



# NTG Motor Services Limited

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## To convert your cylinder head:

- I. Strip old cylinder head, check for cracks and then clean in caustic soda.
- II. After washing off the caustic solution in a hot wash tank, dry the head and grit blasted to remove any remaining carbon and to clean the waterways.
- III. Fit the Manganese silicon bronze valve guides and reame to size. (Bronze removes heat two and a half times faster than original cast iron valve guides.
- IV. Fit the Lead free exhaust seats inserts.
  - V. Cut the valve seats using three angles, (30, 45 & 60 degree). This aids the flow and increases B.H.P. by approx 7% 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. Skim Head if required.
- 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!**

