Measure and record each valve guide I.D. using a ball gauge or inside micrometer.

SERVICE LIMITS: IN/EX: 6.655 mm (0.2620 in)

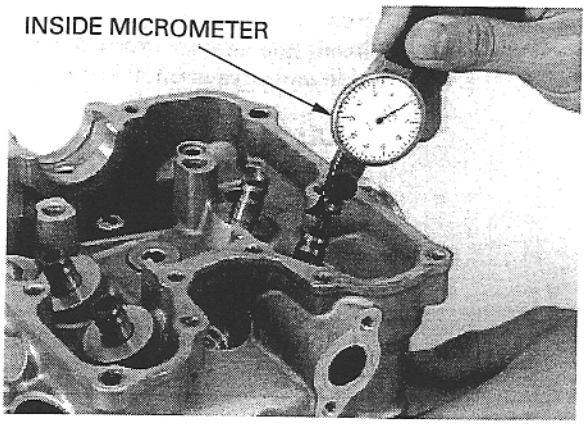
Subtract each valve stem O.D. from the corresponding guide I.D. to obtain the stem-to-guide clearance.

SERVICE LIMITS: IN: 0.12 mm (0.005 in)
EX: 0.14 mm (0.006 in)

If the stem-to-guide clearance exceeds the service limit, determine if a new guide with standard dimensions would bring the clearance within tolerance.
If so, replace the guides as necessary and ream them to fit.
If stem-to-guide clearance still exceeds the service limit after the new guides are installed, replace the valves.

NOTE:

Inspect and reface the valve seats whenever the valve guides are replaced (page 8-14).



VALVE GUIDE REPLACEMENT

⚠WARNING

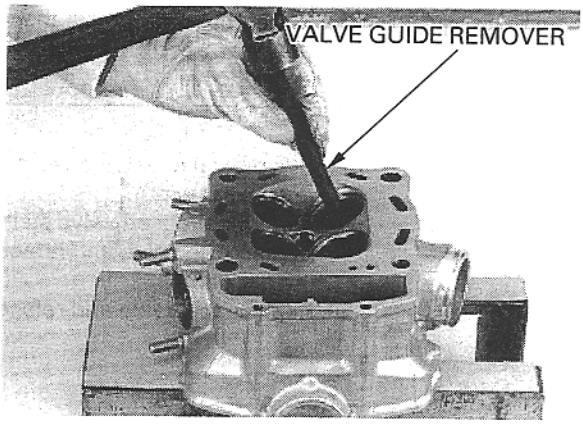
To avoid burns, wear heavy globes when handling the heated cylinder head.

CAUTION:

Do not use a torch to heat the cylinder head; it may cause warping.

Heat the cylinder head to 100—150°C (212—300°F).
Support the cylinder head and drive out the guides from the combustion chamber side.

TOOL:
Valve guide remover, 6.6 mm 07742-0010200



CAUTION:

Do not damage the cylinder head during guide removal.

Install a new O-ring on a new valve guide.
Install a new valve guide from the top of the head, then check that it was not damaged during installation.

TOOL:
Valve guide remover, 6.6 mm 07742-0010200

