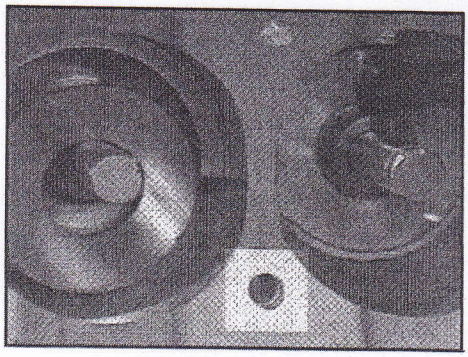


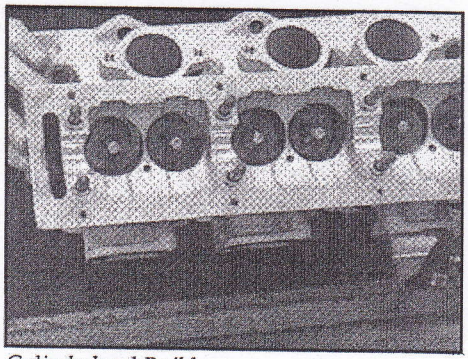
Calculate amount of base shims required, by following the equations below. Then place base shims (if required) into head.

Equation 1 - to calculate required amount of seat shims. (each one - .25mm)

1. Take first DTI reading of valve cap surface to valve,add too...
2. Second reading of valve height as in situ.
3. With total of steps 1+2 add 1.0mm for the spring seat washers, each time.
4. With total measurements of all valves, minus the pre-measured spacer.
5. Use your final answer to determine amount of shims required.

e.g.
1.92mm step 1
+7.86mm step 2
+1.00mm step 3
10.78mm
-59.72mm step 4
-48.94mm

5. Use final tenths of a mm to determine each shim = 0.25mm. round to nearest 0.25mm
N.B. No more than three shims most be used per valve.



Place clean valve seats over valve shims and oil valve stems lightly.