

# TECHNICAL BULLETIN

Number 1034

Rev. 0

**Subject:**                    **Modifying Superior Cylinder Head Valve Spring Pads for Spring Seats**

**PROBLEM:**                Over an extended period of time, valve springs begin to wear into the seating area.

**SOLUTION:**              Utilize stainless inserts for spring seats (P-907-467).

Over an extended amount of run hours, it is common for the valve springs to wear into the head surface creating excessive grooves in the spring seating area. One successful method of repair is by machining the valve spring pad to accept a stainless steel spring seat.

The pad area, where spring seats, should be machined to a depth of .080”-.082”. This will allow the installation of a stainless steel spacer (P-907-467) for the outer spring to seat against. Refer to the attached drawing for machining dimensions.

When installing the new stainless spring seat, it will be necessary to verify before assembly that the seat will go over the shoulder of the valve guide. It may be necessary to lightly sand the valve guide shoulder on a belt sander to allow the stainless seat to pass over it freely.

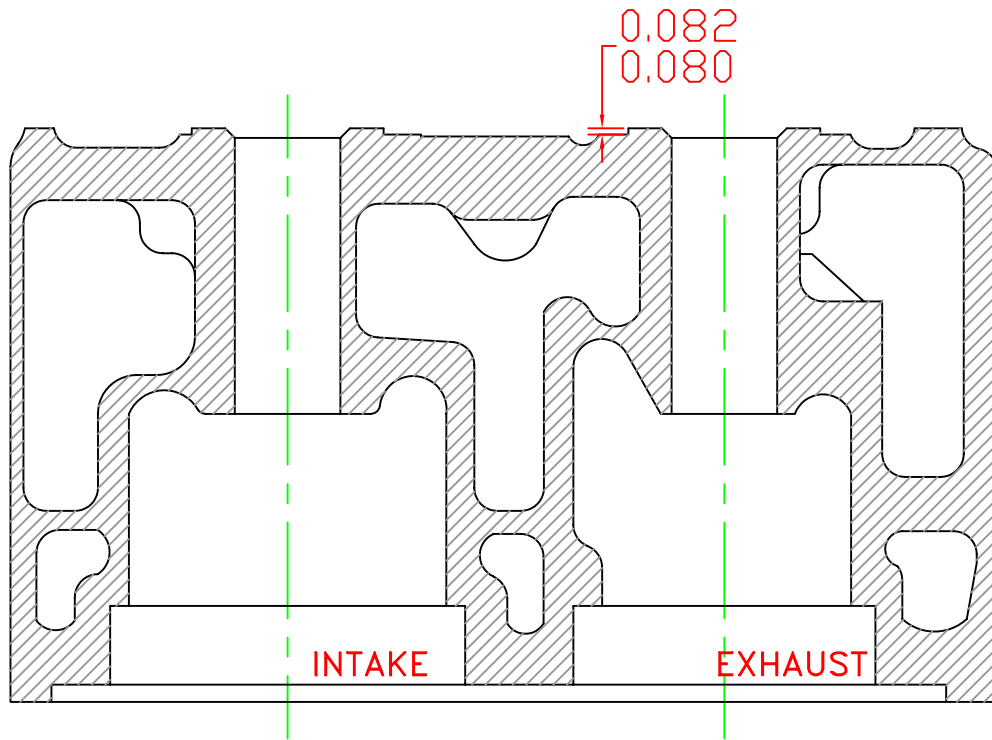
Once the machining is complete, assemble the heads as normal (placing the stainless seats under the springs).

**It is important that the head be stamped “Requires .080” spring seat”.**

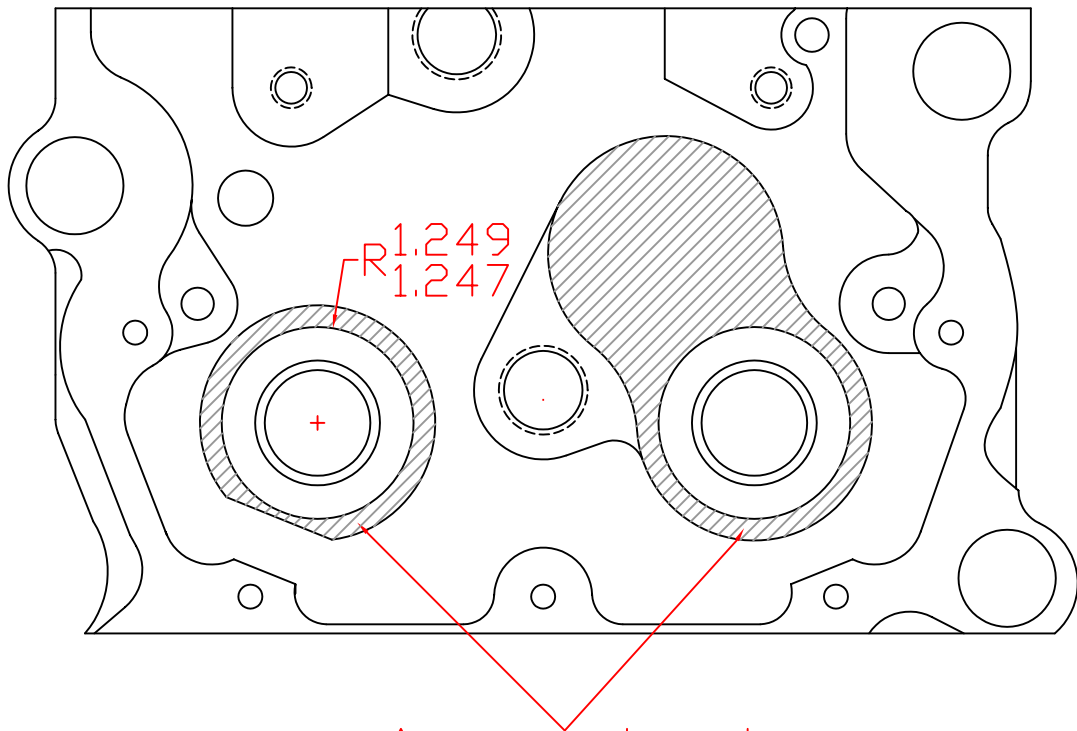
Additional cylinder head rebuilding information is available in EnDyn’s Technical Bulletin #1006.

**For further information or questions concerning Superior engine head rebuilding procedures contact EnDyn’s Technical Department or your local EnDyn PowerParts® Distributor.**

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Head Cross-Section View



Area to be  
machined

Head Top View