

1/29/2003  
Revised on 6\26\03  
R.W.

## **AJPE T/F Hemi Stg V + VI Valve Job Specs.**

**Intake:** Chamber Volume: +. 100" Deck = 198.5 to 199.5 cc (6\26\03 R.W.)  
Std deck = 176 to 177 cc (11\6\02)

**AJPE 45° Seat Cutter: #31Z-100-VSI-A158237**

**Seat Depth:** Std Deck = .529" to .531" New  
+. 100 Deck = .629" to .631" "

**Intake Seat:** 2.445" dia. x 45°

Top Angle:	New = 38°	Used = 38° to 40°
Seat Angle:	New = 45° x .040" wide	Used = 45° x .050" to .060" wide
Bottom Angle:	New = 60° x .085" wide	Used = 60° x .085" to .100" wide

**Intake Valve:** 2.450" dia.

Seat Angle	New = 45° x .160" wide	Used = 45° x Up to .180" wide
Back Angle	New = 32° x .075" wide	Used = 32° x Up to .095" wide

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## **Exhaust:**

**AJPE 55° Seat Cutter: #31Z-100-VSI-A158163**

**Seat Depth:** Std Deck = .917" to .920" New  
+. 100 Deck = 1.013" to 1.015" New (Revised on 6\26\03 R.W.)

(The chamber was modified to fix poor exhaust seat alignment and bring seat height back to the original depth. This was started from set #0340) All remaining heads and repairs will be machined with this new chamber.

**Exhaust Seat:** 1.925" dia. x 55°

Top Angle:	New = 45°	Used = 45° to 50°
Seat Angle:	New = 55° x .085" Wide	Used = 55° x .085" to .100" wide
Bottom Angle:	New = Radius to Throat	Used = 60° Break & Blend into Throat

**Exhaust Valve:** 1.925" dia.

Seat Angle:	New = 55° x .090"	Used = 55° x .090" to .110" wide
Back Angle:	New = 38° x .070"	Used = 38° x .070" to .090" wide