

Service

SHOP DOPE BULLETIN NO. 382

2-8-57

VALVE GUIDES, BIG TWIN OHV

Production engines with aluminum cylinder heads have always been supplied from the factory with steel intake valve guides, and with bronze exhaust valve guides starting in 1950. However, valve guides for parts order have been bronze for both intake and exhaust since 1950.

Because of recent changes, subsequently outlined, bronze valve guides will no longer be used for Big Twin OHV Models.

Exhaust Valve Guides

A change in exhaust valve guide material has been made, starting approximately February 1, 1957, in all Big Twin OHV engines. Valve guide material has been changed from bronze to a special steel alloy. This material is superior to the bronze alloy which it replaces, because of its greater resistance to wear at high temperatures.

The new steel exhaust valve guides will be supplied for parts order under the following part numbers:

18188-48A	(Standard)
18189-48A	(.001" oversize)
18190-48A	(.002" oversize)
18191-48A	(.003" oversize)
18192-48A	(.004" oversize)
18193-48A	(.006" oversize)



Steel Exhaust Valve Guide

Above steel exhaust valve guides will be supplied henceforth on all orders received at the factory for the following replacement valve guides:

18188-48	(Standard)
18189-48	(.001" oversize)
18190-48	(.002" oversize)
18191-48	(.003" oversize)
18192-48	(.004" oversize)
18193-48	(.006" oversize)

Bronze guides which you now have in stock under above part numbers can be used up by using in intake valve position in Big Twin OHV engines.

Important:

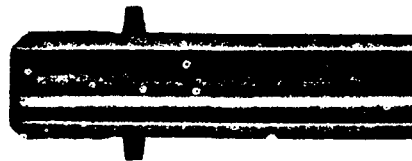
Some bronze valve guides in your stock under above part numbers may have a female thread in the valve guide hole which is intended to improve valve stem lubrication. Such guides are not approved for use in intake position, because excessive oil may pass by valve stem into combustion chamber. Therefore, use only guides with a smooth bore for intake position. Examine all of your bronze guides under above part numbers to determine if guide bore is threaded. Return threaded bronze guides to the factory for credit or exchange.

Intake Valve Guides

Steel intake valve guides have always been used for production Big Twin OHV engines. The special steel material used has proven its resistance to wear, and for this reason is now being made available for replacement guides.

The steel intake valve guides will be supplied for parts order under the following part numbers:

18163-48	(Standard)
18164-48	(.001" oversize)
18165-48	(.002" oversize)
18166-48	(.003" oversize)
18167-48	(.004" oversize)
18169-48	(.006" oversize)



Steel Intake Valve Guide

Note:

All oversize valve guides supplied on parts order are identified with grooves cut around outside at top end, the number of grooves (one to six) indicating .001" increase in outside diameter over standard for each groove. Standard size guide is not grooved.

Because of the limited quantities available at the start of production of both the intake and exhaust steel valve guides, it is requested that initially you order only enough guides to take care of immediate requirements. Sufficient quantities for your reserve stock can be ordered later, when initial orders have all been filled.

Caution:

Order Big Twin OHV intake and exhaust valve guides only under new part numbers shown opposite the illustrations in this bulletin, because if guides intended for the intake valve position are ordered under the old part numbers, we will supply the new type steel exhaust valve guides which are not suitable for use in intake valve position.