

VALVE GUIDE REPLACEMENT

Chill the replacement valve guides in the freezer section of a refrigerator for about an hour.
Heat the cylinder head to 100–150 °C (212–300 °F) with a hot plate or oven.

▲WARNING

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

CAUTION:

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

Support the cylinder head and drive out the valve guides from combustion chamber side of the cylinder head.

TOOL:

Adjustable valve guide driver 07743-0020000

Adjust the tool setting depth with a pair of vernier calipers as shown.

DEPTH:

IN: 13.10–13.30 mm (0.516–0.524 in)

EX: 11.30–11.50 mm (0.445–0.453 in)

TOOL:

Adjustable valve guide driver 07743-0020000

Drive in the guide from the top of the head.

Let the cylinder head cool to room temperature.

Ream the new valve guide after installation.
Insert the reamer from the combustion chamber side of the head and also always rotate the reamer clockwise.

TOOL:

Valve guide reamer, 4.008 mm 07MMH-MV90100

NOTE:

Use cutting oil on the reamer during this operation.

Clean the cylinder head thoroughly to remove any metal particles.

Reface the valve seat (see next page).

