

4. Check the valve seat contact width and if necessary recondition.
Apply a thin coat of red lead to the valve seat surface. Press the valve against the seat and rotate it to check if the contact width is uniform. If not, lap the valve, seat and again check the contact width. If necessary, recondition the valve seat using a valve seat grinder.

CAUTION:

Use the valve seat grinder in accordance with the instruction manual.

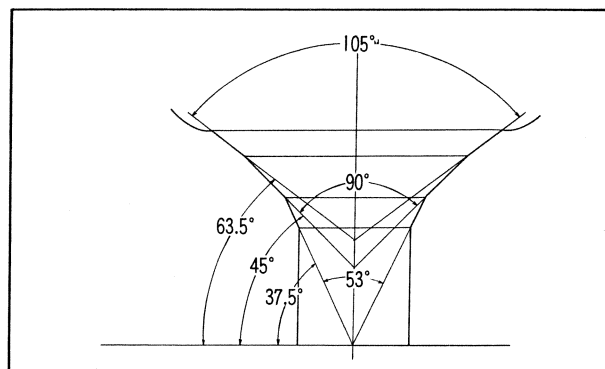


Fig. 4-25

5. Measure the valve-to-guide clearance.
6. Measure the valve spring free length. Also check the installed load.
7. Check the matching surface of the cylinder head for roughness.
8. Measure the cylinder bore.
Using a cylinder gauge, measure the cylinder bore in the directions X and Y at the upper, middle and lower points. If wear is too great so that the service limits are exceeded, the cylinder should be rebored, and oversize piston and piston rings installed. The following four oversize piston and piston rings are available as service parts:

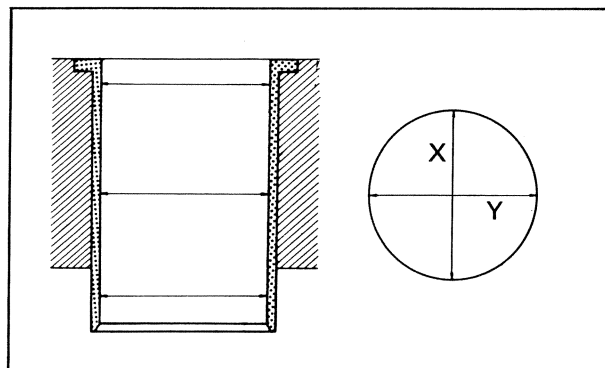


Fig. 4-26 Measure the cylinder bore

Unit: mm (in.)

Oversize piston and ring	Size to which cylinder is to be rebored	
	250 cc	360 cc
0.25	56.26-56.27 (2.2149-2.2153)	67.26-67.27 (2.6480-2.6484)
0.50	56.51-56.52 (2.2248-2.2252)	67.51-67.52 (2.6579-2.6583)
0.75	56.76-56.77 (2.235-2.295)	67.76-67.77 (2.6677-2.6681)
1.00	57.01-57.02 (2.2445-2.2449)	68.01-68.02 (2.6776-2.6780)

9. Measure the piston skirt OD (outside diameter).
10. Measure the piston pin hole diameter.
11. Measure the piston pin OD.
12. Check the side clearance of the piston ring in the groove.
13. Check the piston ring gap.
Install the ring squarely in the skirt of the cylinder to check the ring gap.

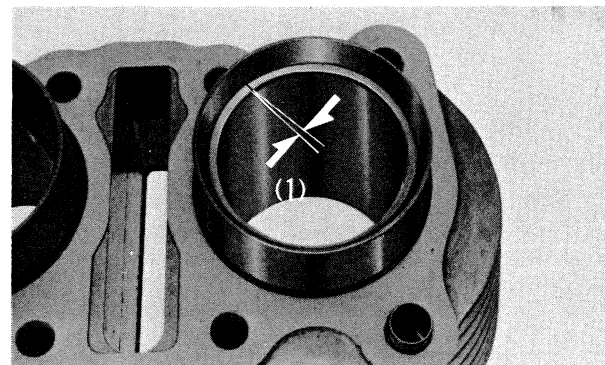


Fig. 4-27 (1) Piston ring gap

Assembly

To assemble, reverse the disassembly procedures paying attention to the following:

1. When the valve guide must be replaced, install it using the valve guide driver (Tool No. 07942-6110000) and finish the inside surface using the valve guide reamer (Tool No. 07984-5900000).

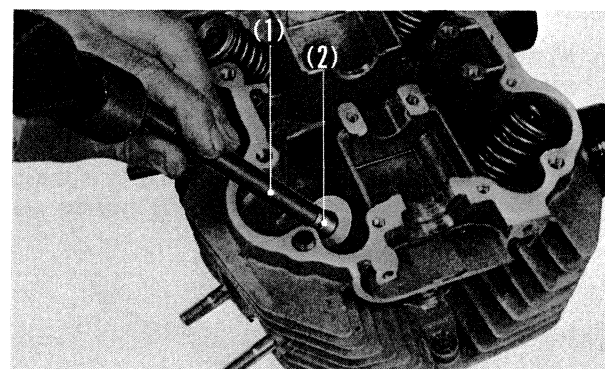


Fig. 4-28 (1) Valve guide remover
(2) Valve guide