides can be pressed or driven from cylinder head if renewal is required. Press guides into cylinder head with smaller O.D. of guide up, until top of the guide is $\frac{1}{16}$ -inch above the valve cover gasket surface of cylinder head. Maximum allowable valve stem to guide clearance is 0.006. Ream new guides after installation, to provide the recommended stem to guide clearance of 0.0015-0.003. Refer to paragraph 142A for valve stem diameter.

142C. Intake and exhaust valve springs are interchangeable in all models. Renew any spring which is rusted, discolored or does not meet the load test specifications which follow:

Spring free length.....	2 $\frac{1}{4}$ inches
Renew if less than.....	1 $\frac{11}{16}$ inches
Pounds pressure	
at 1 $\frac{1}{4}$ inches.....	40-50
Pounds pressure	
at 1 $\frac{11}{16}$ inches.....	105-115

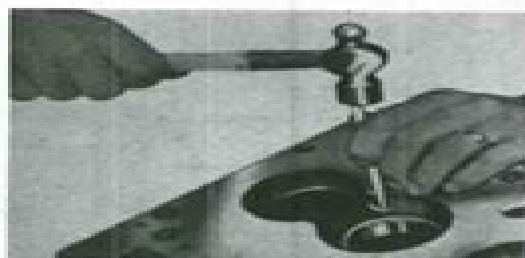


Fig. AC55—Method of removing a valve seat insert.

VALVE TAPPETS (CAM FOLLOWERS)

142D. The 0.560-0.561 diameter mushroom type tappets operate directly in the unbushed cylinder block bores with a suggested clearance of 0.0005-0.0025. Maximum allowable clearance is 0.0035.

To remove the tappets, it is first necessary to remove the camshaft as outlined in paragraph 144. Tappets are available in standard size only.

ROCKER ARMS

143. The hollow rocker arm shaft is drilled for lubrication to each rocker arm bushing. Lubricating oil to the drilled cylinder head passage and slotted oil stud (S—Fig. AC55A) is supplied by an external oil line which is connected to the main oil gallery on left side of engine. CAUTION: Always check the slotted stud to be sure the slot is facing the oil passage in the head. If oil does not flow from the hole in the top of each rocker arm, check for foreign material in the external oil line or in the cylinder head passage.



Fig. AC55A—Rocker arm assembly is lubricated via the slotted stud (S).

Fig. AC55B—Rocker arms are fitted with renewable type valve stem contact buttons which can be removed after extracting the retaining snap rings as shown.



The procedure for disassembling and reassembling the rocker arms from the shaft is evident. Check the rocker arm shaft and the bushing in each rocker arm for excessive wear. Maximum allowable clearance between the shaft and bushings is 0.005. When installing new bushings, make certain that oil hole in bushing is in register with oil hole in rocker arm and ream the bushings to provide a clearance of 0.001-0.002 for the 0.5405-0.541 diameter rocker arm shaft. When installing the rocker arm shaft, make certain that the oil metering holes in the shaft point toward push rods instead of valve stems.

Inspect the valve stem contact button in the end of each rocker arm for being mutilated or excessively loose. If either condition is found, renew the contact button. Extract the button retaining snap ring as shown in Fig. AC55B and remove the button and oil wick. Install new oil wick and button and test the button for a free fit in the rocker arm socket.

Note: If a new contact button has any binding tendency in the rocker arm socket, use a fine lapping compound and hand lap the mating surfaces.

VALVE TIMING

143A. Valves are properly timed when timing marks on camshaft gear and crankshaft gear are in register. The single punch marked tooth space on the camshaft gear should be meshed with the single punch marked tooth on the crankshaft gear, as shown at (X) in Fig. AC56.

CRANKCASE FRONT COVER

143B. To remove the crankcase front cover (timing gear cover), first drain the cooling system and remove the

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