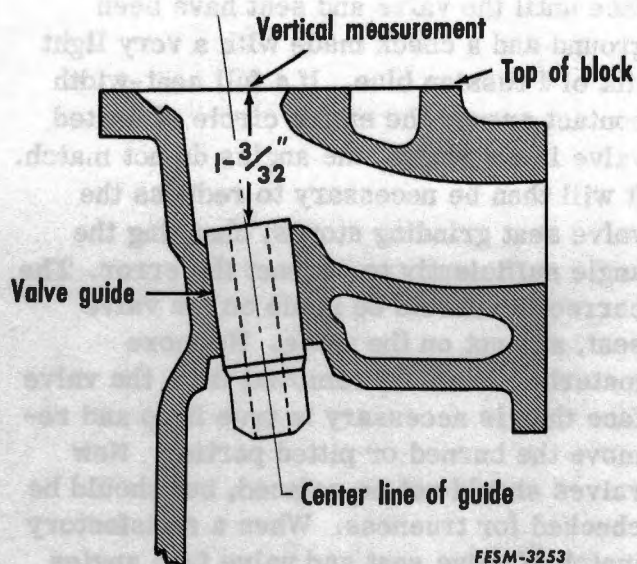


Observing the operation of the valves prior to tear-down of the engine is beneficial in preventing unnecessary checking of worn rotators. Mark the valves with a pencil as movement is relatively slight.



Reconditioning

Valve Guides

1. Press the guides from the crankcase.
2. Install new guides from the top of the crankcase, and press them into the crankcase bores to a measured distance of 1-3/32 inch from the top surface of the block to the top center of the guide.
3. All guides furnished as service parts are reamed to size; however, as they are a press fit, it is necessary to burnish them after installation to remove any possible burrs or slight distortion caused by the pressing operation.

Valves

After being thoroughly cleaned and inspected, valves that are fit for continued use should be reconditioned as follows:

1. Set the valve refacing machine to grind the specified angle of 45-1/2 degrees and dress the grinding stone.
2. Insert a valve in the chuck and take a light cut across its face. This is a check to determine whether the valve can be reconditioned to service standards with a correct amount of margin maintained. Warp-age that may not be apparent in the visual inspection will be clearly definable.

