

VALVE GUIDE REAMING SETS



FIG. 1. The H. O. Lee valve guide reaming tool is designed to remove any metal excess which does not valve guide as part of the cylinder head. These tools can be used to install oversize stem valves or replaceable valve guides.

1



FIG. 2. The H. O. Lee valve guide reaming tool is designed to remove any metal excess which does not valve guide as part of the cylinder head.

2



FIG. 3. The H. O. Lee valve guide reaming tool is designed to remove any metal excess which does not valve guide as part of the cylinder head.

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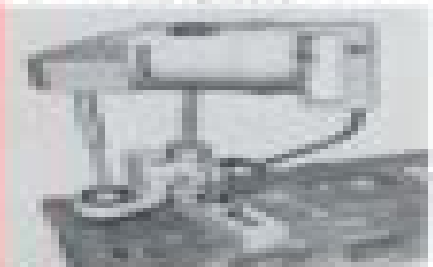


FIG. 4. The H. O. Lee valve guide reaming tool is designed to remove any metal excess which does not valve guide as part of the cylinder head.

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The H. O. Lee valve guide reaming tools are designed to remove any metal excess which does not valve guide as part of the cylinder head. These tools can be used to install oversize stem valves or replaceable valve guides.

Installing Oversize Stem Valves

This is accomplished by reaming out the valve guide for oversize stem valves. Most of the engine and valve manufacturers now offer at least three sizes of oversize valves.

The H. O. Lee valve guide reamer provides a true alignment with original guide bore using Lee self-aligning pilot. The reamer is held rigid with reaming bar during reaming operation. Simple to operate and extremely accurate. Sets available described on page 2.

Installing Replaceable Valve Guides

When old valves are still serviceable, it is more economical to install replaceable valve guides. Roughing and finishing reamers used with the H. O. Lee valve guide reamer run the reamer for a replaceable guide. A complete fitting of the replaceable valve guides, roughing and finishing reamers, and reaming pilot available are listed on page 2. Guide service data on both pages.

OPERATING INSTRUCTIONS

FOR INSTALLING OVERSIZE STEM VALVES

Clean out valve guide hole with an H7000 valve Solid Valve Guide Reamer. Position self-aligning pilot in valve guide with H7000 Pilot. Loosen all screws of reamer guide assembly and install pilot aligning bar in reamed hole. Position with an expanding pilot. Reamer can only clamp and not be aligned to steel base. Tighten clamp nut with finger until base is held firmly in block. Tighten screws and ball rollers. Loosen clamp nut, reposition and turn to block as shown in photo number 1. (NOTE: To insure extreme accuracy, it may be necessary to loosen and tighten screws of reamer guide assembly several times.)

Remove expanding pilot and aligning bar. Position pilot reamer in valve guide. Install reaming bar on top of reamer as shown in photo number 2.

In photo number 3, Reaming Bar is shown in position in reamed hole, providing true alignment. Unit is now ready for reaming. It should be used for hand operation.

Power Drive H7000, adaptable to a power unit, is shown in photo number 4. Available with 150 or 250 rpm universal motor.

FOR INSTALLING REPLACEABLE VALVE GUIDES

The same procedure is used when installing replaceable valve guides. Just be aware that the replaceable guide you wish to install has an O.D. of .01. In photo 2, the H7000 roughing reamer would be used with the H7000C bar. The roughing reamer operation would be followed with the H7000C bar. The H7000C bar is used to finish the valve guide using the same bar. In all roughing and finishing reamers, a .01 shaft is required for these reaming operations. A .01 shaft is recommended. All new valve guides should be installed with some type of gress. O.D. of valve guide and hole must be lubricated before attempting to install guide. It is necessary to run 1.0 of guide after installation, use H7000 valve solid reamer shown on page 2.

Circle 10 on Reader Service Card

Circle 11 on Reader Service Card

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J Dewey



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