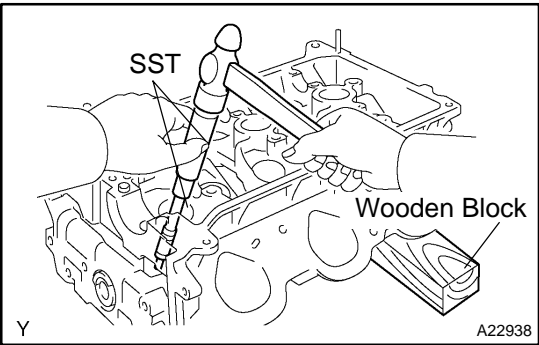


REPLACEMENT

1. REPLACE VALVE GUIDE BUSH

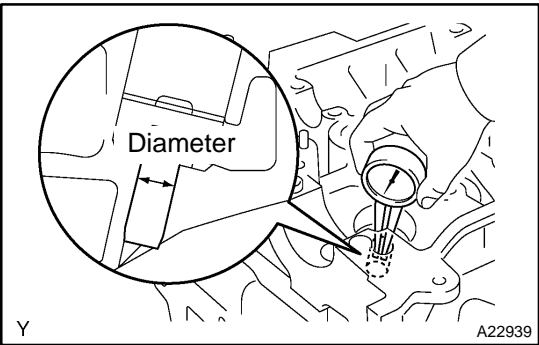
- (a) Gradually heat the cylinder head to between 80 and 100°C (176 to 212°F).



- (b) Place the cylinder head on a wooden block.

- (c) Using SST, tap out the valve guide bush.

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(09951-07100)



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

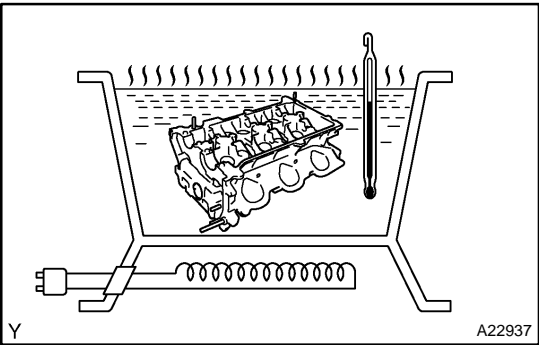
Bush bore diameter:

10.295 to 10.315 mm (0.4053 to 0.4061 in.)

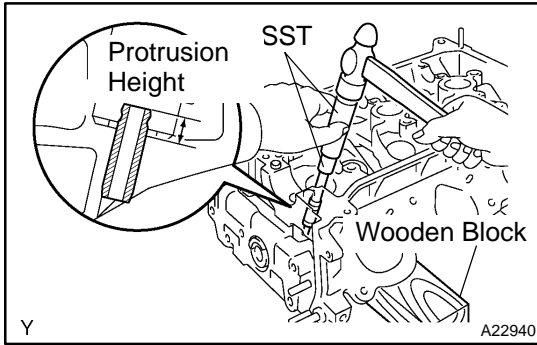
If the bush bore diameter of the cylinder head is greater than 10.315 mm (0.4061 in.), machine the bush bore to dimensions of 10.345 to 10.365 mm (0.4073 to 0.4081 in.).

Valve guide bush diameter

STD	10.333 to 10.344 mm (0.4068 to 0.4072 in.)
O/S 0.05	10.383 to 10.394 mm (0.4088 to 0.4092 in.)



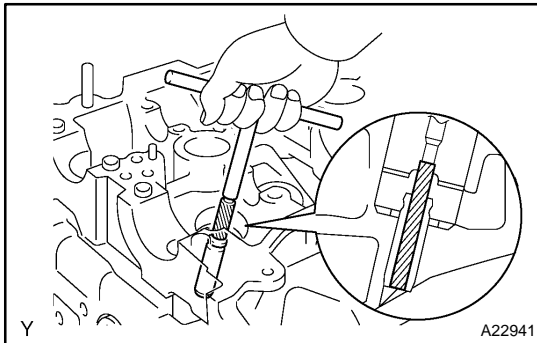
- (e) Gradually heat the cylinder head to between 80 and 100°C (176 to 212°F).



- (f) Place the cylinder head on a wooden block.
- (g) Using SST, tap in a new valve guide bush to the specified protrusion height.

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Protrusion height: 9.3 to 9.7 mm (0.366 to 0.382 in.)



- (h) Using a sharp 5.5 mm reamer, ream the valve guide bush to obtain the standard specified clearance between the valve guide bush and valve stem.

Standard oil clearance:

Intake	0.025 to 0.060 mm (0.0010 to 0.0024 in.)
Exhaust	0.030 to 0.065 mm (0.0012 to 0.0026 in.)