



Side cutaway view of Series B and M engines.

way through. Cut through the webbed portion of the insert with a sharp chisel and remove the two pieces.

To install an insert, pack in "dry lube" for at least fifteen minutes to allow the metal to contract, and heat the exhaust valve port area gradually, if necessary, to permit this material to expand. Then press the insert into the cylinder head or block, as the case may be, using extreme care to see that it is not twisted or misaligned. When installed, finish the seats with the grinding or lapping equipment already mentioned.

VALVE STEM GUIDES

1936-40 All: When necessary to replace valve stem guides on L-head engines, remove the valves and springs, remove the tappet adjusting screws and lift out the tappets. On overhead valve engines, simply remove the valves and springs.

On all engines, valve stem guides should be removed and installed with a suitable puller. However, if this equipment is not available, use a drill, preferably one having a pilot which is the same size as the valve stem, to drive out the guide.

NOTE—On all engines, it is good practice to remove and install one guide at a time.

When installing an intake guide, measure the depth of an intake guide not yet removed in order to determine the correct depth of the guide being installed. Similarly, this procedure should be followed when installing an exhaust guide. When installed, the guide should be seated to provide a clearance within the limits given in the VALVE SYSTEM table.

VALVE TAPPETS & GUIDES

1936-40 Tappets should be a free fit in their guides without excessive side play. If the tappet face is scored due to too close an adjustment, it must be replaced.

On some L-head engines, the tappets are assembled directly to guide holes cast in the cylinder block and can easily be removed without removing the oil pan or crankshaft. Simply take off the cylinder head, remove the valves and springs and lift out the tappets. It may be necessary to remove the tappet adjusting screws.

Other L-head engines have removable tappets pressed in the block and tappets are removed in the same manner as described above. When replacing tappet guide bushings, be sure to line up the oil grooves on the outside of the bushing with the oil feed hole in the crankcase.

An examination of the engine from service will readily show which installation is used.

NOTE—If reaming is required to establish the correct tappet-to-guide clearance, it may be accomplished without removing the crankshaft by using a reamer with a reasonable lead. When using this tool, take off the reamer head, insert the pilot shaft through the valve guide hole and install the reamer head on the shaft through the valve cover opening. Be sure to cover the crankshaft with a clean rag to protect it from iron filings. After the reaming operation is completed, carefully wipe out all chips and remove the rag from the crankshaft. Make a careful inspection to see that all filings and dust are removed. If the reaming equipment necessitated the removal of valve stem guides, install new guides as directed under VALVE STEM GUIDES.

On overhead valve engines, the tappets are of the mushroom type, carried in tappet guide clusters bolted to the side of the cylinder block. When worn, it is usually easier to replace the entire tappet and cluster assembly rather than try to use old tappets with new clusters or vice versa.

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