

# Valve Guide Specifications and Measurement

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

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

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

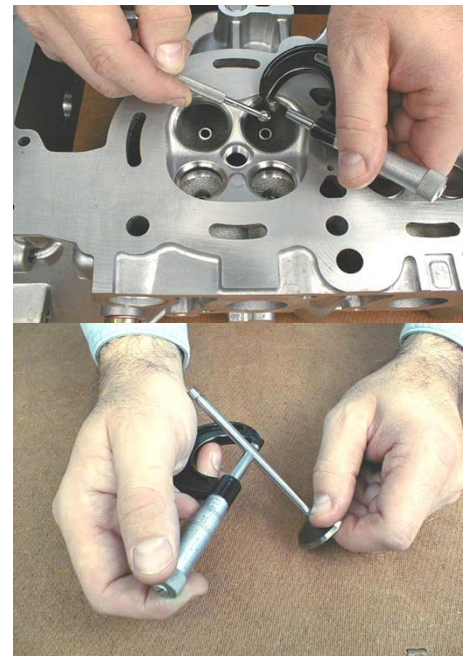
☐ 3. Use a small hole (split-ball) gauge and a 0-1" micrometer to measure the valve guide at three locations.

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? \_\_\_\_\_

\_\_\_\_\_