



## Installation Instructions for KPMI Part No.: 80-80340

### 1970-83 • Yamaha • XS 650

### Racing Valve Spring Kit

A) 80-80340 Kit Includes:

<u>Qty</u>	<u>Application</u>	<u>Description</u>
4 - Pcs	Intake / Exhaust	HT Steel Retainers
4 - Pcs	Intake / Exhaust	Chrome Silicon Springs
4 - Pcs	Intake / Exhaust	H.T. Steel Basewashers
4 - Prs	Intake / Exhaust	H.T. Steel Keepers

*Note: This kit is supplied with radiused bead keepers and must be used with radiused groove valves.*

B) Recommended Installed Height - Intake / Exhaust

1. Installed Height .....	<b>1.445"-1.455"</b>
2. Seat Pressure .....	<b>100 lbs</b>
3. Open Pressure at 0.515" lift .....	<b>228 lbs</b>
4. Max Valve Lift .....	<b>0.515"</b>

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(s) 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 +0.060" for safe operation.
3. Retainer-to-Seal / Guide clearance should also be gross valve lift +0.060" for safe operation.
4. Failure to check valve train clearances can result in serious damage to an engine

Packaged By: \_\_\_\_\_

Date: \_\_\_\_\_

# TECH TIPS

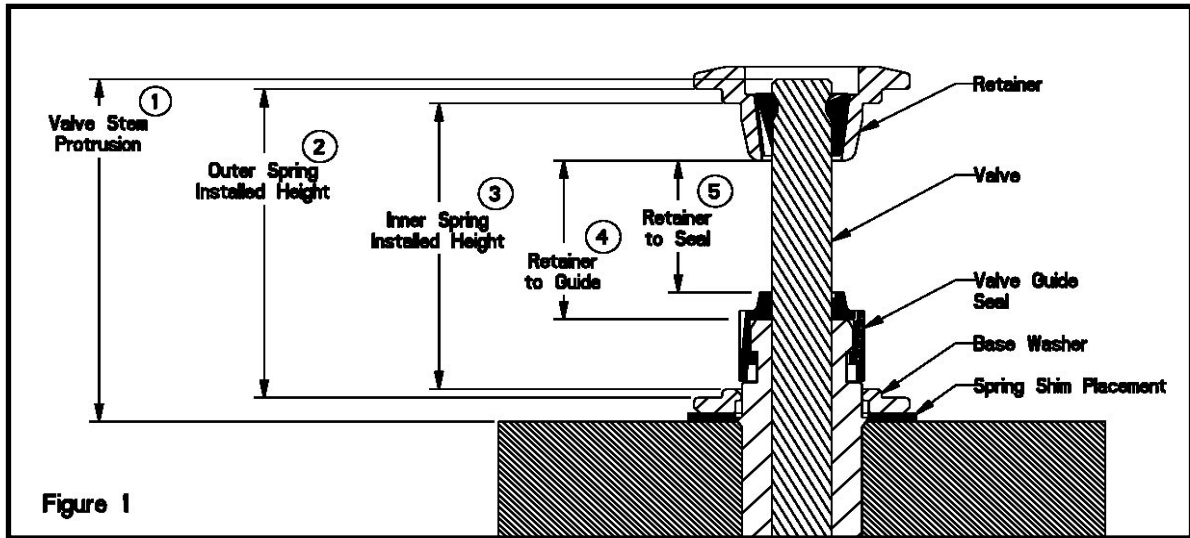


Figure 1

## 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 Basewasher when assembled (See Figure 1).
3. Inner spring installed height is measured where the inner spring contacts the Retainer and Basewasher 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).

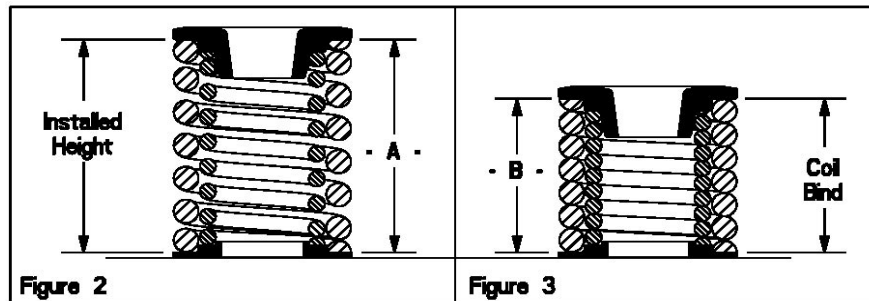


Figure 2

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(s) 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 +0.060" for safe operation.
3. Retainer-to-Seal / Guide clearance should also be gross valve lift +0.060" for safe operation.
4. Failure to check valve train clearances can result in serious damage to an engine.