

Fig. 8
Cylinder Head Bolt Tightening Sequence

The valves operate in guides machined directly in the cylinder head, although in some instances valve guides may be fitted and are available in service. When fitting valve guides, press each new guide into the cylinder head until the plain end is flush with the spot faced boss in the valve port.

Where the guides are machined directly in the cylinder head the bores may be reamed 0.38 mm. (0.015 in.) or 0.76 mm. (0.030 in.) oversize with reamer Tool No. P.6056-015 or P.6056-030 respectively. Valves with 0.38 mm. (0.015 in.) or 0.76 mm.

(0.030 in.) oversize stems can then be fitted. This, of course, may also be done where the guides are replaceable. After fitting new valve guides or reaming the valve stem bore the valve seats must be recut to ensure that the seat is concentric with the valve stem bore.

Recut the seats with cutters Tool No. FMC.317-24 (exhaust) and 317-27 (inlet) fitted to pilot Tool No. 316-10 in handle Tool No. 316X. Where necessary, the seats may be narrowed with top face cutters Tool No. 317T-24 (exhaust) and FMC.317-27 (inlet). The valve seats should also be recut when they show signs of pitting or burning and when fitting new inlet valves.

Replaceable valve seat inserts are available and should be fitted where necessary. Where inserts have not been fitted previously it will be necessary to machine a recess in the cylinder head for the appropriate valve seat insert. If, for any reason, an existing insert has become loose or damaged, oversize inserts can be fitted.

The sizes for machining the recesses for standard and oversize valve seat inserts are tabulated in the Specification section.

Valve seat inserts may be removed by inserting a suitable chisel under the insert and striking smartly when the insert will be forced out of its location. Care should be taken in this operation to avoid damage to the combustion chamber.

To fit a new insert, select the correct size and enter the insert with the chamfered edge away from the combustion chamber and press into place using insert replacer tools made to the dimensions shown in Fig. 10. After fitting the inserts, the seats must be cut with the appropriate cutter tools to the dimensions in Fig. 9.

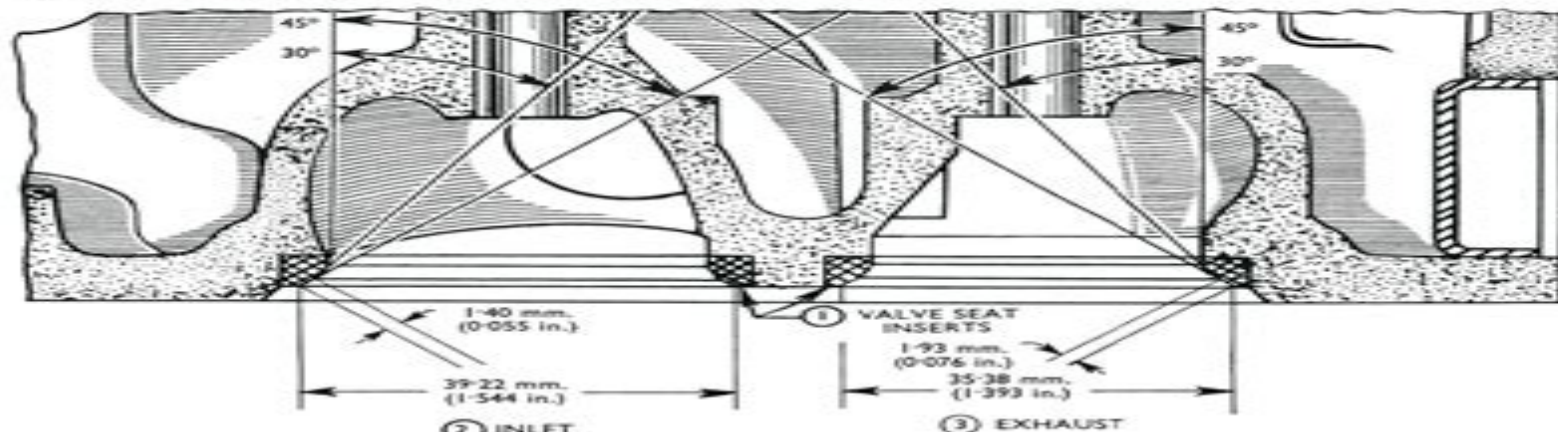


Fig. 9
Valve Seat Insert Machining Dimensions

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Terry C. Jones

A red circular graphic with a gradient, appearing as a semi-circle or a partial circle, located to the right of the author's name.

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