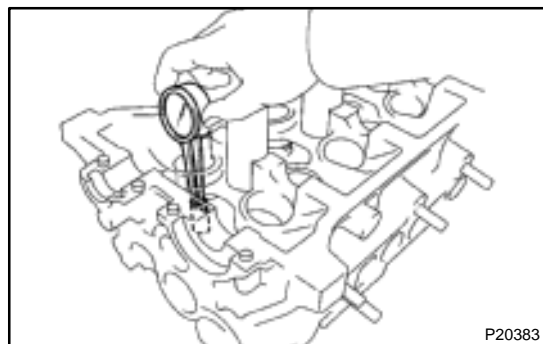


REPLACEMENT

REPLACE VALVE GUIDE BUSHINGS

- (a) Using SST and a hammer, tap out the guide bushing.
 SST 09201-10000 (09201-01060),
 09550-10012 (09252-10010)



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

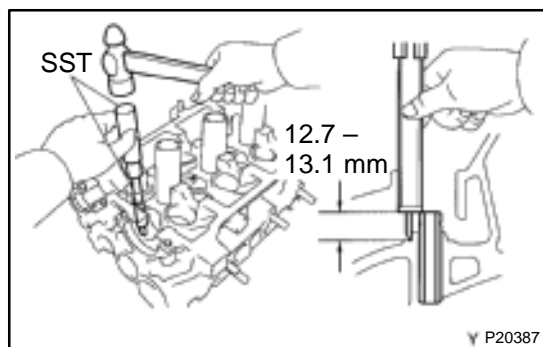
Both intake and exhaust

Bushing bore diameter mm (in.)	Bushing size
11.000 – 11.027 (0.4331 – 0.4342)	Use STD
11.050 – 11.077 (0.4350 – 0.4361)	Use O/S 0.05

- (c) Select a new guide bushing (STD size or O/S 0.05).
 If the bushing bore diameter of the cylinder head is greater than 11.027 mm (0.4341 in.), machine the bushing bore to the following dimension:

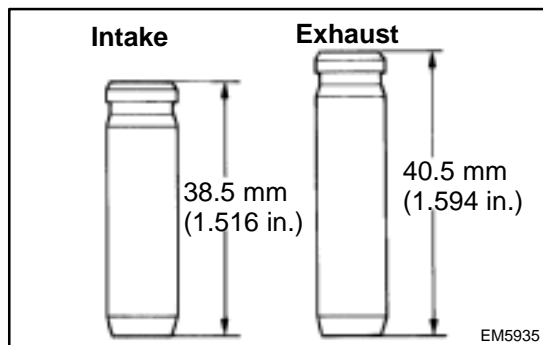
11.050 – 11.077 mm (0.4350 – 0.4361 in.)

- If the bushing bore diameter of the cylinder head is greater than 11.077 mm (0.4361 in.), replace the cylinder head.



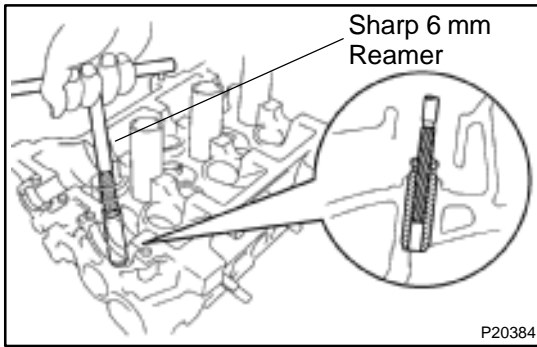
- (d) Using SST and a hammer, tap in a new guide bushing to where there is 12.7 – 13.1 mm (0.500 – 0.510 in.) left protruding from the cylinder head.

SST 09201-10000 (09201-01060)
 09550-10012 (09252-10010)



HINT:

Different bushings are used for the intake and exhaust.



- (e) Using a sharp 6 mm reamer, ream the guide bushing to obtain the standard specified clearance (See page [EM-31](#)) between the guide bushing and valve stem.