

SERVICE BULLETIN

M-869

April 19, 1983



VALVE GUIDE GAUGE/CUTTING TOOL

General

After valve seat refacing on 1200cc and 1340cc engine cylinder heads, the clearance between the valve head (1) and the end of the exhaust valve guide (2) must be correctly gauged to prevent contact. See Figure 1.

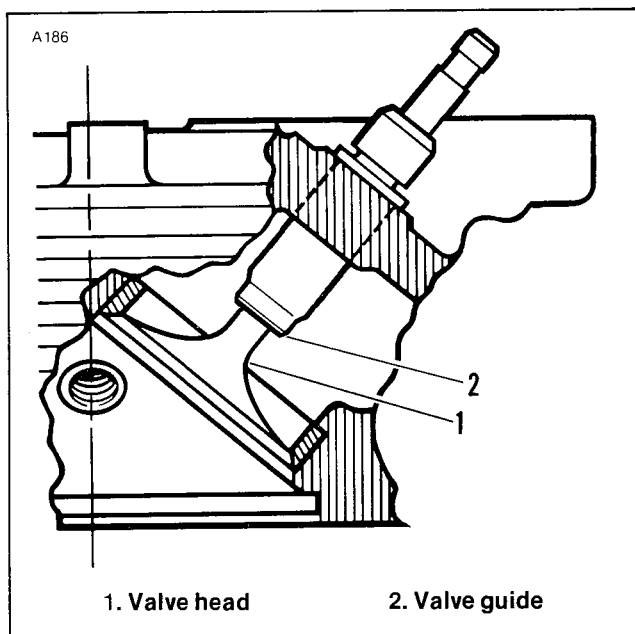


Figure 1. Valve Guide to Valve Head Clearance

Specifications

Kent Moore Tool #HD-34107 is required to accurately gauge this clearance and also eliminate the possibility of excessively shortening the valve guide. The distance from the cutter edges to the adjustable collar face must be set at .575". Refer to Figure 2. Always check the required distance with a Vernier caliper as shown in Figure 3.

Procedure

1. Apply cutting oil to the refaced valve seat and the end of the valve guide.

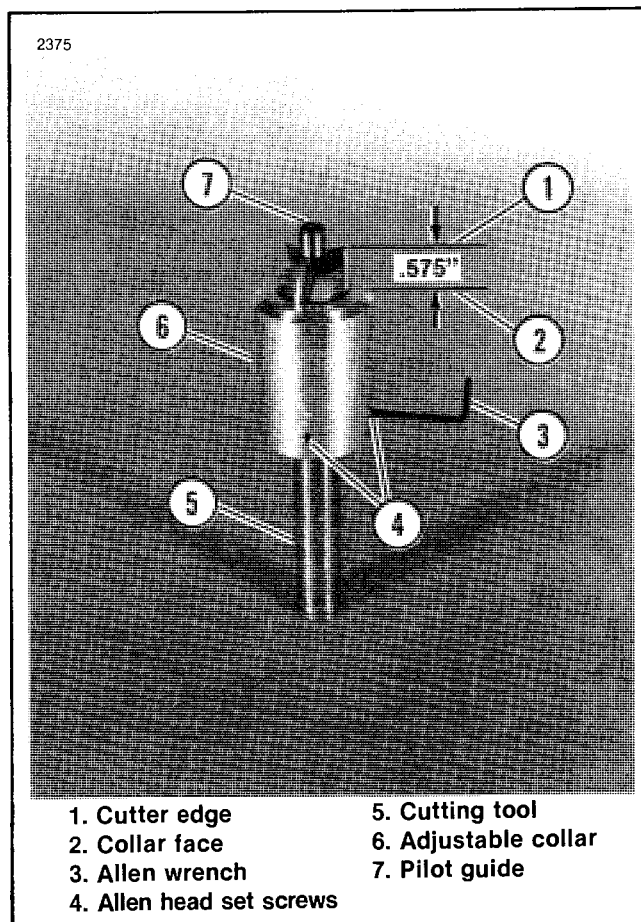


Figure 2. Gauge/Cutting Tool

2. Insert the cutting tool with the smaller diameter pilot end into the valve guide bore.
3. Insert a speed handle into the drive end of the cutting tool. See Figure 4.
4. Rotate the handle and tool in a clockwise direction until the tool collar contacts the machined valve seat surface in the cylinder head.
5. Remove the tool and deburr the valve guide bore.

