

# Valve Guide Specifications and Measurement

**Meets ASE Task:** (A1-B-9) P-3 Inspect valve guides for wear, check valve stem-to-guide clearance; determine needed action.

Name \_\_\_\_\_ Date \_\_\_\_\_ Time on Task \_\_\_\_\_

Make/Model/Year \_\_\_\_\_ VIN \_\_\_\_\_ Evaluation: 4 3 2 1

\_\_\_\_\_ 1. Specification for valve guide bore diameter: \_\_\_\_\_

\_\_\_\_\_ 2. Specification for maximum valve guide wear: \_\_\_\_\_

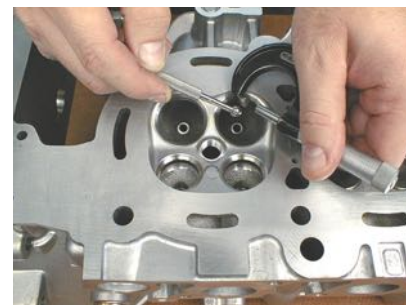
\_\_\_\_\_ 3. Use a small hole (split-ball) gauge and a 0-1" micrometer to measure the valve guide at three locations.

Top of the guide: \_\_\_\_\_

Middle of the guide: \_\_\_\_\_

Bottom of the guide: \_\_\_\_\_

OK \_\_\_\_\_ NOT OK \_\_\_\_\_



\_\_\_\_\_ 4. If the valve guides are worn beyond factory limits, select the replacement type.

\_\_\_\_\_ ream and install oversize (OS) valves

\_\_\_\_\_ thin wall bronze

\_\_\_\_\_ cast iron

\_\_\_\_\_ powdered metal (PM)

\_\_\_\_\_ other (describe): \_\_\_\_\_

\_\_\_\_\_ 5. What is the needed action? \_\_\_\_\_

\_\_\_\_\_