

Item	Specification
Cylinder head gasket surface flatness	Flat within 0.08 mm (0.003 in) length end to end, area 150 mm (5.9 in) x 150 mm (5.9 in) (or full width) should be less than 0.05 mm (0.002 in)
Valve tappet clearance - intake	0.006-0.010 in (.15-.25 mm)
Valve tappet clearance - exhaust - Engine must be at room temperature before measuring	0.01-0.02 in (.36-.46 mm)
Valve guide bore inner diameter	0.217-0.218 in (5.519-5.549 mm)
Valve stem diameter - intake	0.2157-0.2164 in (5.479-5.497 mm)
Valve stem diameter - exhaust	0.2152-0.2159 in (5.466-5.484 mm)
Valve stem-to-guide clearance - intake	0.0009-0.0028 in (.022-.07 mm)
Valve stem-to-guide clearance - exhaust	0.0014-0.0033 in (.035-.083 mm)
Valve head diameter - intake	1.46 in (37 mm)
Valve head diameter - exhaust	1.22 in (31 mm)
Valve face runout	0.002 in (.05 mm)
Valve face angle	44.5-45.5 °
Valve seat width - intake	0.051-0.059 in (1.3-1.5 mm)
Valve seat width - exhaust	0.067-0.079 in (1.7-2 mm)
Valve seat runout	0.002 in (.04 mm)
Valve seat angle	44.5-45.5 °
Valve spring free length (approx.)	1.890 in (48 mm)
Valve spring compression pressure (N @ spec. length)	525 N @ 27.0 mm (114.7 lb @ 1.06 in)
Valve spring installed height	1.457 in (37 mm)
Valve spring installed height pressure (N @ spec. length)	235 N @ 37.0 mm (53 lb @ 1.45 in)
Valve spring installed pressure - service limit	10% force loss @ specified height

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Item	Specification
Theoretical valve lift (intake) @ 0 lash	0.394 in (10 mm)
Theoretical valve lift (exhaust) @ 0 lash	0.38 in (9.6798 mm)
Lobe lift - intake	0.394 in (10 mm)