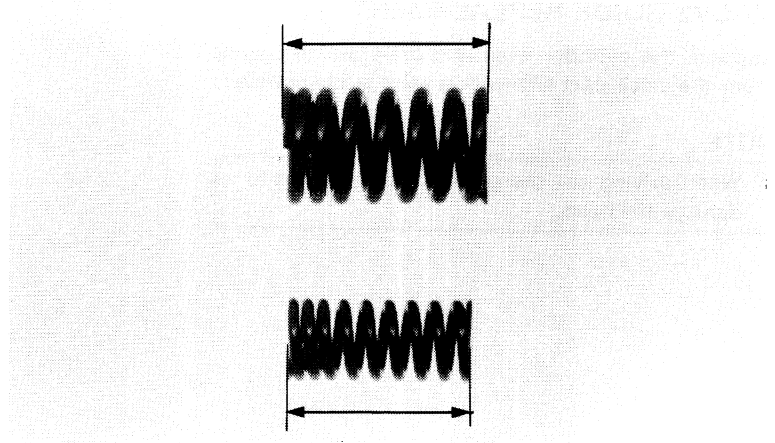


VALVE SPRING INSPECTION

Measure the free length of the inner and outer valve springs.

SERVICE LIMITS:

- INNER: 35.5 mm (1.40 in)
- OUTER: 41.0 mm (1.61 in)



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's O.D.

SERVICE LIMITS:

- INTAKE: 5.42 mm (0.213 in)
- EXHAUST: 5.40 mm (0.213 in)

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

Measure and record the valve guide I.D.

SERVICE LIMIT: 5.50 mm (0.217 in)

Calculate the stem-to-guide clearance.

SERVICE LIMITS:

- INTAKE: 0.12 mm (0.005 in)
- EXHAUST: 0.14 mm (0.006 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 the valve guide is replaced, the valve seat must be refaced.

