

1

(4) Narrow the valve seat at the bottom using a 63.5° stone.

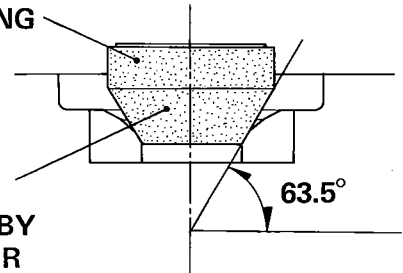
	Grinding Stone Part No. (O.D.)	Grinding Angle (Color code)
IN	07783 - 0050200 (26 mm) (1.024 in.)	63.5° (Pink)
EX	07783 - 0050100 (23 mm) (0.905 in.)	

2

SIDE DRESSING

3

SURFACED
PRODUCED BY
63.5° CUTTER

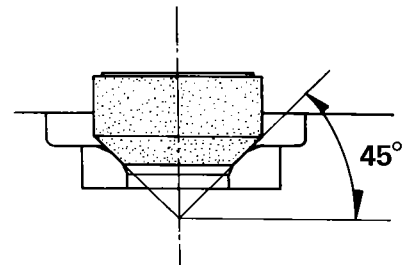


4

(5) Bring the seat to the correct width and location on the valve face with a 45° stone as is used in Step (2) above.

NOTE

The grinding stones must be dressed as frequently as possible to insure that the limits are not exceeded.



Valve seat width	Standard	1.0 mm (IN/EX) (0.394 in.)
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5

(6) Apply a small amount of fine grinding compound to the valve face. Lap the two surfaces lightly together by rotating the handle.

NOTE

Do not allow the lapping compound to enter the valve guide. Apply a thin coating of Prussian Blue to the seat and then set the valve in place. The contact is satisfactory if the Prussian Blue is transferred to the center of the seat evenly.

As for handling of the valve seat grinder, follow the instructions furnished by the manufacturer.

6

ROTATE ONE FULL
TURN WHILE PRESS-
ING DOWN WITH A
LIGHT PRESSURE.

