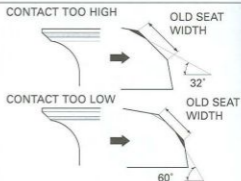
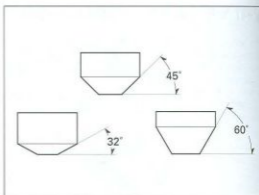


VALVE SEAT REFACING

Valve seat cutters/grinders or equivalent valve seat refacing equipment are recommended to correct worn valve seats.

Follow the refacing manufacturer's operating instructions.

If the contact area is too high on the valve, the seat must be lowered using a 32° flat cutter.
If the contact area is too low on the valve, the seat must be raised using a 60° interior cutter.

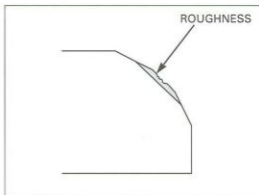


Use a 45-degree cutter to remove any roughness or irregularities from the seat.

TOOLS:

Seat cutter, 27.5 mm
(45° IN/EX)
Cutter holder, 4.5 mm

07780-0010200
07781-0010600 or
equivalent commercially available



Use a 32-degree cutter to remove the top 1/4 of the existing valve seat material.

TOOLS:

Flat cutter, 27 mm (32° EX)
Flat cutter, 30 mm (32° IN)
Cutter holder, 4.5 mm

07780-0013300
07780-0012200
07781-0010600 or
equivalent commercially available

