

~~I → Q = 0.0017~~

~~II → I = 0.0018~~

~~III →~~

Piston/Cylinder Clearance

(0.031-0.058mm)
0.0012-0.023 in

- 0.0017-0.0019 in

Piston ring gap

(Max = 0.028 in)

I → 0.011-0.017

Valve spring pressure

(inner 52) I (outer 97.2)

IN
59/112

EX
58/112

II

59/115

60/112

59/115

59/112

59/115

58/114

59/113

58/115

60/113

58/112 lbs

Valve stem clearance

Int: 0.0015

Ex: 0.0022

Valve stem height

Ex (1.460-1.492)

- 1.482 -

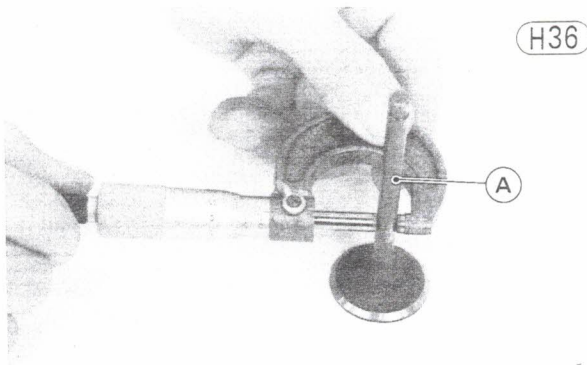
In (1.4645-1.496)

- 1.480 -

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Measure the diameter of the valve stem with a micrometer. Since the stem wears unevenly, take measurements at four places up and down the stem, keeping the micrometer at right angles to the stem.

Replace the valve if the stem is worn to less than the service limit.



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A. Valve Stem

Table H20 Valve Stem Diameter

	Inlet	Exhaust
Service Limit	6.90 mm	6.89 mm

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Valve guide inspection

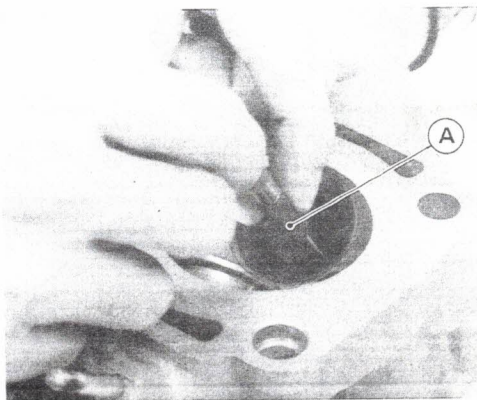
Remove the valve, and measure the inside diameter of the valve guide using a small bore gauge and micrometer. Since the guide wears unevenly, measure the diameter at four places up and down the guide. If any measurement exceeds the service limit, replace the guide.

HONED STOCK TO .0015 INT
WAS S/A
MAX .006
.0022 INT

Table H21 Valve Guide Inside Diameter

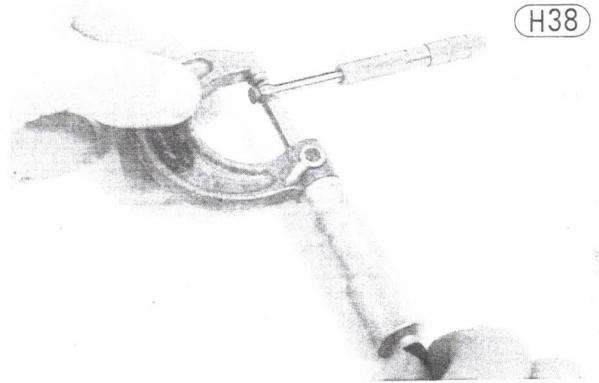
Service Limit	7.08 mm
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A. Small Bore Gauge



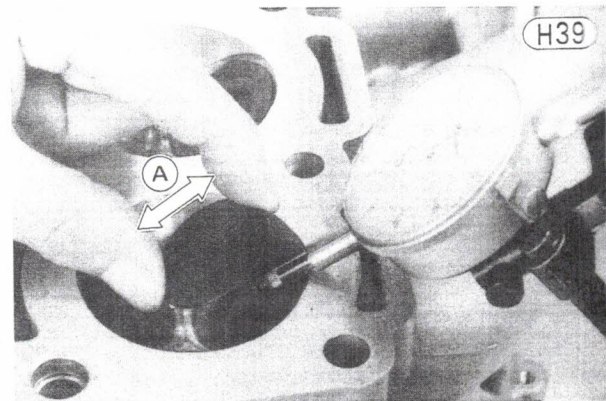
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If a small bore gauge is not available, inspect the valve guide wear by measuring the valve to valve guide clearance with the wobble method, as indicated below.

Insert a new valve into the guide and set a dial gauge against the stem perpendicular to it as close as possible to the cylinder head mating surface. Move the stem back and forth to measure valve/valve guide clearance. Repeat the measurement in a direction at a right angle to the first.

If the reading exceeds the service limit, replace the guide.

NOTE: The reading is not actual valve/valve guide clearance because the measuring point is above the guide.



H39

A. Move the valve.

Table H22 Valve/Valve Guide Clearance (Wobble Method)

	Inlet	Exhaust
Service Limit	0.23 mm	0.24 mm

Valve seat inspection and repair

The valve must seat in the valve seat evenly around the circumference over the specified area. If the seating area is too wide, the seating pressure per unit of area is reduced, which may result in compression leakage and carbon accumulation on the seating surface. If the seating area is too narrow, heat transfer from the valve