

(Fig. 6-46). With all parts seated, step end of gauge should be at least flush with gasket face of head, but should not project past the step on the gauge.

b. If gauge projects too far, indicating that the valve stem is too long, grind the tip of the valve stem as necessary to make the gauge index properly.

CAUTION: When grinding valve stem be very careful not to overheat it. Overheating will soften the hardened stem causing rapid wear.

FITTING VALVE STEMS TO GUIDES

Correct valve stem clearance for valve guides is .0016" to .0033" for the intake valve and .0021" to .0038" for the exhaust valve.

Valves with oversize stems are available in .001", .003" and .005" larger than standard. The same valve stem to guide clearance applies for oversize stems.

Oversize reamers are required to enlarge valve guide holes to fit the oversize stems. When the reamer is turned through the valve guide it will size the hole to fit the valve stem according to the above limits.

Carefully ream the valve guide using Valve Guide

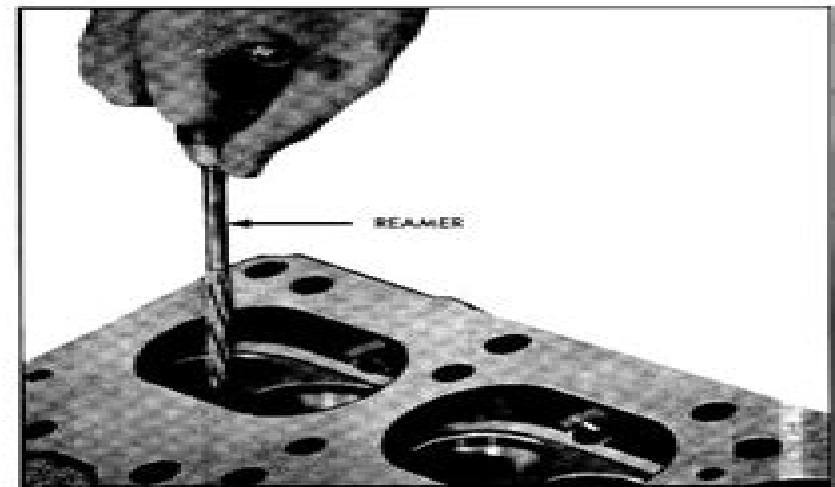


Fig. 6-47 Fitting Valve Stems to Guide

Reamer J-5830-1 for .003" oversize stems and Valve Guide Reamer J-6621 for .005" oversize stems (Fig. 6-47). For best results when installing .005" oversize valve stem use the .003" oversize reamer first and then ream to .005" oversize. Always reface the valve and valve seat after reaming valve guide. **NOTE:** Valves are marked .001, .003 or .005 with colored ink.

