

**VALVE SPRING**

Check the valve springs for fatigue or damage.

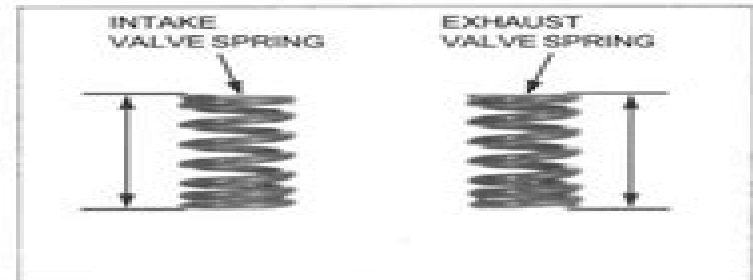
Measure the free length of the intake and exhaust valve springs.

**SERVICE LIMITS:**

IN (Orange paint): 40.6 mm (1.60 in)

EX (Gray paint): 42.1 mm (1.66 in)

Replace the springs if they are shorter than the service limits.

**VALVE/VALVE GUIDE**

Inspect each valve for out-of-round, burns, scratches or abnormal stem wear.

Check the valve movement in the guide. Measure and record the valve stem O.D.

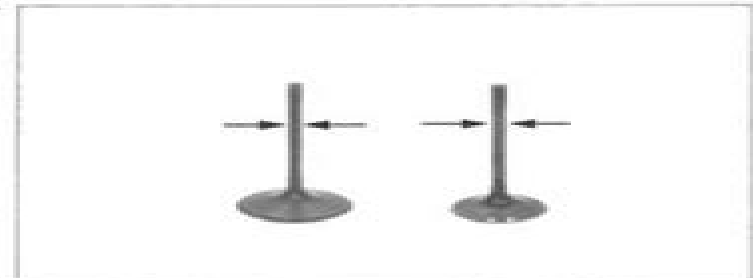
**STANDARD:**

IN: 4.975 – 4.990 mm (0.1959 – 0.1965 in)

EX: 4.965 – 4.980 mm (0.1955 – 0.1961 in)

**SERVICE LIMIT:**

EX: 4.96 mm (0.195 in)



*Take care not to tilt or lean the reamer in the guide while reaming.*

Ream the valve guide to remove any carbon build-up before measuring the guide I.D.

Insert the reamer from the combustion chamber side of the cylinder head and always rotate the reamer clockwise.

**TOOL:**

Valve guide reamer, 5.0 mm

07984-MA60001 or  
07984-MA6000D  
(U.S.A. only)



Measure and record each valve guide I.D. in the combustion chamber.

**SERVICE LIMIT: 5.052 mm (0.1989 in)**

Subtract each valve stem O.D. from the corresponding guide I.D. to obtain the stem-to-guide clearance.

**STANDARD:**

IN: 0.010 – 0.037 mm (0.0004 – 0.0015 in)

EX: 0.020 – 0.047 mm (0.0008 – 0.0019 in)

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



*Reface the valve seats whenever the valve guides are replaced (page 9-25).*

# P3history Owners Manual Diagrams Stripping Guide

**Ian Pickup**



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