

Valve Dimensions**Intake Valve (minimum)**

Stem diameter: 7.935 mm (.3124 in.)
Face angle: 44 1/2°
Valve margin: .794 mm (.031 in.)
Head diameter: 45.5 mm (1.79 in.)
Length: 125.38 mm (4.936 in.)

Exhaust Valve (minimum)

Stem diameter: 7.906 mm (.3112 in.)
Face angle: 44 1/2°
Valve margin: 1.191 mm (.0469 in.)
Head diameter: 37.5 mm (1.476 in.)
Length: 126.00 mm (4.964 in.)

9109-47

Fig. 19 Valve Dimensions**REFACING VALVES AND VALVE SEATS**

The intake and exhaust valves have a 44-1/2 to 45 degree face angle. The valve seats have a 45 to 45-1/2 degree face angle. The valve face and valve seat angles are shown in (Fig. 20).

VALVES

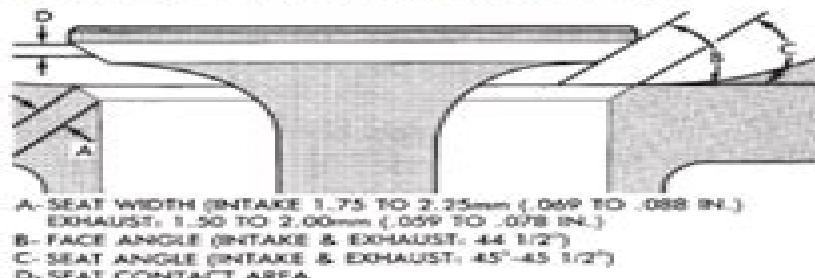
(1) Inspect the remaining margin after the valves are refaced Refer to specifications (Fig. 19).

VALVE SEATS

CAUTION: Do not un-shroud cylinder head from around the valve during valve seat refacing (Fig. 21).

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

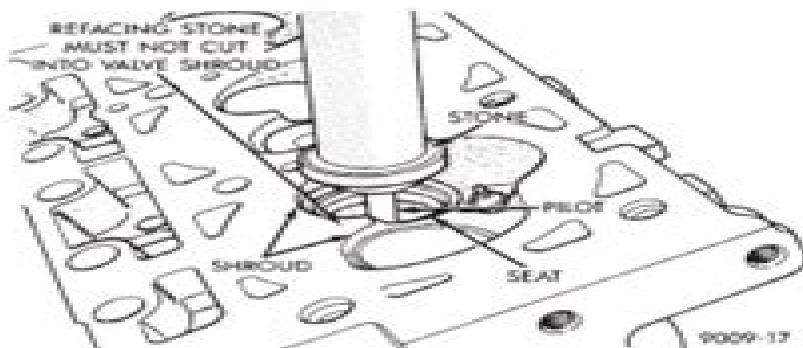
(2) Measure the concentricity of valve seat using dial indicator. Total runout should not exceed .051mm (.002 inch) total indicator reading.



9009-88

Fig. 20 Valve Seats

(3) Inspect the valve seat with Prussian blue to determine where the valve contacts the seat. To do

**Fig. 21 Refacing Valve Seats**

this, coat valve seat **LIGHTLY** with Prussian blue then set valve in place. Rotate the valve with light pressure. If the blue is transferred to the center of valve face, contact is satisfactory. If the blue is transferred to top edge of valve face, lower valve seat with a 15 degree stone. If the blue is transferred to the bottom edge of valve face raise valve seat with a 65 degrees stone.

Valve seats which are worn or burned can be reworked, provided that correct angle and seat width are maintained. Otherwise cylinder head must be replaced.

(4) When seat is properly positioned the width of intake seats should be 1.75 to 2.25mm (.069 to .088 inch) The width of the exhaust seats should be 1.50 to 2.00mm (.059 to .078 inch) (Fig. 20)

(5) Check the valve spring installed height after refacing the valve and seat (Fig. 23).

TESTING VALVE SPRINGS

Whenever valves have been removed for inspection, reconditioning or replacement, valve springs should be tested (Fig. 22). As an example: the compression length of the spring to be tested is 33.34mm (1-5/16 inches). Turn table of Tool C-647 until surface is in line with the 33.34mm (1-5/16 inch) mark on the threaded stud and the zero mark on the front. Place spring over stud on the table and lift compressing lever to set tone device. Pull on torque wrench until ping is heard. Take reading on torque wrench at this instant. Multiply this reading by two. This will give the spring load at test length. Fractional measurements are indicated on the table for finer adjustments. Refer to specifications to obtain specified height and allowable tensions. Discard the springs that do not meet specifications.

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