ROUTING:	SERVICE MANAGER	SALES MANAGER	PARTS MANAGER	CHIEF MECHANIC	MECHANIC NO. 1	MECHANIC NO. 2	MECHANIC NO. 3	MECHANIC NO. 4	RETURN THIS TO:
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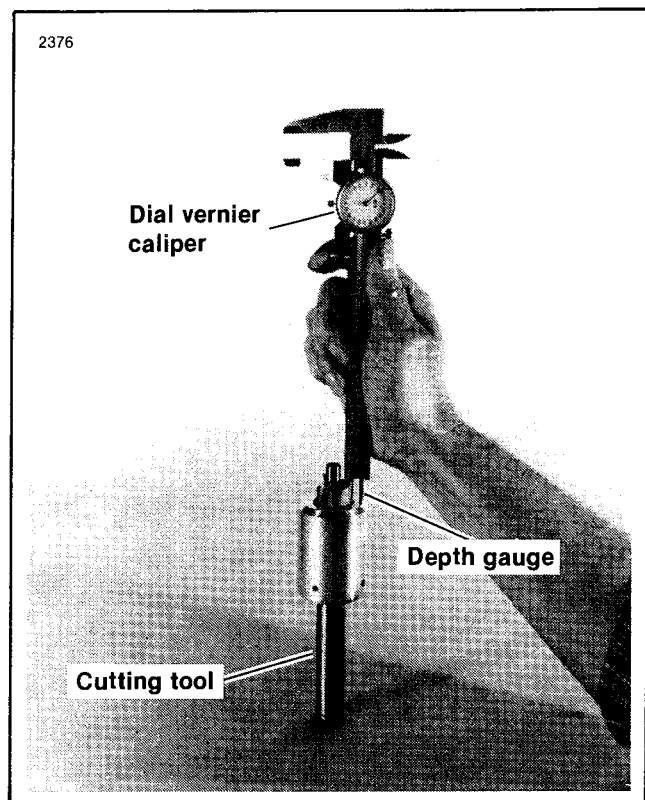


Figure 3. Gauging Collar Position

NOTE

Refer to the latest Service Manual for inspection, reconditioning and assembly procedures.

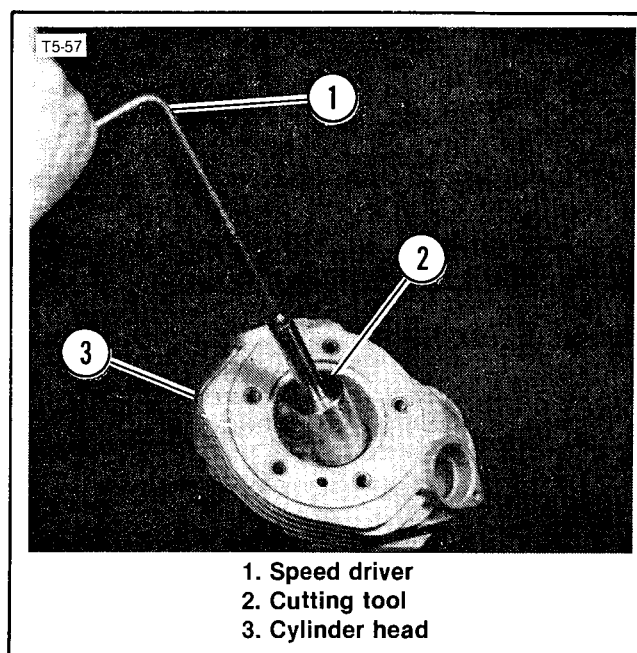


Figure 4. Cutting Valve Guide

CAUTION

The Gauge/Cutting tool is a precision instrument. Always handle carefully. Clean the tool after each usage and apply a light coat of oil to all the surfaces of the cutter and pilot.