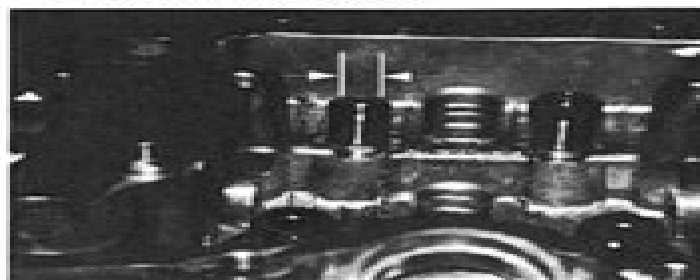


6. Measure valve guide inside diameter at the top, middle and end of the guide using a small hole gauge and a micrometer. Measure in two directions, front to back and side to side.



Valve Guide I.D.:
.2362 - .2367" (6.0 - 6.012 mm)

7. Subtract valve stem measurement to obtain stem to guide clearance.

NOTE: Be sure to measure each guide and valve combination individually.

8. Replace valve and/or guide if clearance is excessive. Compare to specifications.

NOTE: If valve guides are replaced, valve seats must be reconditioned. Refer to the "Valve Seat Reconditioning" procedure.

Combustion Chamber

Clean all accumulated carbon deposits from combustion chamber and valve seat area with a soft wire brush.



3

Valve Seat Reconditioning

Valve Seat Inspection

Inspect valve seat in cylinder head for pitting, burnt spots, roughness, and uneven surface. If any of the above conditions exist, the valve seat must be reconditioned. If the valve seat is cracked the cylinder head must be replaced.

Cylinder Head Reconditioning

NOTE: Servicing the valve guides and valve seats requires special tools and a thorough knowledge of reconditioning techniques. Follow the instructions provided in the cylinder head service tool kit.



CAUTION

Wear eye protection when performing cylinder head service. Valve guide replacement will require heating of the cylinder head.
Wear gloves to prevent burns.

Valve Guide Removal / Installation

1. Remove all carbon deposits from the combustion chamber, valve seat and valve guide area before attempting to remove valve guides. **CAUTION:** Carbon deposits are extremely abrasive and may damage the valve guide bore when guides are removed.
2. Place new valve guides in a freezer for at least 15 minutes while heating cylinder head.

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