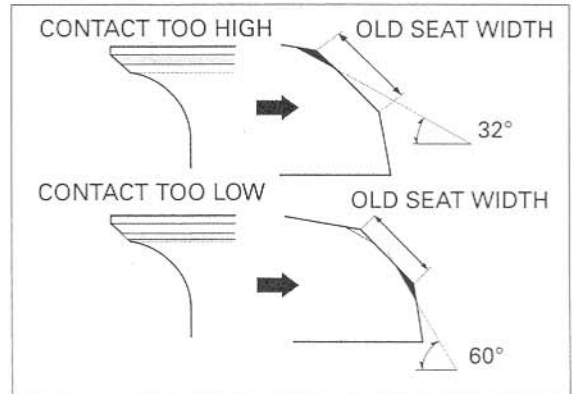


CYLINDER HEAD/VALVES

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 interior cutter.



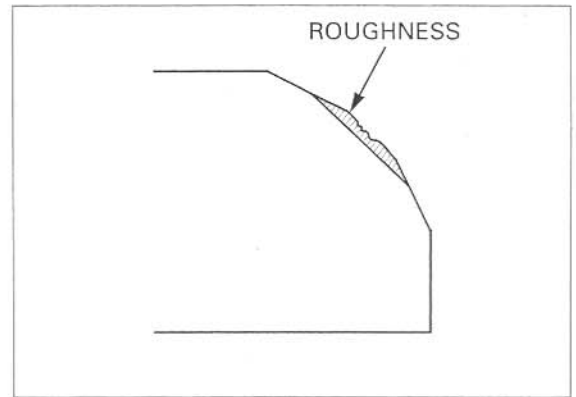
Reface the seat with a 45-degree cutter whenever a valve guide is replaced.

Use a 45-degree cutter to remove any roughness or irregularities from the seat.

TOOLS:

Seat cutter, 27.5 mm (IN)
 Seat cutter, 24 mm (EX)
 Cutter holder, 4.0 mm

07780-0010200
 07780-0010600
 07781-0010500 or
 equivalent commercially
 available in
 U.S.A.

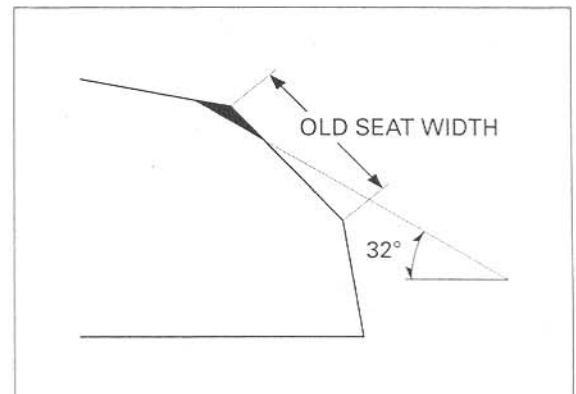


Use a 32-degree cutter to remove the top 1/4 of the existing valve seat material.

TOOLS:

Flat cutter, 30 mm (IN)
 Flat cutter, 24 mm (EX)
 Cutter holder, 4.0 mm

07780-0012200
 07780-0012500
 07781-0010500 or
 equivalent commercially
 available in
 U.S.A.



Use a 60-degree cutter to remove the bottom 1/4 of the old seat.

TOOLS:

Interior cutter, 26 mm (IN)
 Interior cutter, 22 mm (EX)
 Cutter holder, 4.0 mm

07780-0014500
 07780-0014202
 07781-0010500 or
 equivalent commercially
 available in
 U.S.A.

