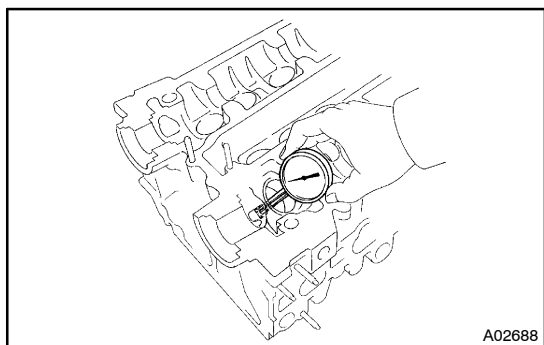


## REPLACEMENT

### REPLACE VALVE GUIDE BUSHINGS

- (a) Using SST and a hammer, tap out the guide bushing.  
 SST 09201-10000 (09201-01060),  
 09950-70010 (09951-07100)



- (b) Using a caliper gauge, measure the bushing bore diameter of the cylinder head.

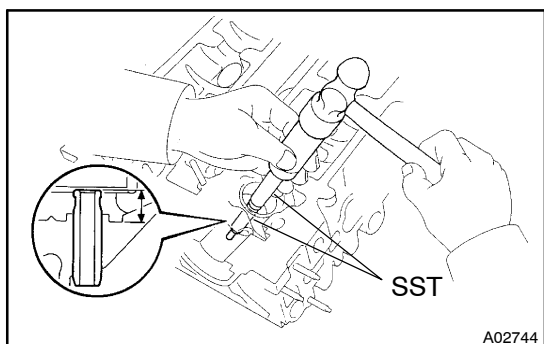
Both intake and exhaust

| Bushing bore diameter<br>mm (in.)           | Bushing<br>size |
|---|-----------------|
| 10.985 – 11.006 mm<br>(0.4325 – 0.4333 in.) | Use STD         |
| 11.035 – 11.056 mm<br>(0.4344 – 0.4353 in.) | Use O/S<br>0.05 |

- (c) Select a new guide bushing (STD or O/S 0.05).  
 If the bushing bore diameter of the cylinder head is greater than 11.006 mm (0.4333 in.), machine the bushing bore to the following dimension:

**11.035 – 11.056 mm (0.4344 – 0.4353 in.)**

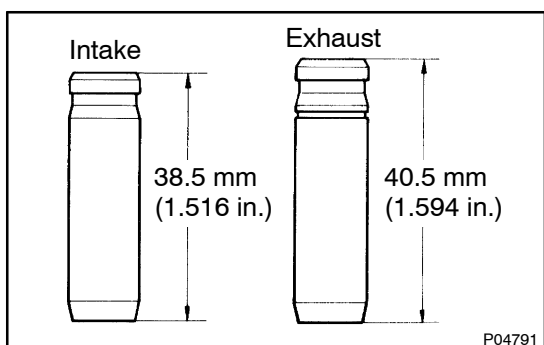
- If the bushing bore diameter of the cylinder head is greater than 11.056 mm (0.4353 in.), replace the cylinder head.



- (d) Using SST and a hammer, tap in a new guide bushing to the specified protrusion height.  
 SST 09201-10000 (09201-01060),  
 09950-70010 (09951-07100)

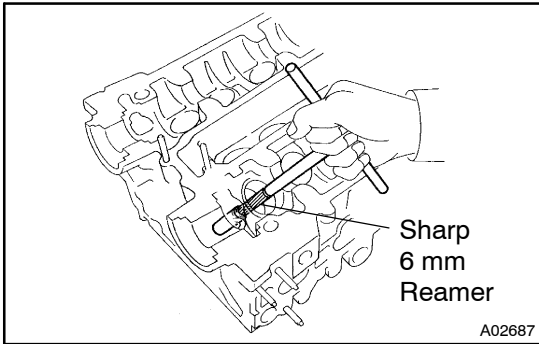
#### Protrusion height:

|         |                                    |
|---------|------------------------------------|
| Intake  | 12.3 – 12.7 mm (0.484 – 0.500 in.) |
| Exhaust | 11.4 – 11.8 mm (0.449 – 0.465 in.) |



#### HINT:

Different bushings are used for the intake and exhaust.



- (e) Using a sharp 6 mm reamer, chamfer the guide bushing to obtain the standard specified clearance (See page EM-41) between the guide bushing and valve stem.