

G2CS CYLINDER HEAD MODIFICATION

PARTS REQUIRED

MATCHLESS PARTS

1	026030	Valve Guide
1	042069	Valve Guide
2	011111	Valve Guide Circlip
2	014168	Valve Stem Collar
2	IND 16	Valve Spring
2	IND 17	Valve Spring

JAMES VALVES FOR JAGUAR ENGINE

1	VK2489	Inlet Valve
1	1798	Exhaust Valve
4	B-2	Valve Stem Key

OPERATIONS REQUIRED

1. Bore the inlet valve seat and valve pocket to 1 7/16 inches. Open manifold to side of carburetor to be used. Blend and polish port and manifold.
2. Bore the exhaust valve seat and valve pocket to 1 1/4 inches. Blend and polish port.
3. Turn the head of the inlet valve to 1 5/8 inches, reduce the thickness to 1/32 inch safe edge and polish the valve head.
4. Turn the head of the exhaust valve to 1 7/16 inches, reduce the thickness to 1/32 inch safe edge and polish the valve head.
5. Ream the upper valve collars to a 10 degree taper to fit the B-2 valve stem keys.
6. Assemble the valves and springs and check to be sure there is 1 5/16 inch spring pack with the valve collar and keys securely seated.
7. Bore the carburetor spacers to suit the carburetor to be used.
8. Remove all valve pocket projections from the head of the piston. Assemble the engine and place strips of modeling clay, 1/8 inch in diameter, at all points of possible contact. Assemble the cylinder head with the gasket in place. Rotate the engine several times, then disassemble and check the thickness of all clay strips. Remove metal from the piston at any point where the clay strips are less than .050 inches in thickness.