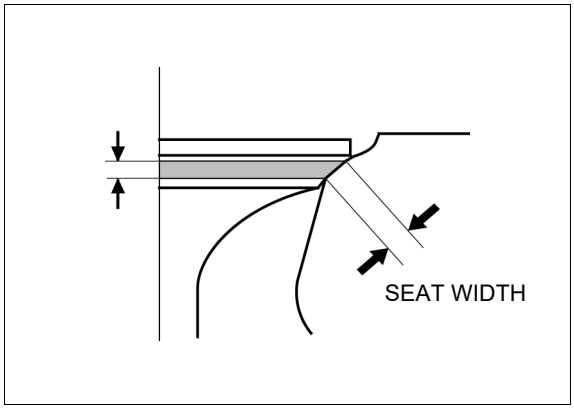
The valve cannot be grounded. If the valve face is burned or badly worn or if it contacts the seat unevenly, replace the valve.

Remove the valve and inspect the width of each valve seat.

The valve seat contact should be within the specified width and even all around the circumference.

STANDARD: 0.9 – 1.1 mm (0.035 – 0.043 in)
SERVICE LIMIT: 1.5 mm (0.06 in)



If the valve seat width is not within specification, reface the valve seat.

Inspect the valve seat face for:

- Damaged face:
  – Replace the valve and reface the valve seat.
- Uneven seat width:
  – Bent or collapsed valve stem;
  Replace the valve and reface the valve seat.
- Contact area (too high or too low area)
  – Reface the valve seat.

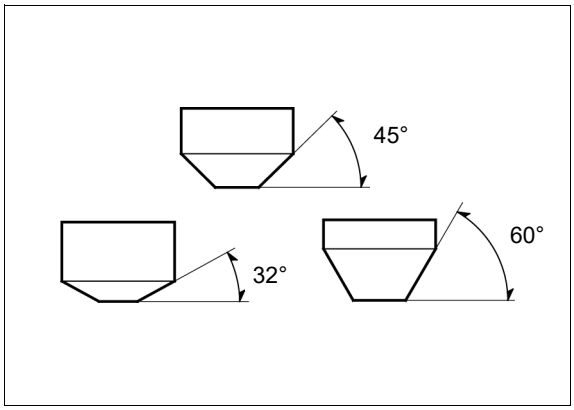
VALVE SEAT REFACING

Follow the refacing manufacturer's operating instructions.

Valve Seat Cutters, a grinder or equivalent valve seat refacing equipment are recommended to correct a worn valve seat.

TOOLS:

Seat cutter, 27.5 mm (45° IN)	**07780-0010200**
Seat cutter, 24.5 mm (45° EX)	**07780-0010100**
Flat cutter, 28 mm (32° IN)	**07780-0012100**
Flat cutter, 25 mm (32° EX)	**07780-0012000**
Interior cutter, 30 mm (60° IN)	**07780-0014000**
Interior cutter, 22 mm (60° EX)	**07780-0014202**
Cutter holder	**07781-0010400**



Using 45 degree cutter and cut the seat to the proper width.

Make sure that all pitting and irregularities are removed.

Refinish if necessary.

STANDARD SEAT WIDTH:
0.9 – 1.1 mm (0.035 – 0.043 in)

Excessive lapping pressure may deform or damage the seat. Lapping compound can cause damage if it enters between the valve stem and guide.

After cutting the seat, apply lapping compound to the valve face and lap the valve using light pressure.
Change the angle of lapping tool [1] frequently to prevent uneven seat wear.

After lapping, wash any residual compound off the cylinder head and valve.
Recheck the seat contact after lapping.