Valve Guide Reconditioning

Methods used to recondition valve guides depend on walve guide material (sintered iron, brass or aluminum).

Recondition Valve Guides (Aluminum) (Tool Kit 19232)

Place counterbore reamer, Tool #19231, and reamer pilot guide, Tool #19234, in worn valve guide using pilot guide to center reamer with valve seat, Fig. 9B. Place new service bushing, Part #231218 on pilot bushing next to reamer. Mark reamer level to 1/16" above top edge of service bushing, Fig. 9B. Ream out worn valve guide until mark on reamer is flush with top of guide bushing, Fig. 9C. Lubricate reamer with Stanisol or kerosene. DO NOT REAM THROUGH GUIDE. Continue to turn reamer clockwise while nemoving reamer from guide. Flush out all chips.

Stide service bushing, Part #231218 onto bushing driver, Tool #19204, and place in counterbored valve guide with grooves down, Fig. 9D. Press bushing into guide until it bottoms.

Use finish reamer, Tool #19233, and reamer pilot guide, Tool #19234, to finish ream service bushing. Use Stanisol or kerosene to lubricate reamer. Ream through entire guide into valve tappet chamber, Fig. 9E. Keep turning reamer clockwise when removing reamer from guide. Flush out all chips.

Recondition Valve Guides (Brass or Sintered Iron Guides, Factory or Field Installed)

Brass or sintered iron valve guide bushings are replaceable as follows:

Lubricate tap Tool #19264 and valve guide bushing with engine oil or kerosene. Using a tap wrench, turn tap clockwise into valve guide bushing approximately 1/2". DO NOT turn tap more than 1" deep. Remove tap and clean chips from bushing threads, Fig. 10A.

Thread Nut, Tool #19239, up until it touches head of Puller Screw, Tool #19238. Place Puller Washer, Tool #19240 over valve seat, keeping it centered, Fig. 10B. Lubricate puller screw with Stanisol or kerosene and thread puller screw into bushing until it bottoms, Fig. 10B.

COMPRESSION Recondition Valves Guides

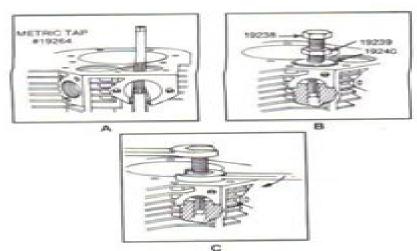


Fig. 10 - Pulling Brass or Sintered Iron Guide Bushing

Hold bee head of puller screw from turning and turn hex nut down on puller washer. Continue turning nut until bushing is free, Fig. 10C.

Valve Guide Bushing Identification

See Fig. 11A, B, C, D or E below to identify bushing that has been removed. Use replacement bushing shown in Fig. 11.



Fig. 11 - Bushing Identification

Install Service Bushing

Place service bushing on bushing driver, Tool #19204. Two grooves on service bushing, #231218, go down. Service bushing #230655 or 261961 can be installed either way, Fig. 9D. Press bushing in until it bottoms. NOTE: The following procedure is not required for service bushing #230655, but is recommended to ensure that the entire guide is clean and free of foreign material.

Briggs Opposed Twin Repair Manual

AW Rasmussen

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