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To convert your cylinder head:

- I. Strip the cylinder head of all components. Have the head U.V checked for any cracks and then clean in caustic soda.
- II. After washing off the caustic solution in a hot wash tank, dry the head and grit blast to remove any remaining carbon and to clean the waterways.
- III. Fit the Manganese silicon bronze valve guides and ream to size. (Bronze removes heat two and a half times faster than original cast iron valve guides.
- IV. Machine the exhaust seats and fit the lead free compatible seat inserts.
 - V. Cut the valve seats using three angles, (15, 30 & 45 degree). This aids the flow and increases B.H.P. for use with premium lead-free fuel.
- VI. Blend the throat valves to remove any sharp edges caused by fitting the inserts and cutting the seats.
- VII. The head may need skimming to ensure the face is flat.
- VIII. After de-burring, hot wash the head, dry, assemble and paint.

This procedure is best left to a qualified engineer/machinist and these instructions are offered as a guideline only!

