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The reamers are K-Line bronze guide finish reamers, HSS. I reamed by hand with some gear oil. A few observations: - Reaming by hand was hard and slow,but was totally OK with me. - Reamed finish seems very nice. - Reamed guide appears smaller in ID than the indicated reamer size by 1/2 thou or more.

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You need a 6mm reamer, the valves are just under sized to give you the required clearance. You'll probably find you don't need to drill them out first as there just ready to ream once pressed into the head. It's also good practice to have the valve seats recut after a valve guide replacement.

[VWVortex.com - Valve guide question, Please Help!](#)
All compressions in the mid to high 70's. Rocker arm geometry is very important as you don't want a lot of side loading on the valve stem. Also, IMO, it is important to provide at least a 1/32" rad. on both ends of the valve guide I.D.'s. This is what I did to the old Nitralloy (hardened) valve guides that CM took off the market.

[BeechTalk.com - BT - Intake Valve Guide Reamer size...](#)
1. Drill guides with a drill just a tiny bit small than the OD, pick the remaining out. 2. Take a bar sized to a slip fit of the inside of the guide, with a step milled in as a stop, place in freezer, Heat the heads with a torch, place bar into guide and knock out. This is the method we used to use on light aircraft engines.