



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".

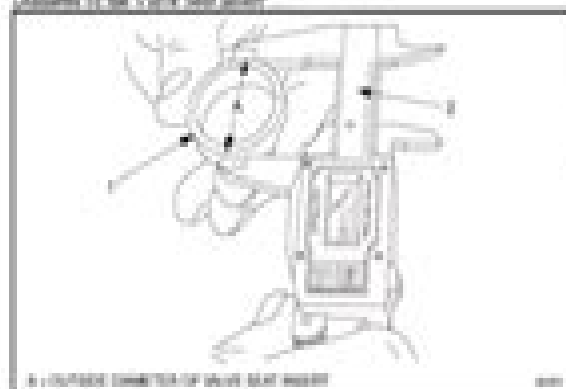


Figure 11. Measuring the Outside Diameter of the Valve Seat Inset

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

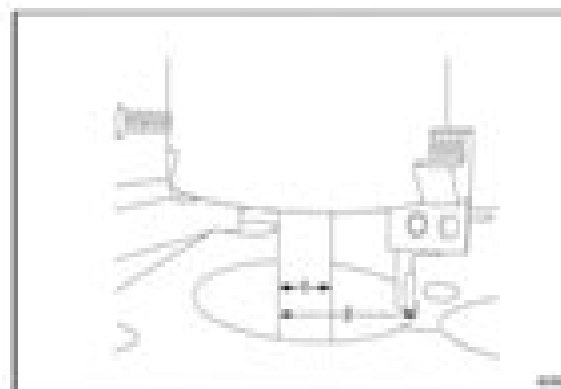


Figure 12. Determining the Machining Adjustment

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

| Base Base in Cylinder Head - Outside Diameter of Valve Seat Inset |                             |                 |                 |
|-------------------------------------------------------------------|-----------------------------|-----------------|-----------------|
| (see Figure 10)                                                   |                             | (see Figure 11) |                 |
| Inlet                                                             | Exhaust                     | Inlet           | 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   |                 |
| Standard                                                          | (1.578-1.579) (1.575-1.576) | (1.5807-1.5811) | (1.5775-1.5779) |
| 15.000-15.025 (40.000-40.025)                                     | 15.075-15.100               | 40.075-40.100   |                 |
| Standard                                                          | (1.580-1.581) (1.575-1.580) | (1.5805-1.5809) | (1.5805-1.5809) |
| 15.000-15.025 (40.000-40.025)                                     | 15.075-15.100               | 40.075-40.100   |                 |
| Stage 1                                                           | (1.580-1.580) (1.584-1.585) | (1.5804-1.5808) | (1.5875-1.5879) |

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 base and divide by two. Use this formula:  $M = (A + P) / 2$ . Example: If the valve seat base is 1.578 inches, and the diameter of the pilot is 0.571 inches,  $M = (1.578 + 0.571) / 2 = 1.051 / 2 = 0.525$  inches.

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