

## CYLINDER HEAD/VALVES

---

### VALVE/VALVE GUIDE INSPECTION

Inspect each valve for trueness, burning, scratches or abnormal stem wear.  
Check the valve movement in the guide. Measure and record each valve stem O.D.

#### SERVICE LIMITS:

**INTAKE:** 6.56 mm (0.257 in)

**EXHAUST:** 6.55 mm (0.258 in)



Measure and record each valve guide I.D. using a ball gauge or inside micrometer.

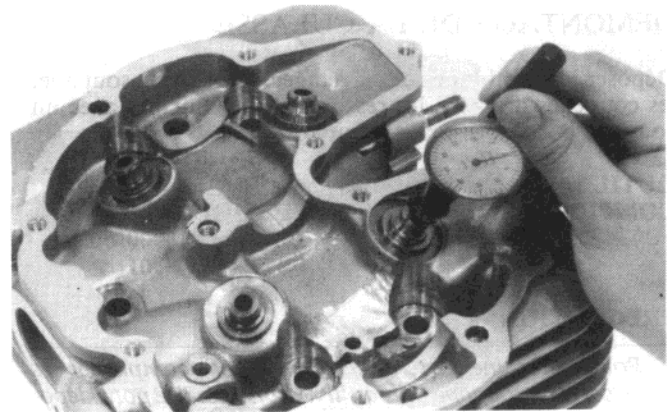
#### NOTE

- Ream the guides to remove the carbon build-up before checking the valve guide I.D.

#### SERVICE LIMITS:

**INTAKE:** 6.63 mm (0.261 in)

**EXHAUST:** 6.63 mm (0.261 in)



Calculate the stem-to-guide clearance.

### VALVE STEM-TO-GUIDE CLEARANCE

#### SERVICE LIMITS:

**INTAKE:** 0.065 mm (0.0026 in)

**EXHAUST:** 0.080 mm (0.0031 in)

#### NOTE

- If the stem-to-guide clearance exceeds the service limit, determine if a new guide with standard dimensions would bring the clearance within tolerance. If so, replace guides as necessary and ream to fit.

If stem-to-guide clearance still exceeds the service limit when new guides are installed, replace the valves.

#### NOTE

- Reface valve seats whenever new valve guides are installed.