

Valve Spring Installed Height (spring seat to retainer)	1-53/64-1-57/64"	1-53/64"-1-57/64"
Use 1/16" spacer to reduce spring height when over specifications		
VALVE GUIDES		
Type		Cast in Head
Guide Bore Diameter374-.375" std.
CYLINDER HEAD		
Number Used		2
Combustion Chamber		Wedge Type
Valve Seat Runout (maximum)002"
Intake Valve Seat Angle		45°
Intake Seat Width060 to .085"
Exhaust Valve Seat Angle		45°
Exhaust Seat Width040 to .060"
Cylinder Head Gasket Compressed (thickness)021"
ENGINE LUBRICATION		
Pump Type		Rotor Full Pressure
Capacity (qts.)		4 U.S. or 3-1/4 Imperial Quarts*
Pump Drive		Camshaft
Operating Pressure at 1000 R.P.M.		45 to 65 lbs.
Oil Filter Type		Full Flow
Pressure Drop Resulting from Clogged Filter		7 to 9 lbs.
OIL PUMP INSPECTION LIMITS FOR REPLACEMENT		
Oil Pump Cover (filter base)0015 inch or more
Outer Rotor Length943 inch or less
Outer Rotor Diameter		2.469 inch or less
Inner Rotor Length942 inch or less
Clearance Over Rotor—Outer004 inch or more
Inner004 inch or more
Outer Rotor Clearance012 inch or more
Tip Clearance Between Rotors010 inch or more

*When filter is replaced, add 1 U.S. Quart or 3/4 of an Imperial Quart.

OVERSIZE AND UNDERSIZE ENGINE COMPONENT MARKINGS

Engine Displacement	Condition	Identification	Location of Identification
383 cu. in. 440 cu. in.	.001" U/S Crankshaft	Maltese Cross M-2-3 etc. (indicating #2 & 3 main bearing journal) and/or R-1-4 etc. (indicating #1 & 4 connecting rod journals)	Top Pad—Front of Engine Crankshaft Counterweight
	.010" U/S Crankshaft	Maltese Cross and X M-10 (indicate .010" U/S all main journals) and/or R-10 (indicates .010" U/S all rod journals)	Top Pad—Front of Engine Crankshaft Counterweight
— —	.020" O/S Cylinder Bores	A	Top Pad—Front of Engine
—	.008" O/S Tappets	Diamond	Top Pad—Front of Engine
	.005" O/S Valve Stems	O.S.	Single Bolt Boss on End of the Head