



1. Valve Seat Inset 2. Measuring Device

Figure 10. Measuring the Weight of the Valve Seat Inset

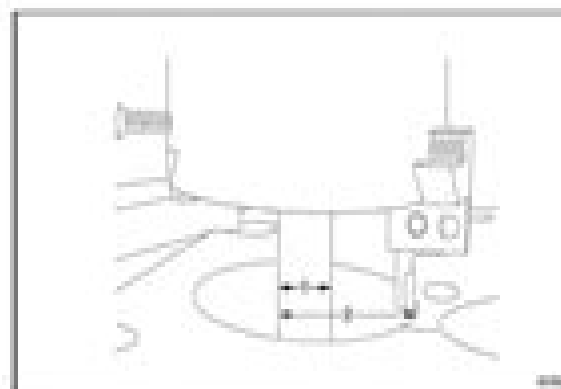
6. Measure the outside diameter of the valve seat inset. See Figure "Measuring Diameter of the Valve Seat Inset".



1. Valve Seat Inset 2. Measuring Device

Figure 12. Measuring the Outside Diameter of the Valve Seat Inset

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



1. Pilot Seat Diameter (P) 2. Machining Adjustment (M)

Figure 13. Determining the Machining Adjustment



- value for the valve seat inset bore (dimension "A" listed in Table "Repair Stage Specs").

Insert Bore is Cylinder Head - Outside Diameter of Valve Seat Inset

|            | (see Figure 10)               |               | (see Figure 12) |                 |
|------------|-------------------------------|---------------|-----------------|-----------------|
|            | Inlet                         | Exhaust       | Inlet           | Exhaust         |
| mm (in.)   | mm (in.)                      | mm (in.)      | mm (in.)        | mm (in.)        |
| Standard   | 11.000-11.020 (41.000-41.021) | 11.015-11.030 | 40.015-40.030   | 40.015-40.030   |
|            | (1.176-1.179)                 | (1.175-1.179) | (1.1805-1.1811) | (1.1775-1.1779) |
| Standard 1 | 11.000-11.020 (41.000-41.021) | 11.015-11.030 | 40.015-40.030   | 40.015-40.030   |
|            | (1.180-1.181)                 | (1.175-1.180) | (1.1805-1.1809) | (1.1805-1.1809) |
| Stage 1    | 11.000-11.020 (41.000-41.021) | 11.015-11.030 | 40.015-40.030   | 40.015-40.030   |
|            | (1.180-1.180)                 | (1.184-1.185) | (1.4004-1.4008) | (1.1875-1.1878) |

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.

8. Measure the diameter of the pilot (P). See Figure "Determining the Machining Adjustment".
9. 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 0.573 inches,  $M = (1.178 + 0.573) / 2 = 1.851 / 2 = 0.926$  inches.

# Mbe 900 Shop Manual

**M Walker**



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