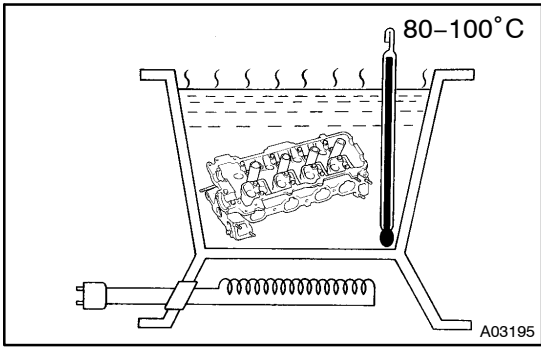
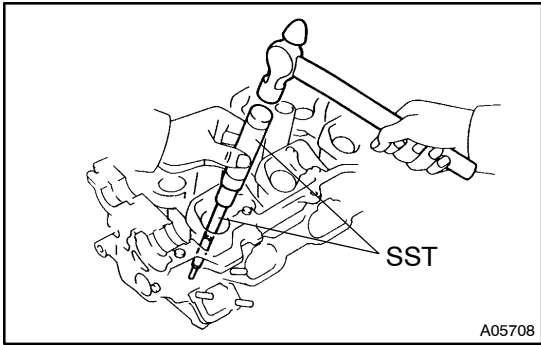




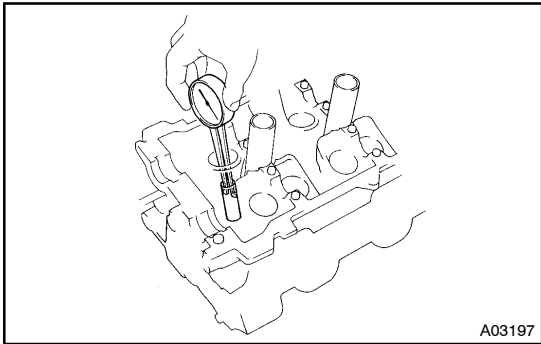
REPLACEMENT

1. REPLACE VALVE GUIDE BUSHINGS

- (a) Gradually heat the cylinder head to 80 – 100°C (176 – 212°F).



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



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

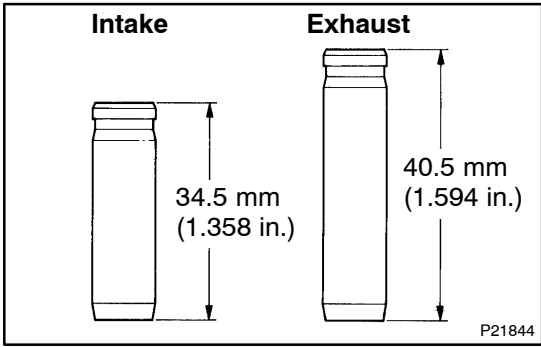
Both intake and exhaust

Bushing bore diameter mm (in.)	Bushing size
10.285 – 10.306 (0.4049 – 0.4057)	Use STD
10.335 – 10.356 (0.4069 – 0.4077)	Use O/S STD

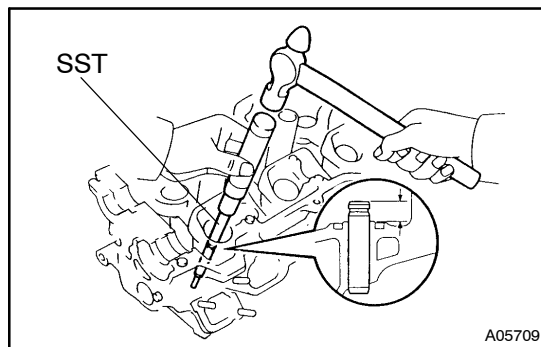
- (d) Select a new guide bushing (STD or O/S 0.05).
If the bushing bore diameter of the cylinder head is greater than 10.306 mm (0.4057 in.), machine the bushing bore to the following dimension:

10.335 – 10.356 mm (0.4069 – 0.4077 in.)

- If the bushing bore diameter of the cylinder head is greater than 10.356 mm (0.4077 in.), replace the cylinder head.



HINT:
The intake bushing and the exhaust bushing differ in their sizes.



- (e) Gradually heat the cylinder head to 80 – 100°C (176 – 212°F).
- (f) Using SST and a hammer, tap in a new guide bushing to the specified protrusion height.

Protrusion height:

Intake

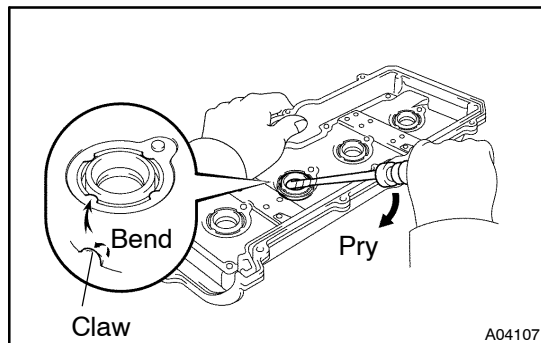
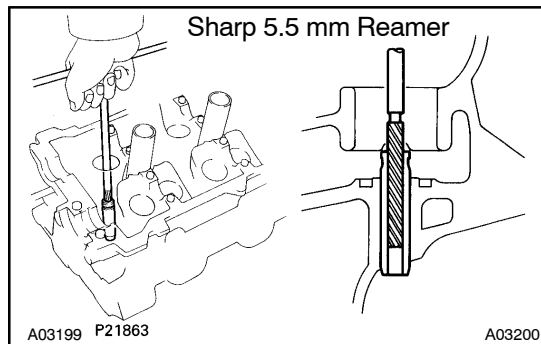
9.2 – 9.8 mm (0.362 – 0.386 in.)

Exhaust

8.2 – 8.8 mm (0.323 – 0.346 in.)

SST 09201-10000 (09201-01060),
09950-70010 (09951-07100)

- (g) Using a sharp 5.5 mm reamer, ream the guide bushing to obtain the standard specified clearance (See page [EM-45](#)) between the guide bushing and the valve stem.

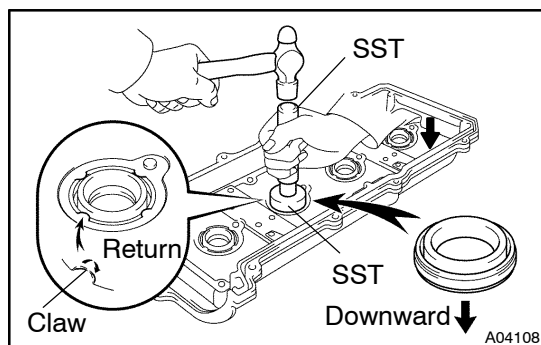


2. REPLACE SPARK PLUG TUBE GASKETS

- (a) Bend the 4 ventilation case claws installed on the cylinder head cover to an angle of 90° or more.
- (b) Using a screwdriver, pry out the gasket.

NOTICE:

Be careful not to damage the cylinder head cover. Tape up the screwdriver tip.



- (c) Using SST and a hammer, tap in a new gasket until its surface is flush with the upper edge of the cylinder head cover.

SST 09950-60010 (09551-00240, 09951-00440,
09952-06010), 09950-70010 (09951-07100)

NOTICE:

Be careful of the installation direction.

- (d) Apply a light coat of MP grease to the gasket lip.
- (e) Put the 4 ventilation case claws back to its original position.