

Fig. 156

Valve seat width "a"

Intake: 1.1 to 1.4 mm (.043 to .055 in.)

Exhaust: 1.4 to 1.7 mm (.055 to .067 in.)

Cutting sequence

1. Cut 45° surfaces.

When cutting this surface it is important that the cutter is centered and does not chatter so that a smooth finish is obtained. Pressure must be applied vertically to prevent wobble. Remove as little material as possible to avoid replacing seats. When the cutter has cleaned the entire seat face remove the cutter.

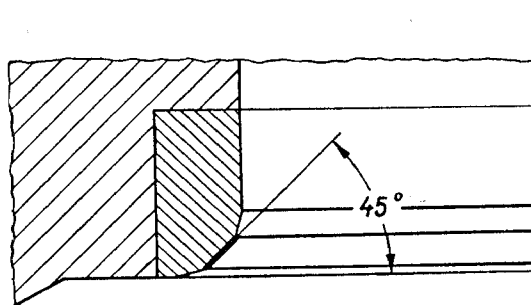


Fig. 157

2. Cut 75° surfaces.

Bevel the inner edge of the seat lightly with the 75° cutter.

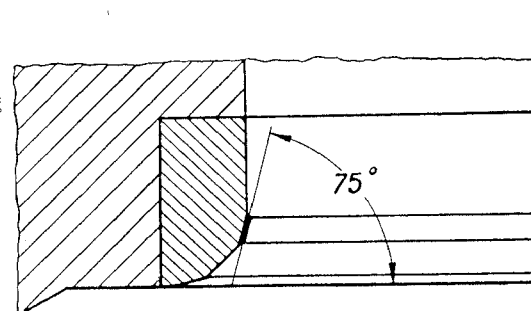


Fig. 158

3. Cut 15° surfaces.

Bevel the upper edge of the seat with the 15° cutter until the required seat width is obtained.

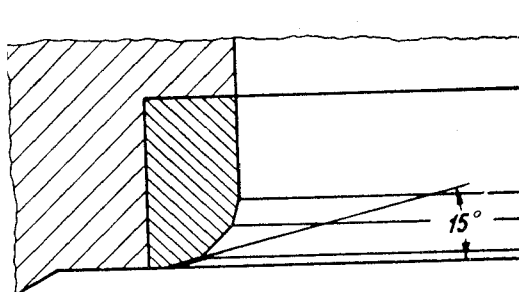


Fig. 159

Grinding Valves

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Valves with pitted or worn faces should be refaced on a valve grinding machine.

When refacing valves, remove only enough material

to clean the face. Care must be taken that the stone does not contact the valve stem since valves with rough or gouged stems must be replaced.