



Figure 10. Measuring the Weight of the Valve Seat Inset

6. Measure the outside diameter of the valve seat inset. See Figure "Measuring the Outside Diameter of the Valve Seat Inset".



Figure 11. Measuring the Outside Diameter of the Valve Seat Inset

7. Calculate the machining adjustment. See Figure "Determining the Machining Adjustment".



Figure 12. Determining the Machining Adjustment

8. Determine the valve seat inset bore (dimension "A" listed in Table "Repair Stage Specifications").

Bore Bore in Cylinder Head - Outside Diameter of Valve Seat Inset			
(see Figure 10)		(see Figure 11)	
Intake	Exhaust	Intake	Exhaust
mm (in.)	mm (in.)	mm (in.)	mm (in.)
15.000-15.025 (40.000-40.025)	15.075-15.100	40.075-40.100	40.075-40.100
Standard	(1.178-1.179) (1.175-1.176)	(1.5887-1.5911)	(1.1775-1.1779)
15.000-15.025 (40.000-40.025)	15.075-15.100	40.075-40.100	40.075-40.100
Standard	(1.178-1.179) (1.175-1.176)	(1.5887-1.5911)	(1.1775-1.1779)
15.000-15.025 (40.000-40.025)	15.075-15.100	40.075-40.100	40.075-40.100
Stage 1	(1.178-1.179) (1.174-1.175)	(1.4004-1.4008)	(1.1875-1.1876)

Table 12. Repair Stage Specifications

Note: Choose the repair stage corresponding to the size of the outside diameter of the valve seat inset (dimension "B" listed in Table "Repair Stage Specifications"), as measured in the previous step.

9. Measure the diameter of the pilot (P). See Figure "Determining the Machining Adjustment".
10. Add the diameter of the pilot to the valve seat bore and divide by two. Use this formula:  $M = (A + P) / 2$ . Example: If the valve seat bore is 1.178 inches, and the diameter of the pilot is 0.571 inches,  $M = (1.178 + 0.571) / 2 = 1.851 / 2 = 0.926$  inches.

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