

# IMPORTANT



***These Cylinder Heads should be assembled only by experienced cylinder head technicians.***

## **INSPECTION**

Upon receiving these heads they should be thoroughly inspected for shipping damage.

**Prior to machining and assembly please inspect the following items:**

Valve seats - Port walls - Valve guides - Deck surfaces - All threads

## **MEASURING & MACHINING**

- All initial measuring should be done before any machining or porting has begun.
- Chamber volume is machined to nominal size. Please measure actual volume (cc) before milling if you need a particular chamber volume.
- Valve to valve guide clearance is finished at .0012" - .002" with our valves (OD .3415"). If you have a particular clearance for your valves or application the guides should be measured and sized to your specifications.
- We recommend the use of guide-plate model # 27001230-4 for this application.

## **CLEANING**

- These heads are thoroughly pressure washed before shipping. Occasionally there may be machining chips that get stuck in the water jackets and can loosen up during shipping. Even though we tape up all water jacket openings of assembled heads before shipping, sometimes a small amount of these chips can escape from the taped openings. Be sure to blow off the head with compressed air paying particular attention to the intake and exhaust ports.