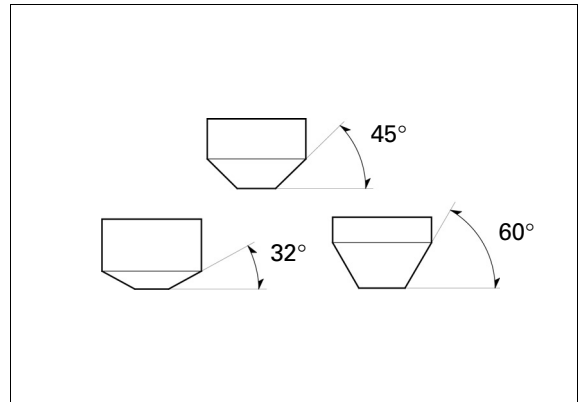


## CYLINDER HEAD/VALVES

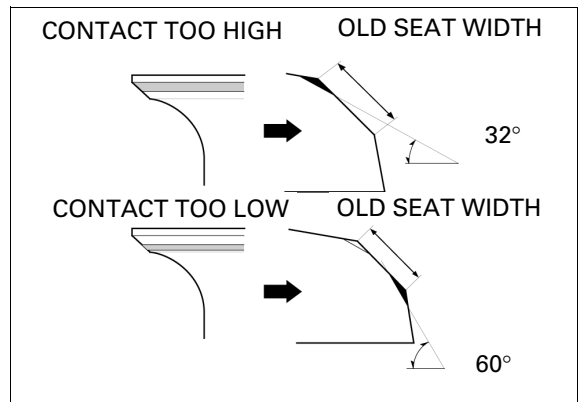
### VALVE SEAT REFACING

- Follow the refacing manufacturer's operating instructions.
- Be careful not to grind the seat more than necessary.



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

If the contact area is too low on the valve, the seat must be raised using a 60° interior cutter. Refinish the seat to specifications, using a 45° finish cutter.

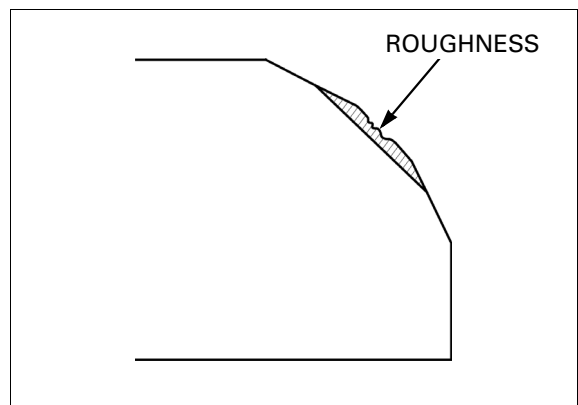


*Reface the seat with a 45-degree cutter whenever a valve guide is replaced.*

Use a 45° seat cutter, remove any roughness or irregularities from the seat.

**TOOLS:**

- |                                       |                      |
|---------------------------------------|----------------------|
| <b>Seat cutter, 27.5 mm (IN, 45°)</b> | <b>07780-0010200</b> |
| <b>Seat cutter, 24 mm (EX, 45°)</b>   | <b>07780-0010600</b> |
| <b>Cutter holder, 5.0 mm</b>          | <b>07781-0010400</b> |



Use a 32° flat cutter, remove the top 1/4 of the existing valve seat material.

**TOOLS:**

- |                                     |                      |
|-------------------------------------|----------------------|
| <b>Flat cutter, 27 mm (IN, 32°)</b> | <b>07780-0013300</b> |
| <b>Flat cutter, 22 mm (EX, 32°)</b> | <b>07780-0012601</b> |
| <b>Cutter holder, 5.0 mm</b>        | <b>07781-0010400</b> |

