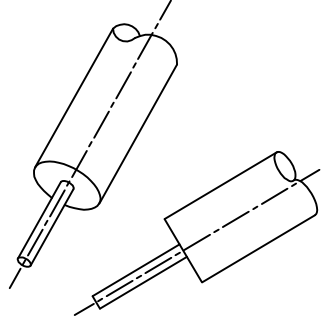
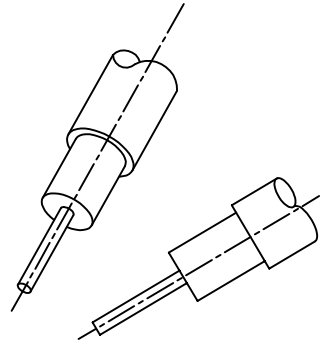


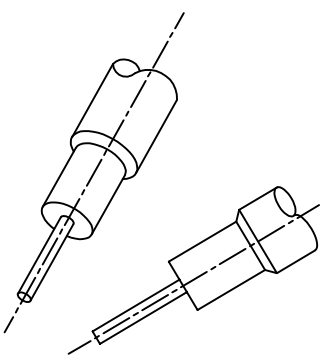
TO USE:  
 DRILL PILOT AND INSERT IN GUIDE HOLE  
 ONLY PUT ENOUGH PRESSURE ON TOOL  
 TO CUT VALVE SEAT.  
 I WOULD RECOMMEND NO LARGER  
 THAN .015-.020 WIDTH



TURN PILOT



TURN PORT BODY DIAMETER

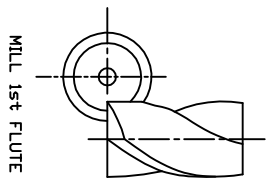


TURN 45 DEGREE FACE

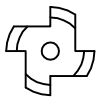
TILT ON 45°  
 ROTATE 15°  
 CUT RELIEF BEHIND 45° FACE  
 LEAVING .010-.015 LAND  
 AT CUTTING EDGE

WATER HARDENING DRILL ROD  
 HAS THE BEST MACHINABILITY OF THE  
 DRILL ROD SERIES.  
 HARDEN AND HONE CLEARANCE  
 ON LAND UP TO THE 45° CUTTING EDGE

DRILL ROD TENDS TO GROOV  
 WHEN HARDENED.  
 IF PILOT IS TOO LARGE  
 HONE DOWN TO FIT GUIDE HOLE



MILL 1st FLUTE



MILL MINIMUM 3 FLUTES

DRAWN BY: GEORGE B. BRITNELL	SHT. 0
SCALE: NON SPECIFIED	
DATE: DECEMBER 4, 2010	
<b>VALVE SEAT TOOL</b>	