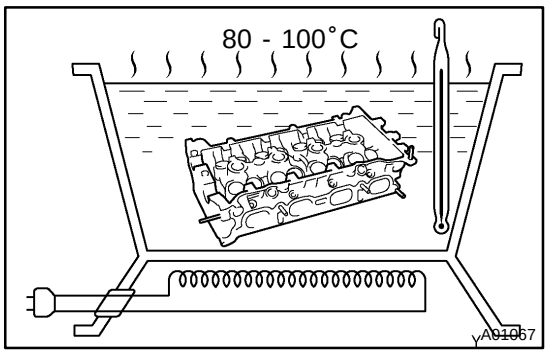
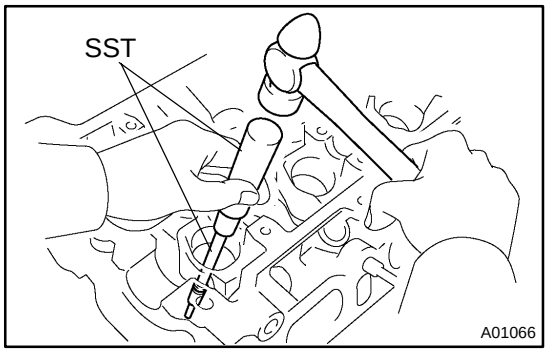
EM16L-01

REPLACEMENT

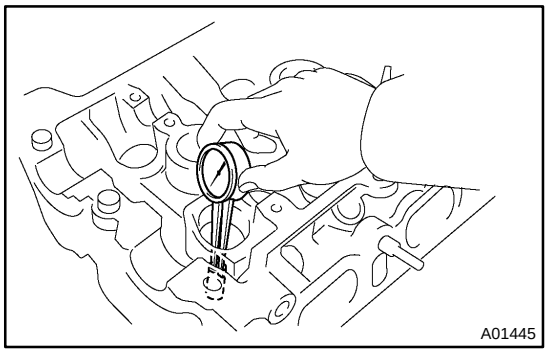
REPLACE VALVE GUIDE BUSHINGS



(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 09201-01055, 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
9.685 - 9.706 (0.38130 - 0.38213)	Use STD
9.735 - 9.756 (0.38327 - 0.38493)	Use O/S 0.05

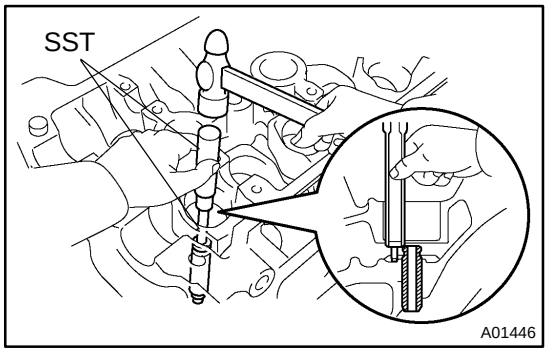
(d) Select the new guide bushing (STD or O/S 0.05).

If the bushing bore diameter of the cylinder head is greater than 9.706 mm (0.38213 in.), machine the bushing bore to the following dimension:

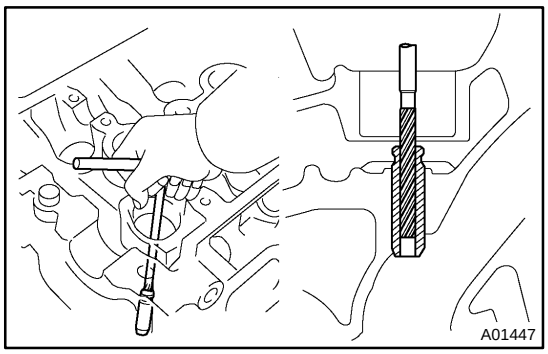
9.735 - 9.756 mm (0.38327 - 0.38493 in.)

If the bushing bore diameter of the cylinder head is greater than 9.756 mm (0.38493 in.), replace the cylinder head.

(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.
SST 09201-01055, 09950-70010 (09951-07100)
Protrusion height:
9.0 - 9.4 mm (0.354 - 0.370 in.)



(g) Using a sharp 5 mm reamer, ream the guide bushing to obtain the standard specified clearance (See page EM-32) between the guide bushing and valve stem.