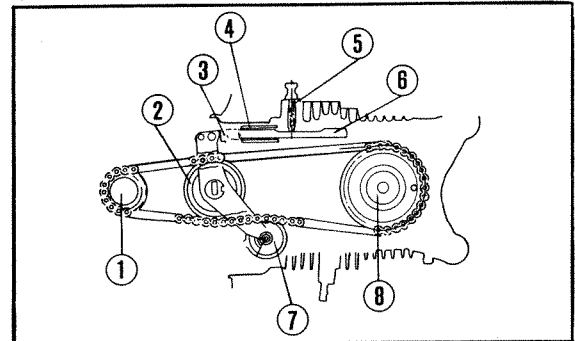


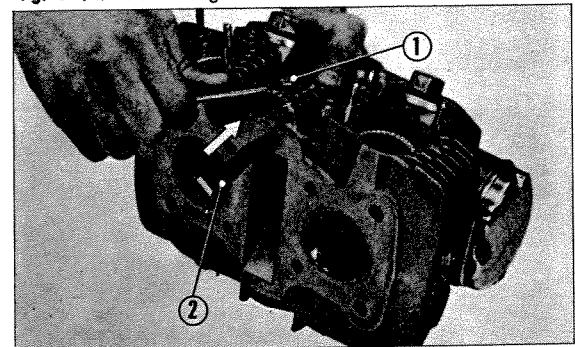
- When replacement of the valve guide becomes necessary, remove and replace with an oversize guide, use the valve guide remover (Tool No. 07047-04001) and the valve guide driver (Tool No. 07046-21601) for replacement operation. After installing the valve guide, use a reamer to obtain the proper valve clearance.

D. Reassembly

- Clean and inspect the cylinder head interior and exterior for cracks, damage and warpage, also inspect the head gasket, valves, valve guide and spring for satisfactory condition. Perform the head assembly in the reverse order of disassembly.
- When installing the cylinder head to the cylinder, the cam chain should be assembled as shown in Fig. 3-14 and attention should be given to the proper valve timing. Align the "T" timing mark on the generator to the timing index mark (the piston is at top-dead-center), position the camshaft sprocket so that the "O" mark on the face of the sprocket is at the top, and then assemble the cam chain. The joint clip must be installed with the opening facing in the opposite direction to the normal chain movement.
- If the cam chain tensioner pushbar is not completely pushed in, the cam chain cannot be connected. (Fig. 3-15)



① Center crankshaft ② Cam chain guide roller
 ③ Tensioner push rubber ④ Cam chain tensioner spring
 ⑤ Tensioner set bolt ⑥ Tensioner push bar
 ⑦ Cam chain tensioner ⑧ Cam shaft
Fig. 3-14. Assembling the cam chain



① Tensioner set bolt ② Tensioner push bar
Fig. 3-15. Pushing in the tension push bar

- The cylinder head should be tightened uniformly with the torque wrench in the sequence shown in Fig. 3-16. [Torque: 160~210 Kg. cm (11.6~15.2 ft. lb)]

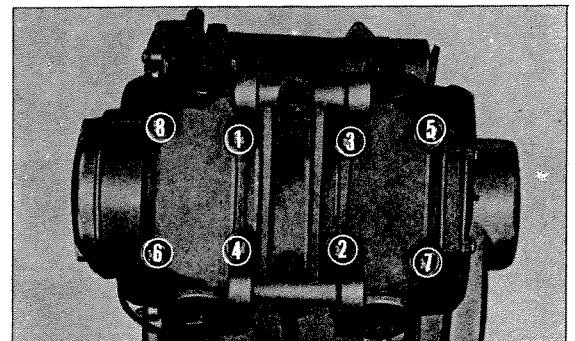


Fig. 3-16. Tightening sequence of the cylinder head