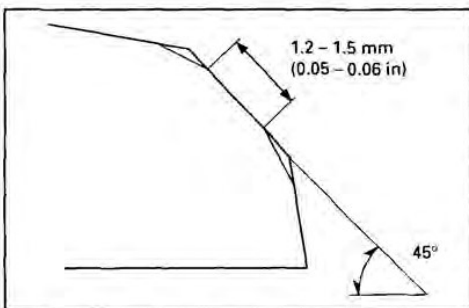


## CYLINDER HEAD/VALVES

Install a 45 degree seat cutter and cut the seat to proper width.

Make sure that all pitting and irregularities are removed. Refinish if necessary.

**STANDARD SEAT WIDTH: 1.2 – 1.6 mm (0.05 – 0.06 in)**



Apply thin coat of Prussian Blue to the valve seat. Press the valve through the valve guide and onto the seat to make a clear pattern.

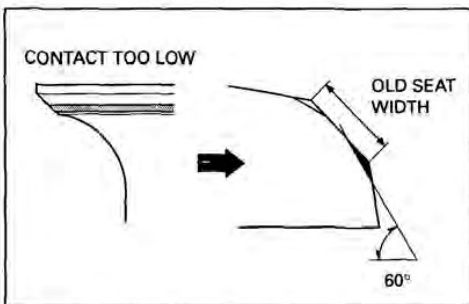
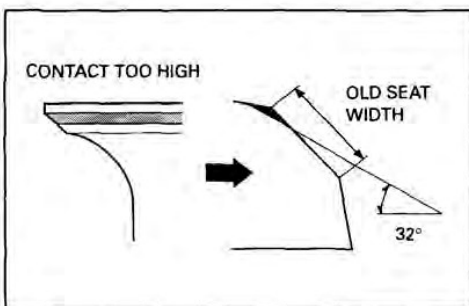
### NOTE:

The location of the valve seat in relation to the valve face is very important for good sealing.

If the contact area is too high on the valve, the seat must be lowered using a 32 degree flat cutter.

If the contact area is too low on the valve, the seat must be raised using a 60 degree inner cutter.

Refinish the seat to specifications, using a 45 degree seat cutter.



### CAUTION:

- Excessive lapping pressure may deform or damage the seat.
- Change the angle of lapping tool frequently to prevent uneven seat wear.
- Lapping compound can cause damage if it enters between the valve stem and guide.

After cutting the seat, apply lapping compound to the valve face and lap the valve using light pressure.

After lapping, wash any residual compound off the cylinder head and valve.

Recheck the seat contact after lapping.

