

124 MAINTENANCE

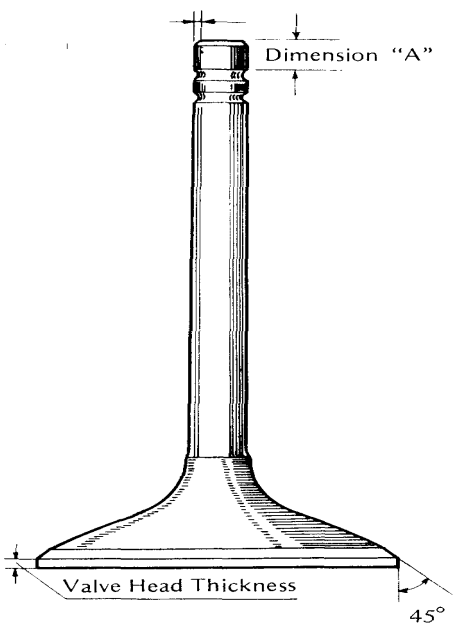
The valve stem end may be ground to permit additional valve clearance, use a refacing grinder to assure a flat, square surface.

Caution If the valves Dimension "A" is less than specified, the valve lifter may contact the valve spring retainer during operation, allowing the keepers to loosen. Consequently, the valve may drop into the engine, causing serious damage.

Valve Shape

Do not grind off more than 0.3 mm.

A = Minimum after grinding
 5.7 mm (Inlet)
 4.7 mm (Exhaust)

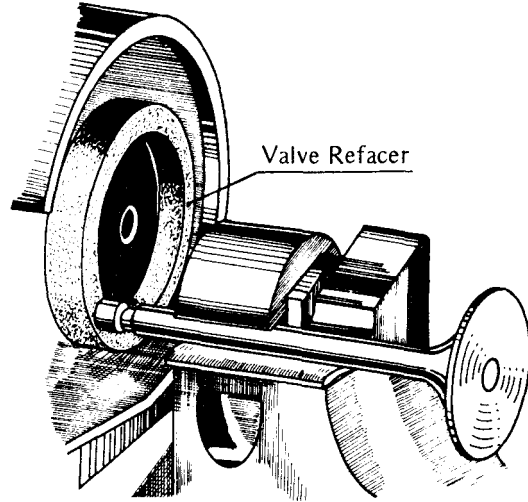


425

Hold the valve at both ends of the stem straight portion, and set a dial gauge against the center of the stem. One example is shown in Fig. 427.

**Valve Stem Bend
 Valve Stem Grinding**

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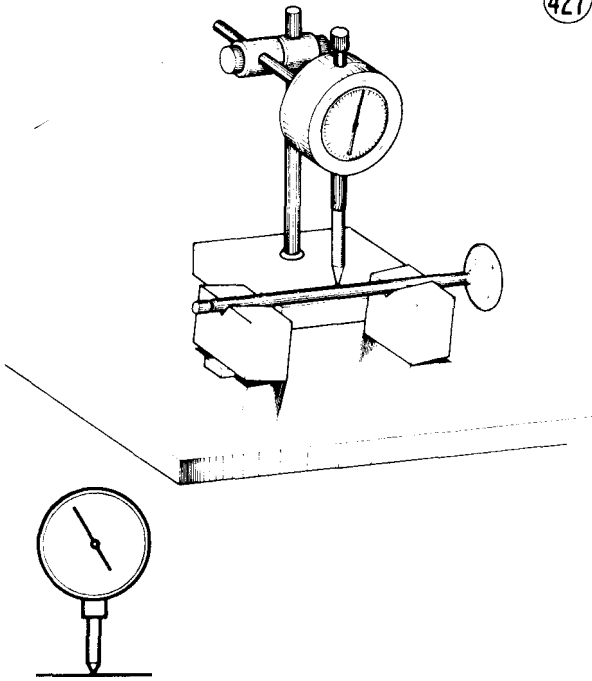


Valve Stem 428

Table 23 Valve Head Thickness

Standard	Service Limit
0.85~1.15 mm	0.5 mm

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Turning the valve, read a variation in the dial gauge. Replace the valve if it is bent over the service limit.

Table 24 Valve Stem Bend

Standard	Service Limit
under 0.01 mm	0.05 mm

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.

