



Installation Instructions for KPMI Part No: 80-80394
Yamaha • R1 1998-'03 • RX-1 2003-'05 • Apex 2006-'10
Spring Only Kit, High Performance

A) 80-80394 Kit Includes

<u>Qty</u>	<u>Application</u>	<u>Description</u>
12 - Pcs	Intake	Chrome Silicon Springs
8 - Pcs	Exhaust	Chrome Silicon Springs
8 - Pcs	Exhaust	H.T. Steel Basewasher

B) Recommended Installed Height - Intake

- 1. Installed Height **1.365"-1.375"**
- 2. Seat Pressure **30#**
- 3. Open Pressure at .315 lift **80#**
- 4. Open Pressure at .350 lift **90#**
- 5. Max Valve Lift **0.350"**

Recommended Installed Height - Exhaust

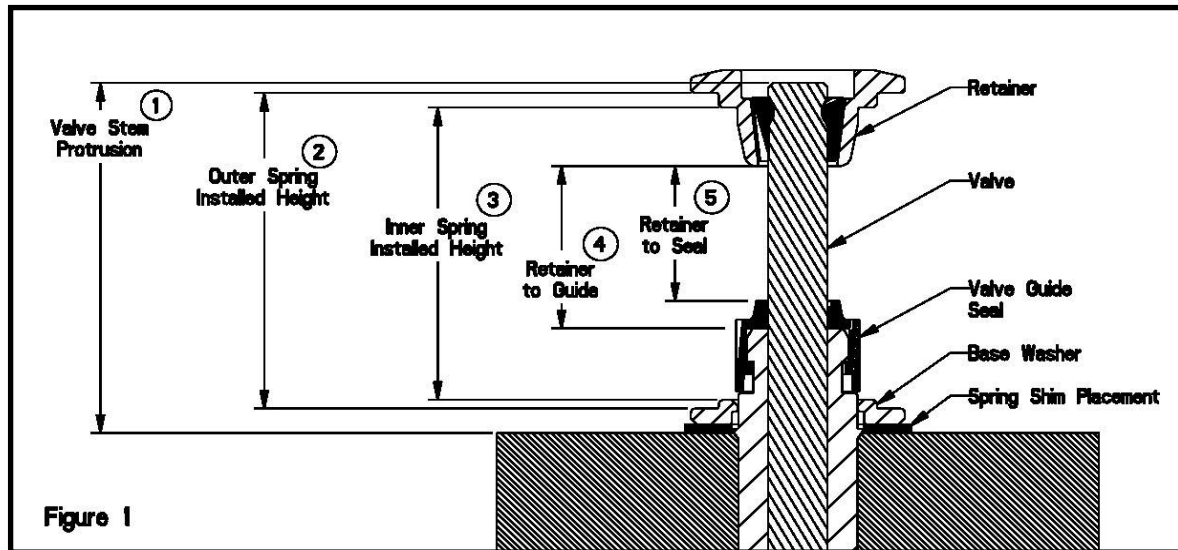
- 1. Installed Height **1.410"-1.420"**
- 2. Seat Pressure **44#**
- 3. Open Pressure at .315 lift **95#**
- 4. Max Valve Lift **0.315"**

C) Notes

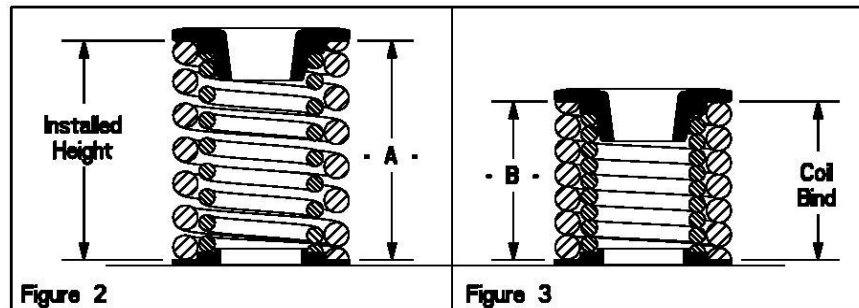
- 1. We suggest using KPMI spring kit (80-80394) for applications where only the intake cams have been changed. **(We also recommend using OEM Stock Exhaust Cams with these springs).**
- 2. The difference between the installed height and the coil bind height is considered "Free-Travel"

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.

- 3. Free-travel should always be gross valve lift +.060" for safe operation.
- 4. Retainer to seal and retainer to guide clearance should also be gross valve lift +.060" for safe operation.
- 5. Failure to check valve train clearances can result in serious damage to an engine

TECH TIPS**Figure 1****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.

**Figure 2****Figure 3****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.