

(Fig. 6-46). With all parts seated, step end of gauge should be at least flush with gasket face of head, but should not project past the step on the gauge.

b. If gauge projects too far, indicating that the valve stem is too long, grind the tip of the valve stem as necessary to make the gauge index properly.

**CAUTION:** When grinding valve stem be very careful not to overheat it. Overheating will soften the hardened stem causing rapid wear.

### FITTING VALVE STEMS TO GUIDES

Correct valve stem clearance for valve guides is .0016" to .0033" for the intake valve and .0021" to .0038" for the exhaust valve.

Valves with oversize stems are available in .001", .003" and .005" larger than standard. The same valve stem to guide clearance applies for oversize stems.

Oversize reamers are required to enlarge valve guide holes to fit the oversize stems. When the reamer is turned through the valve guide it will size the hole to fit the valve stem according to the above limits.

Carefully ream the valve guide using Valve Guide

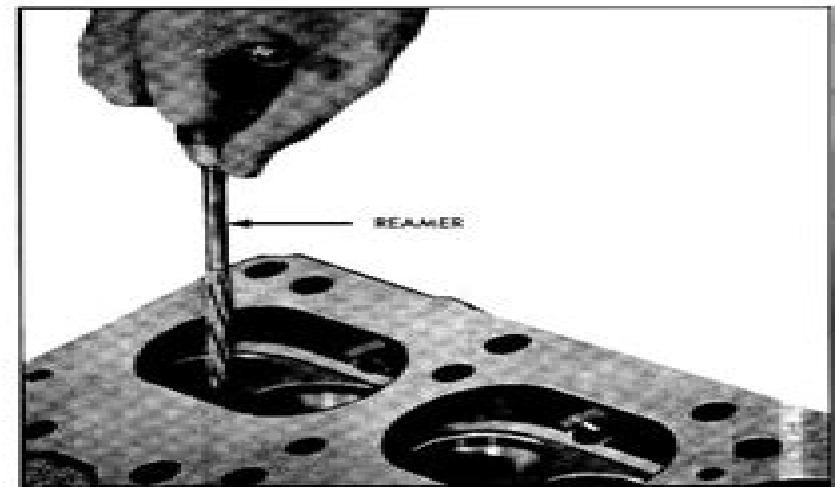


Fig. 6-47 Fitting Valve Stems to Guide

Reamer J-5830-1 for .003" oversize stems and Valve Guide Reamer J-5621 for .005" oversize stems (Fig. 6-47). For best results when installing .005" oversize valve stem use the .003" oversize reamer first and then ream to .005" oversize. Always reface the valve and valve seat after reaming valve guide. **NOTE:** Valves are marked .001, .003 or .005 with colored ink.

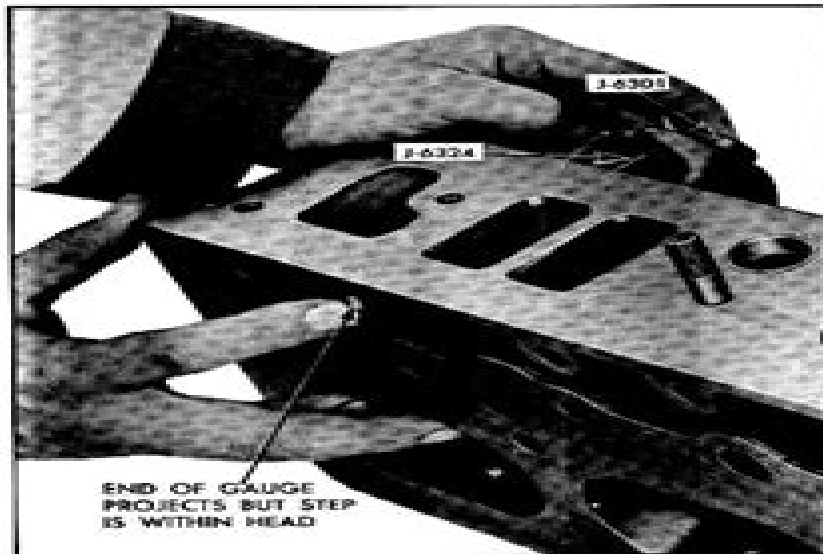


Fig. 6-46 Checking Length of Valve Stem

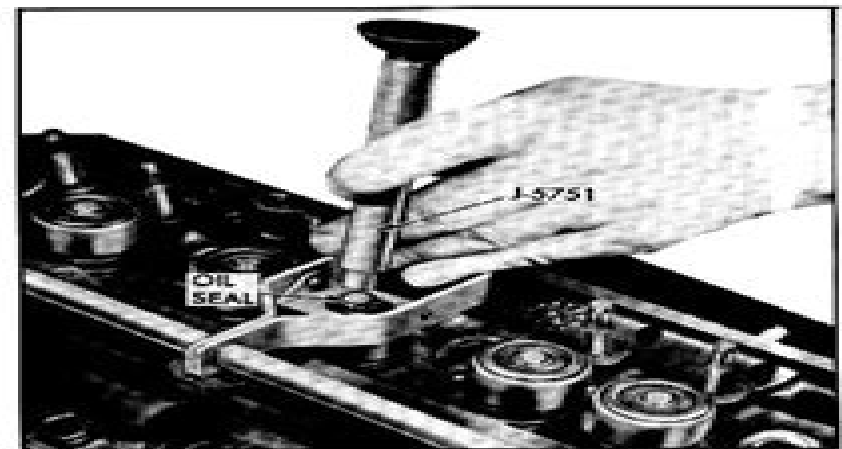


Fig. 6-48 Installing Valve Stem Seal

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**Robert R. Redfield**



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