

1D



Valve Seat Repair

Refer to [Valve / Valve Spring Removal and Installation](#).

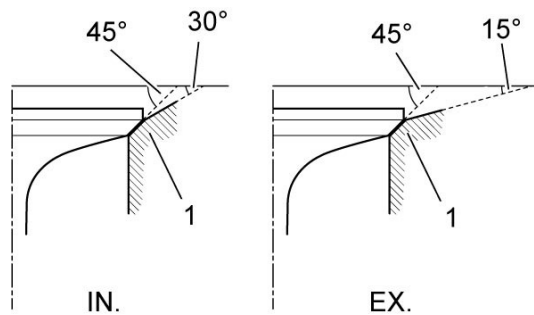
The valve seats (1) for both the intake and exhaust valves are machined to two different angles. The seat contact surface is cut at 45°.

NOTICE:

- The valve seat contact area must be inspected after each cut.
- Do not use lapping compound after the final cut is made. The finished valve seat should have a velvety smooth finish but not a highly polished or shiny finish. This will provide a soft surface for the final seating of the valve which will occur during the first few seconds of engine operation.

NOTE:

After servicing the valve seats, be sure to check the valve clearance after the cylinder head has been installed.



	Intake	Exhaust
Seat angle	30°/45°	15°/45°
Seat width	1.17 – 1.37 mm (0.046 – 0.054 in)	1.31 – 1.51 mm (0.052 – 0.059 in)
Valve diameter	36 mm (1.4 in)	33 mm (1.3 in)
Valve guide I.D.	5.500 – 5.512 mm (0.2165 – 0.2170 in)	←