

Evaluation (Enter number from 4, 3, 2, 1) :\_\_\_\_\_\_\_\_\_

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

**Valve Guide Specifications and Measurement**

Name:\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_

Date:\_\_\_\_\_\_\_\_\_\_\_\_\_

Time on Task:\_\_\_\_\_\_\_\_\_\_\_\_\_

Make/Model/Year:\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_

VIN:\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_

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**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? \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_

\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_