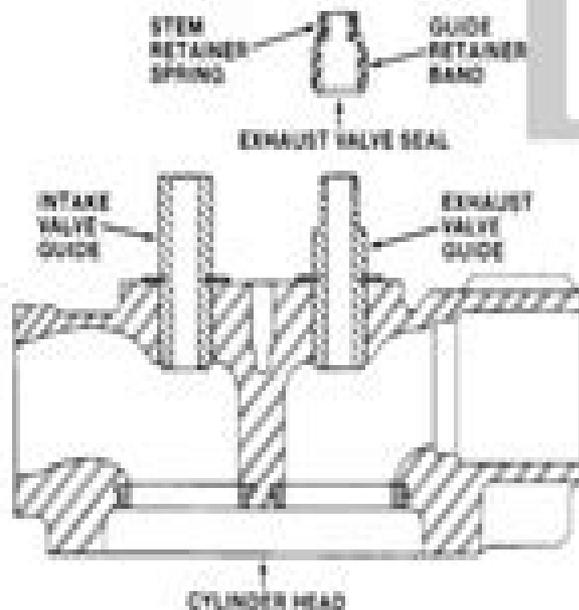


**KM1 EXHAUST VALVE SEAL**

Some KM1 cylinder heads utilize an exhaust valve seal which is installed on the exhaust valve guide. If replacing this seal, use the following precaution to prevent seal failure due to improper or incorrect seal installation.

When pressing an exhaust valve seal onto an exhaust valve guide, press on the seal guide retainer band only. Pressing directly on the valve seal body or stem retainer spring will distort the seal and result in seal failure.



**KM1 VALVE GUIDE REPLACEMENT**

Two types of valve guides have been used in KM1 cylinder heads (see figure 1). Some exhaust valve guides are machined to accommodate a valve seal.

If valve guides are worn beyond the maximum allowable specifications, remove and replace the guides using the following procedure.

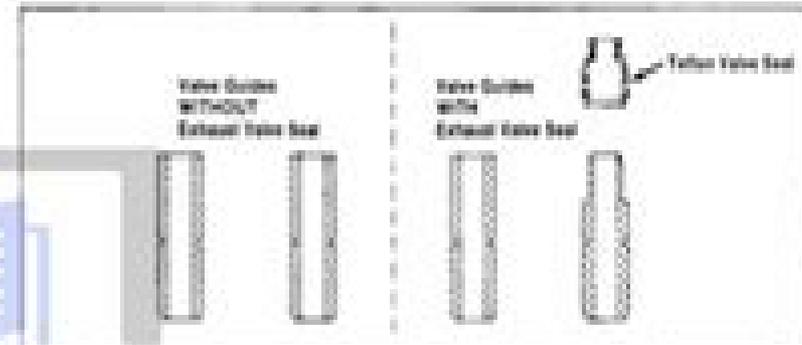


FIGURE 1

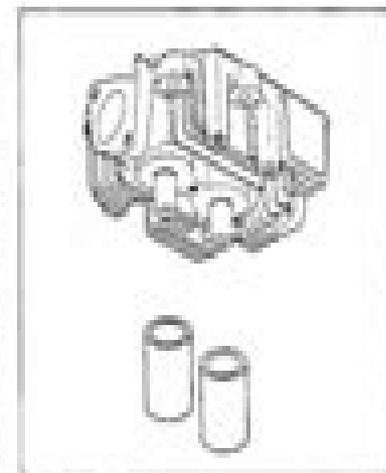
**Valve Guide Removal**

1. Remove cylinder head from engine (disassemble and clean as explained in the service manual).
2. Heat cylinder head in a 400° F (200° C) oven to less than 30 minutes.

**WARNING:** Use extreme care when working with hot metal. Compression of working area can result in serious burns.

3. Remove head from oven using thermal insulated gloves, tongs, etc. Position an air inlet pipe (aim with the valve seats "up") and the valve guide rod (use pieces of pipe 1" (25mm) 1/2" x 1/8" (3mm) long with straight ends, see figure 2).
4. Center a 1/2" (12mm) diameter drill punch on the valve guide. Press guide from head.

**CAUTION:** Straighten if drill punch or guide being removed cause damage cylinder head.



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**Wilkening Manufacturing Co**



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