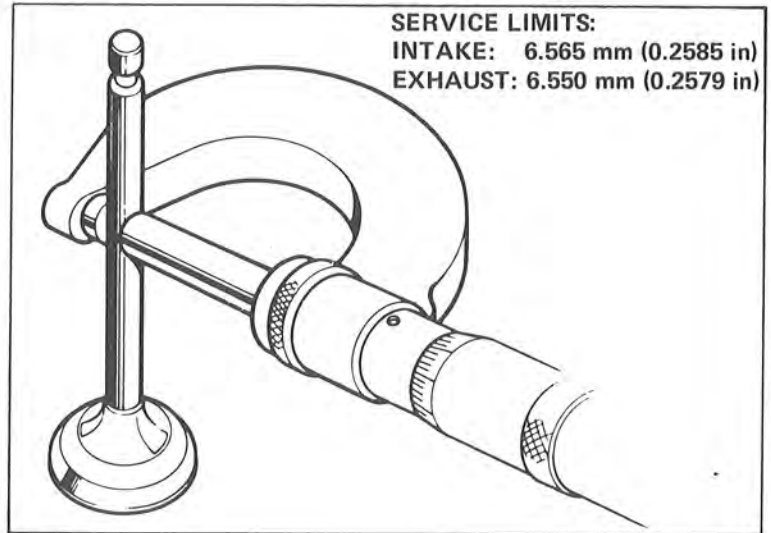




**VALVE/VALVE GUIDE INSPECTION**

Inspect each valve for trueness, burning, scratches or abnormal stem wear.  
Check the valve movement in the guide. Measure and record each valve stem O.D.



Measure and record each valve guide I.D. using a ball gauge or inside micrometer.

**NOTE**

Ream the guides to remove the carbon build-up before checking the valve guide I.D.

Calculate the stem-to-guide clearance.

**VALVE STEM-TO-GUIDE CLEARANCE**

**SERVICE LIMITS:**

**INTAKE:** 0.065 mm (0.0026 in)

**EXHAUST:** 0.080 mm (0.0031 in)

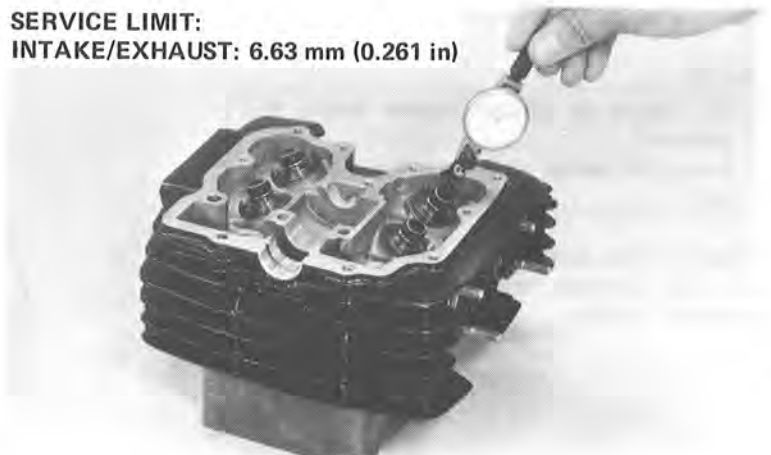
**NOTE**

If the stem-to-guide clearance exceeds the service limit, determine if a new guide with standard dimensions would bring the clearance within tolerance. If so, replace guides as necessary and ream to fit.

If stem-to-guide clearance still exceeds the service limit when new guides are installed, replace the valves.

**NOTE**

Reface valve seats whenever new valve guides are installed.



**VALVE GUIDE REPLACEMENT**

Support the cylinder head and drive out the guide from the valve port.

**NOTE**

When driving out the valve guide, do not damage the head.

