



Installation Instructions for KPMI Part No: **30-30235**

Honda • XR/XL/CRF 75-100 • 1973-'13

Lightweight Racing Valve Spring Kit

XL75 1977-1979	XL100S 1979-1985
XR75 1973-1978	XR100 1981-1984
XL80S 1980-1985	XR100R 1985-2003
XR80 1979-1984	CRF80F 2004-2013
XR80R 1985-2003	CRF100F 2004-2013

A) 30-30235 Kit Includes

<u>Qty</u>	<u>Application</u>	<u>Description</u>
2 - Pcs	Intake / Exhaust	Titanium Retainers
2 - Prs	Intake / Exhaust	Chrome Silicon Springs
2 - Pcs	Intake / Exhaust	Spring Shims

B) Recommended Installed Height - Intake/Exhaust

1. Installed Height **1.160" to 1.170"**
2. Seat Pressure **47 #**
3. Open pressure at .300 lift **116 #**
4. Open pressure at .360 lift **130 #**
5. Max Valve Lift **0.360"**

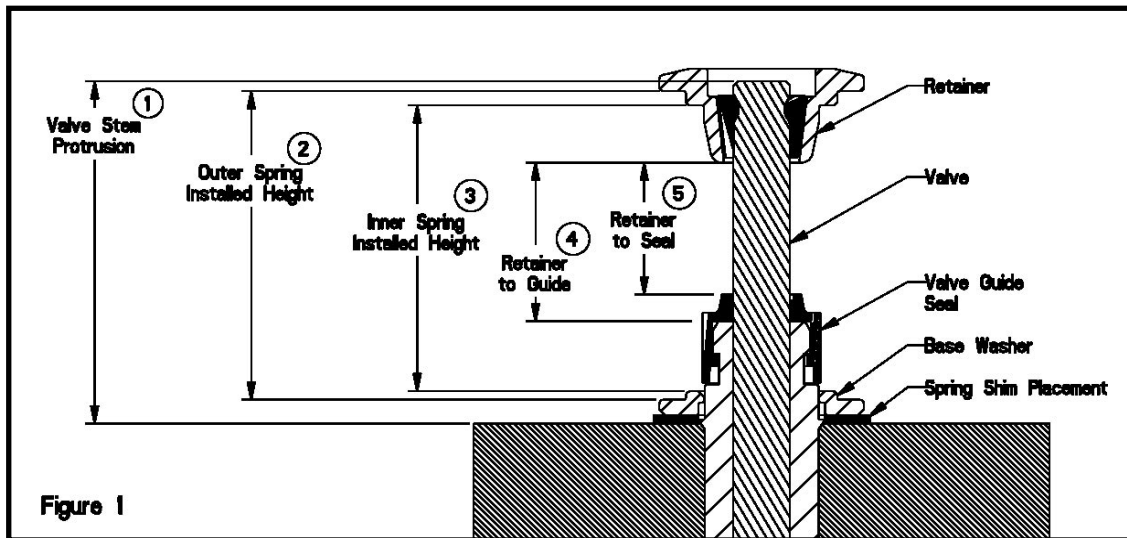
C) Notes

1. The difference between the installed height and the coil bind height is considered "Free-Travel"
The coil bind height is determined by compressing the spring or springs with the retainer and basewasher in place, a vice can be used for this operation, once springs are compressed measure the distance between the retainer and basewasher where the outer spring contacts them.
2. Free-travel should always be gross valve lift +.060" for safe operation.
3. Retainer to seal and retainer to guide clearance should also be gross valve lift +.060" for safe operation.
4. Failure to check valve train clearances can result in serious damage to an engine

Packaged By: _____

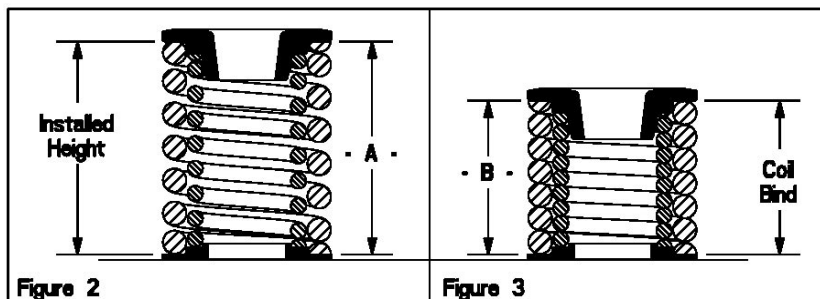
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TECH TIPS



Valve Train Terminology

1. Stem Protrusion is measured from the tip of the valve stem to the cylinder head. See Figure 1.
2. Outer spring installed height is measured where the outer spring contacts the retainer and lower component when assembled. See Figure 1.
3. Inner spring installed height is measured where the inner spring contacts the retainer and lower component when assembled. See Figure 1.
4. Retainer to guide clearance is the distance between the valve guide (w/o the seal) and the bottom of the retainer, with the valve in the closed position. See Figure 1 and Notes 3 & 4.
5. Retainer to seal clearance is the distance between the valve stem seal and the bottom of the retainer, with the valve in the closed position. See Figure 1 and Notes 3 & 4.



Installed Height

1. In Figure 2 the installed height is measured from where the outer spring contacts the retainer and the basewasher. This measurement is taken when the valve, basewasher, retainer, and keepers are assembled in the cylinder head.

Coil Bind / Solid Height:

1. In Figure 3 the coil bind height is determined by compressing the spring or springs with the retainer and basewasher in place, a vice can be used for this operation, once springs are compressed measure the distance between the retainer and basewasher where the outer spring contacts them.

Notes:

1. The difference between the installed height and the coil bind height is considered "Free-Travel"
2. Free-travel should always be gross valve lift +.060" for safe operation.
3. Retainer to seal and retainer to guide clearance should also be gross valve lift +.060" for safe operation.
4. Failure to check valve train clearances can result in serious damage to an engine.