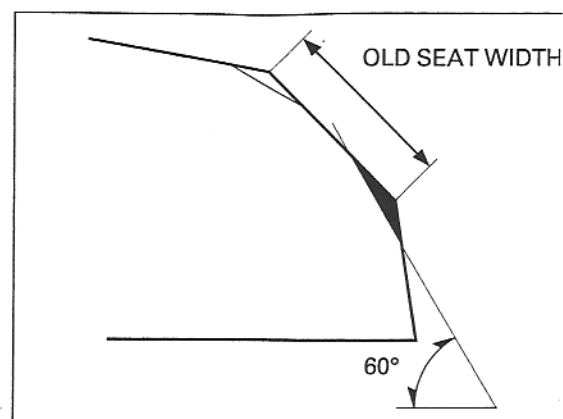
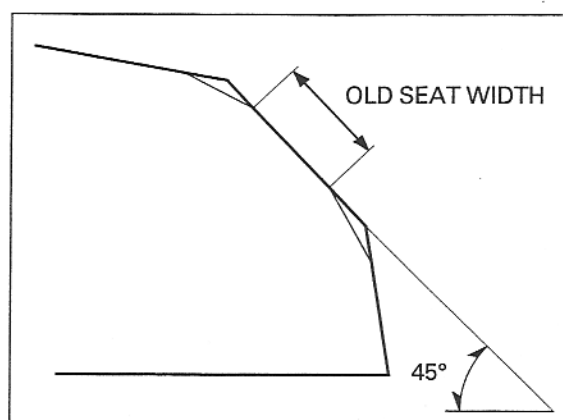


Use a 60 degree cutter to remove the bottom 1/4 of the old seat.
Remove the cutter and inspect the area you have refaced.



Install a 45 degree finish cutter and cut the seat to the proper width.
Make sure that all pitting and irregularities are removed.
Refinish if necessary.



Apply a 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.

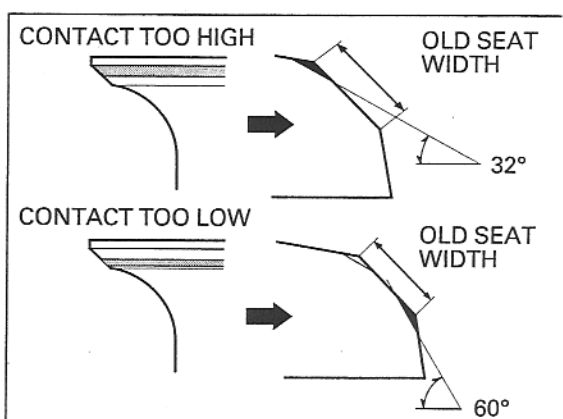
If the contact area is too low on the valve, the seat must be raised using a 60 degree inner cutter.

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

Do not allow lapping compound to enter the guides.

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

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



HAND-LAPPING TOOL

