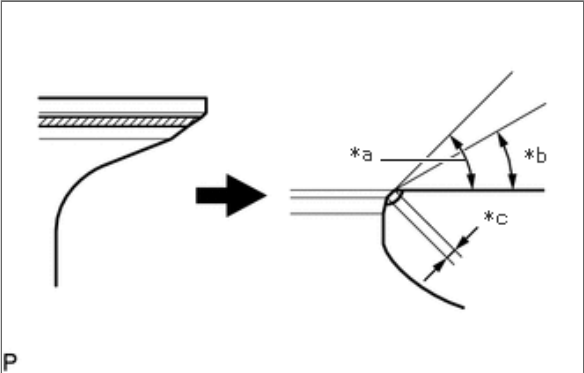


PROCEDURE

1.REPAIR VALVE SPRING SEAT

13734

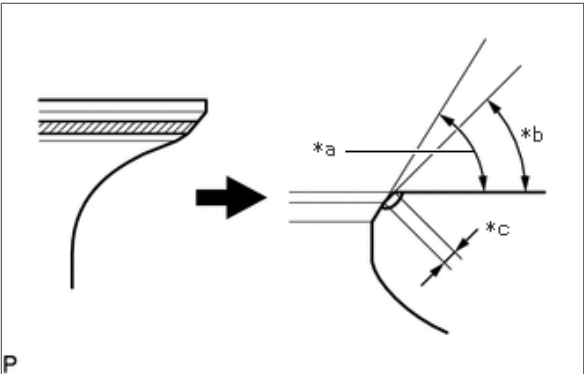
a.



*a	45°
*b	30°
*c	1.0 to 1.4 mm (0.0394 to 0.0551 in.)

If the seating is too high on the valve face, use 30° and 45° cutters to correct the seat.

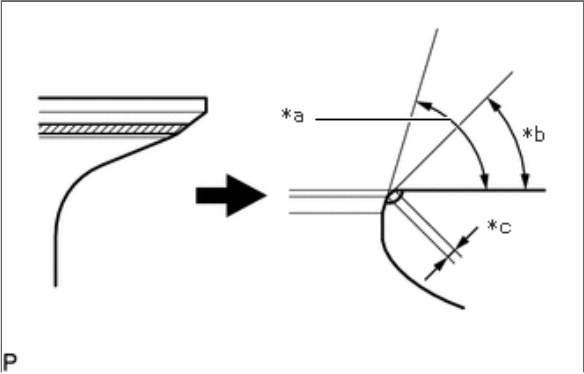
b.



*a	60°
*b	45°
*c	1.0 to 1.4 mm (0.0394 to 0.0551 in.)

Intake Side:
If the seating is too low on the valve face, use 60° and 45° cutters to correct the seat.

c.

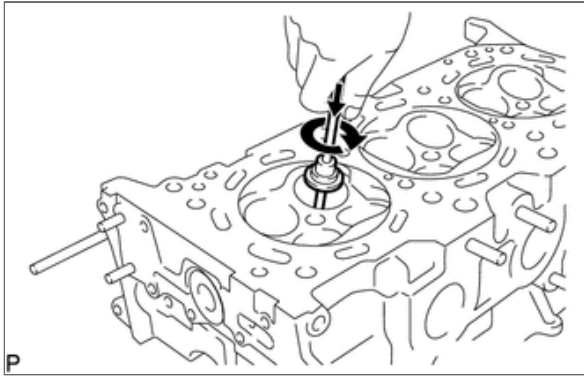


*a	75°
*b	45°
*c	1.0 to 1.4 mm (0.0394 to 0.0551 in.)

Exhaust Side:

If the seating is too low on the valve face, use 75° and 45° cutters to correct the seat.

d.



Hand-lap the valve and valve seat with an abrasive compound.

e. After lapping the valve by hand, clean the valve and valve seat.