

VALVE GUIDE REAMING SETS



FIG. 1. The H. O. Lee valve guide reaming tool is designed to remove any metal excess which does not valve guide as part of the cylinder head. These tools can be used to install oversize stem valves or replaceable valve guides.

1



FIG. 2. The H. O. Lee valve guide reaming tool is designed to remove any metal excess which does not valve guide as part of the cylinder head. These tools can be used to install oversize stem valves or replaceable valve guides.

2



FIG. 3. The H. O. Lee valve guide reaming tool is designed to remove any metal excess which does not valve guide as part of the cylinder head. These tools can be used to install oversize stem valves or replaceable valve guides.

3

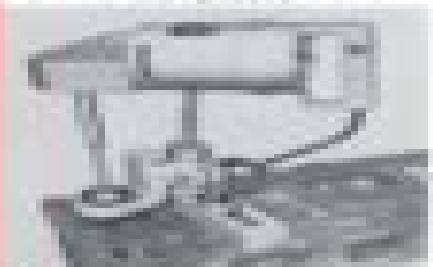


FIG. 4. The H. O. Lee valve guide reaming tool is designed to remove any metal excess which does not valve guide as part of the cylinder head. These tools can be used to install oversize stem valves or replaceable valve guides.

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The H. O. Lee valve guide reaming tools are designed to remove any metal excess which does not valve guide as part of the cylinder head. These tools can be used to install oversize stem valves or replaceable valve guides.

Installing Oversize Stem Valves

This is accomplished by reaming out the valve guide for oversize stem valves. Most of the engine and valve manufacturers now offer at least three sizes of oversize valves.

The H. O. Lee valve guide reamer provides a true alignment with original guide bore using Lee self-aligning pilot. The reamer is held rigid with reaming bar during reaming operation. Results in square and extremely accurate bore. Tools available described on page 2.

Installing Replaceable Valve Guides

When old valves are still serviceable, it is more economical to install replaceable valve guides. Roughing and finishing reamers used with the H. O. Lee valve guide reamer run the bore for a replaceable guide. A complete fitting of the replaceable valve guides, roughing and finishing reamers, and reaming pilot available are listed on page 2. Guide service data on both pages.

OPERATING INSTRUCTIONS

FOR INSTALLING OVERSIZE STEM VALVES

Clean out valve guide hole with an H7000 valve Solid Valve Guide Reamer. Position self-aligning pilot in valve guide with H7000 Pilot Wrench. Loosen all screws of reamer guide assembly and install pilot aligning bar in reamed hole. Position with an expanding pilot. Reamer can only clamp and can be aligned to steel face. Tighten clamp nut with finger until face is held firmly to block. Tighten screws and ball rollers. Loosen clamp nut, reposition and turn to block as shown in photo number 1. (NOTE: To insure extreme accuracy it may be necessary to loosen and tighten screws of reamer guide assembly several times.)

Remove expanding pilot and aligning bar. Position pilot reamer in valve guide. Install reaming bar on top of reamer as shown in photo number 2.

In photo number 3, Reaming Bar is shown in position in reamed hole, providing true alignment. Pilot is now ready for reaming. It should be used for hand operation.

Power Drive H7000, adaptable to a power unit, is shown in photo number 4. Available with 150 or 250 rpm universal motor.

FOR INSTALLING REPLACEABLE VALVE GUIDES

The same procedure is used when installing replaceable valve guides. Just be aware that the replaceable guide you wish to install has an O.D. of .01. In photo 2, the H7000 roughing reamer would be used with the H7000C bar. The roughing reamer operation would be followed with the H7000C Guide Head or H7000 High Speed Head finishing reamer using the same bar. In all roughing and finishing reamers, a 1/2 inch drill is recommended. All new valve guides should be installed with some type of grease. O.D. of valve guide and hole must be lubricated before attempting to install guide. It is necessary to run 1.00 of guide after installation, use H7000 valve solid reamer shown on page 2.

Circle 10 on Reader Service Card

Circle 11 on Reader Service Card

Valve Guide Tool For Ko Lee

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, **Operator, Organizational, Direct Support, and General Support Maintenance Manual Including Repair Parts List for Grinding Kit, Valve Seat (K O Lee Co, Inc) (4910-00-060-9983).** ,1989 *Chilton Automotive Buyer's Guide* ,1949 **I&T Product File** ,1997 **Small Air-cooled Engine Service Manual, 1990-1994** ,1995 Previously published as one volume under same title *Operator's, Organizational, Direct Support and General Support Maintenance Manual Including Repair Parts List for Grinding Machine, Valve Face, Model K403C and K500C, (K.O. Lee Co.), (NSN 4910-00-540-4679).* ,1989 *String Trimmer and Blower* Intertec Publishing Corporation,1992 Provides detailed information on how to operate maintain and repair string trimmers and blowers the following manufacturers of electric and gasoline powered string trimmers and blowers are covered Alpina Black specific repair instructions for string trimmer and blower gasoline engines are covered for the following manufacturers John Deere Echo Efco Fuji Homelite Husqvarna IDC Kawasaki Kioritz Komatsu McCulloch Mitsubishi Piston Powered Products Poulan Sachs Dolmar Shindaiwa Stihl Tanaka TAS Tecumseh TML Trail Page 4 of cover *The Tractor Field Book* ,1951 *Small AC Generator Service Manual* ,1986 **Motor** ,1928 **Canadian Automotive Trade** ,1960 *Farm Equipment Red Book* ,1961 **School Shop** ,1986 **Tractor Field Book** ,1951 *The Commercial Car Journal* ,1971 Beginning with 1937 the April issue of each vol is the Fleet reference annual **Fleet Owner** ,1984 **Bus & Truck Transport** ,1945 *Implement & Tractor* ,1961 *Landscaping the Gilded Age* Julie Cain,1944 Issue of Noticias del Puerto de Monterey dedicated to the Hotel del Monte garden in Monterey California designed by Rudolph Ulrich a German immigrant landscape architect **Automotive Service Digest** ,1954

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