

(2) Measure valve stems for wear. The intake valve stem diameter should measure .372 to .373 inch and the exhaust valve stem diameter should measure .371 to .372 inch. If wear exceeds .022 inch, replace the valve.

(3) Remove carbon and varnish deposits from inside of valve guides with cleaner, Tool C-756.

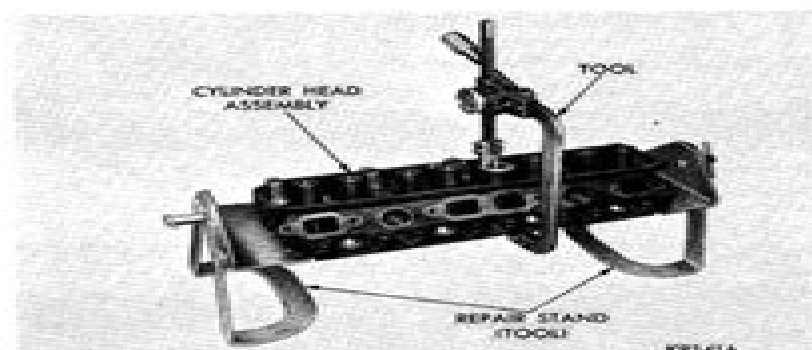


Fig. 6—Compressing Valve Spring



Fig. 7—Installing Valve and Tool C-3973

(4) Measure valve stem guide clearance as follows: Install sleeve Tool C-3973 over valve stem (Fig. 7) and install valve.

(5) The special sleeve places the valve at the correct height for measuring with a dial indicator. Attach dial indicator Tool C-3339 to the cylinder head and set it at a right angle to the valve stem being measured (Fig. 8).



Fig. 8—Measuring Valve Guide Wear

(6) Move valve to and from the indicator. Total dial indicator reading should not exceed .017 inch. If the dial indicator reading is excessive or if the stems are scored or worn excessively, ream the guides for new valves with oversize stems.

(7) Service valves with oversize stems are available in .005, .015 and .030 inch oversize. Reamers to accommodate the oversize valve stem are as follows:

Reamer Tool Number	Reamer Oversize	Valve Guide Size
C-3433	.005 in.	.379-.380 in.
C-3430	.015 in.	.389-.390 in.
C-3427	.030 in.	.404-.405 in.

(8) Slowly turn reamer by hand and clean guide thoroughly before installing new valve. Do not attempt to ream the valve guides from standard directly to .030 inch. Use step procedure of .005, .015 and .030 inch so the valve guides may be reamed true in relation to the valve seat.

Refacing Valves and Valve Seats

The intake and exhaust valve faces have a 45 degree angle. Always inspect the remaining valve margin after the valves are refaced (Fig. 9). Valves with less than 3/64 inch margin should be discarded.

(1) The angle of both the valve and seat should be identical. When refacing valve seats, it is important that the correct size valve guide pilot be used for reseating stones. A true and complete valve seat surface must be obtained.

(2) Inspect valve seat with Prussian blue to determine where valve contacts seat. To do this, coat valve seat lightly with Prussian blue, then set valve in place. Rotate valve with light pres-

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Harold T. Glenn



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