



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 valve guide. 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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1. Understanding the eBook Continental Engine Manual
 - The Rise of Digital Reading Continental Engine Manual
 - Advantages of eBooks Over Traditional Books
2. Identifying Continental Engine Manual
 - Exploring Different Genres
 - Considering Fiction vs. Non-Fiction
 - Determining Your Reading Goals
3. Choosing the Right eBook Platform
 - Popular eBook Platforms
 - Features to Look for in an Continental Engine Manual
 - User-Friendly Interface
4. Exploring eBook Recommendations from Continental Engine Manual
 - Personalized Recommendations
 - Continental Engine Manual User Reviews and Ratings
 - Continental Engine Manual and Bestseller Lists
5. Accessing Continental Engine Manual Free and Paid eBooks
 - Continental Engine Manual Public Domain eBooks

- Continental Engine Manual eBook Subscription Services
- Continental Engine Manual Budget-Friendly Options
- 6. Navigating Continental Engine Manual eBook Formats
 - ePub, PDF, MOBI, and More
 - Continental Engine Manual Compatibility with Devices
 - Continental Engine Manual Enhanced eBook Features
- 7. Enhancing Your Reading Experience
 - Adjustable Fonts and Text Sizes of Continental Engine Manual
 - Highlighting and Note-Taking Continental Engine Manual
 - Interactive Elements Continental Engine Manual
- 8. Staying Engaged with Continental Engine Manual
 - Joining Online Reading Communities
 - Participating in Virtual Book Clubs
 - Following Authors and Publishers Continental Engine Manual
- 9. Balancing eBooks and Physical Books Continental Engine Manual
 - Benefits of a Digital Library
 - Creating a Diverse Reading Collection Continental Engine Manual
- 10. Overcoming Reading Challenges
 - Dealing with Digital Eye Strain
 - Minimizing Distractions
 - Managing Screen Time
- 11. Cultivating a Reading Routine Continental Engine Manual
 - Setting Reading Goals Continental Engine Manual
 - Carving Out Dedicated Reading Time
- 12. Sourcing Reliable Information of Continental Engine Manual
 - Fact-Checking eBook Content of Continental Engine Manual
 - Distinguishing Credible Sources
- 13. Promoting Lifelong Learning
 - Utilizing eBooks for Skill Development
 - Exploring Educational eBooks

14. Embracing eBook Trends

- Integration of Multimedia Elements
- Interactive and Gamified eBooks

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