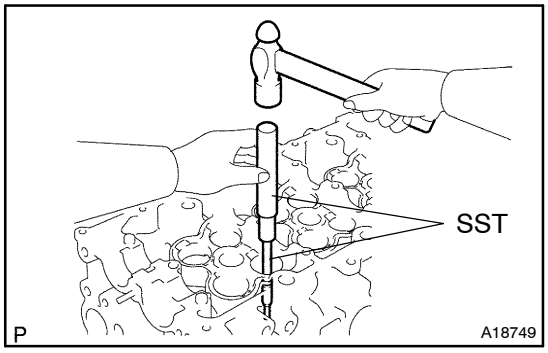
EM1TU–01

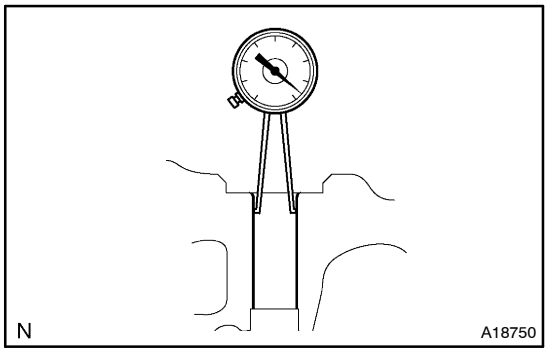
REPLACEMENT

1. REPLACE VALVE GUIDE BUSHINGS



(a) Using SST and a hammer, tap out the valve guide bushing.

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



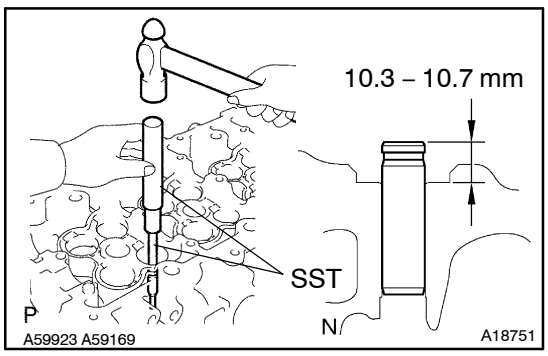
(b) Using a caliper gauge, measure the bushing bore diameter of the cylinder head.

(c) Select a new guide bushing (STD or O/S 0.05).

Bushing bore diameter	Bushing size
10.985 – 11.006 mm (0.4325 – 0.4333 in.)	Use STD
11.035 – 11.056 mm (0.4344 – 0.4353 in.)	Use 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 this dimension of 11.035 – 11.056 mm (0.4344 – 0.4353 in.).

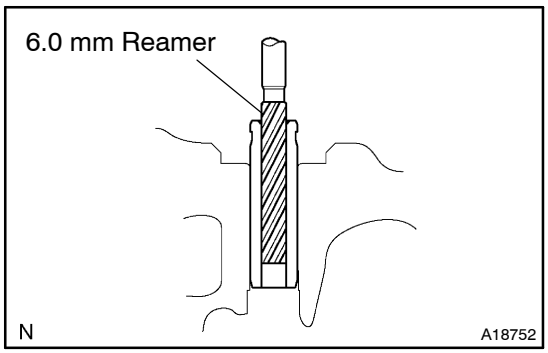
If the bushing bore diameter of the cylinder head is greater than 11.056 mm (0.4353 in.), replace the cylinder head.



(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: 10.3 – 10.7 mm (0.406 – 0.421 in.)



(e) Using a sharp 6.0 mm reamer, ream the guide bushing to obtain the standard specified clearance (See page EM–44) between the guide bushing and valve stem.