

Valve Seat Grinding

Meets NATEF Task: Not specified by NATEF

Name _____ Date _____ Time on Task _____

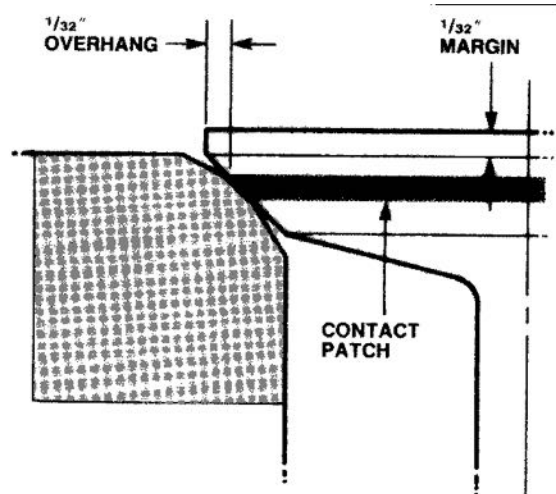
Make/Model/Year _____ VIN _____ Evaluation: 4 3 2 1

- _____ 1. Clean the valve guide.
- _____ 2. Choose the proper pilot for the guide.
- _____ 3. Insert the pilot. (Do not force the pilot.)
- _____ 4. Select the proper stones for each valve size. Make sure that the stones will not contact the side of the combustion chamber.
- _____ 5. Dress the stones to the proper angles for grinding.
- _____ 6. Grind the seat angle first. The width should be 1/8" to 3/16" wide.

OK _____ NOT OK _____

- _____ 7. Grind the topping angle.
- _____ 8. Grind the throating angle.
- _____ 9. When finished, the seat width should be 1/16" approximately.

OK _____ NOT OK _____



SEAT GRINDING SPECIFICATIONS

Intake Valve

Seat angle _____ Throat angle _____
 Topping angle _____ Interference angle _____
 Seat width _____ Pilot size _____

Exhaust Valve

Seat angle _____ Throat angle _____
 Topping angle _____ Interference angle _____
 Seat width _____ Pilot size _____