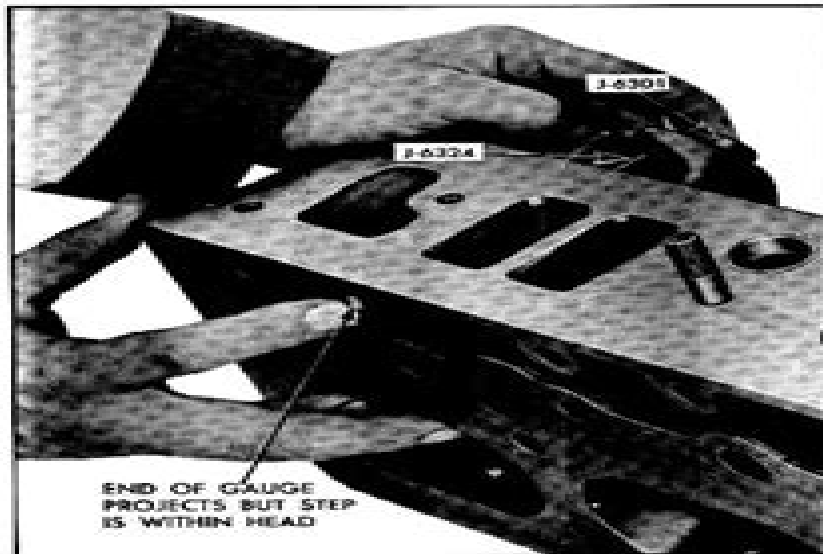


Fig. 6-46 Checking Length of Valve Stem

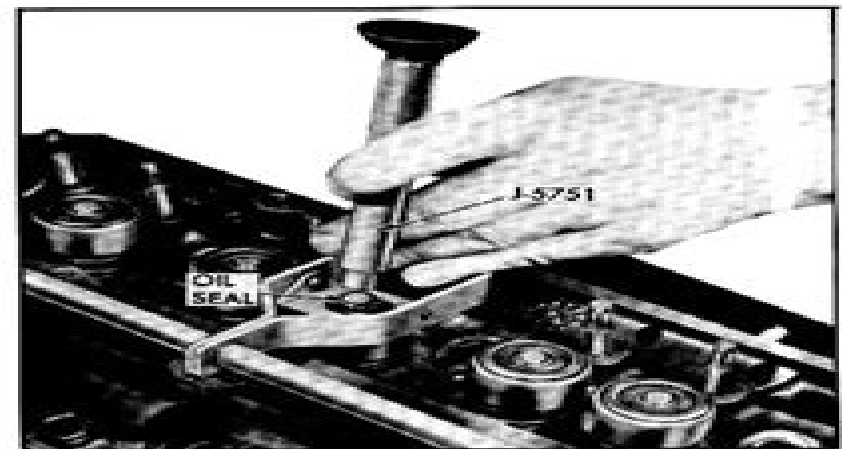


Fig. 6-48 Installing Valve Stem Seal

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J. “Kelly” Flory, Jr.



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1. Understanding the eBook Pontiac Manual Page 1960
 - The Rise of Digital Reading Pontiac Manual Page 1960
 - Advantages of eBooks Over Traditional Books
2. Identifying Pontiac Manual Page 1960
 - Exploring Different Genres
 - Considering Fiction vs. Non-Fiction
 - Determining Your Reading Goals
3. Choosing the Right eBook Platform
 - Popular eBook Platforms
 - Features to Look for in an Pontiac Manual Page 1960
 - User-Friendly Interface
4. Exploring eBook Recommendations from Pontiac Manual Page 1960
 - Personalized Recommendations
 - Pontiac Manual Page 1960 User Reviews and Ratings
 - Pontiac Manual Page 1960 and Bestseller Lists
5. Accessing Pontiac Manual Page 1960 Free and Paid eBooks
 - Pontiac Manual Page 1960 Public Domain eBooks
 - Pontiac Manual Page 1960 eBook Subscription Services
 - Pontiac Manual Page 1960 Budget-Friendly Options
6. Navigating Pontiac Manual Page 1960 eBook Formats

- ePub, PDF, MOBI, and More
- Pontiac Manual Page 1960 Compatibility with Devices
- Pontiac Manual Page 1960 Enhanced eBook Features
- 7. Enhancing Your Reading Experience
 - Adjustable Fonts and Text Sizes of Pontiac Manual Page 1960
 - Highlighting and Note-Taking Pontiac Manual Page 1960
 - Interactive Elements Pontiac Manual Page 1960
- 8. Staying Engaged with Pontiac Manual Page 1960
 - Joining Online Reading Communities
 - Participating in Virtual Book Clubs
 - Following Authors and Publishers Pontiac Manual Page 1960
- 9. Balancing eBooks and Physical Books Pontiac Manual Page 1960
 - Benefits of a Digital Library
 - Creating a Diverse Reading Collection Pontiac Manual Page 1960
- 10. Overcoming Reading Challenges
 - Dealing with Digital Eye Strain
 - Minimizing Distractions
 - Managing Screen Time
- 11. Cultivating a Reading Routine Pontiac Manual Page 1960
 - Setting Reading Goals Pontiac Manual Page 1960
 - Carving Out Dedicated Reading Time
- 12. Sourcing Reliable Information of Pontiac Manual Page 1960
 - Fact-Checking eBook Content of Pontiac Manual Page 1960
 - Distinguishing Credible Sources
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 - Utilizing eBooks for Skill Development
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