



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

SERVICE LIMIT:

IN: 5.04 mm (0.198 in)

EX: 5.04 mm (0.198 in)

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

SERVICE LIMITS:

IN: 0.07 mm (0.003 in)

EX: 0.09 mm (0.004 in)

If the stem-to-guide clearance exceeds the service limits, determine if a new guide with standard dimensions would bring the clearance within tolerance. If so, replace any guides as necessary and ream to fit.

If the stem-to-guide clearance exceeds the service limits with new guides, replace the valves and guides.

NOTE

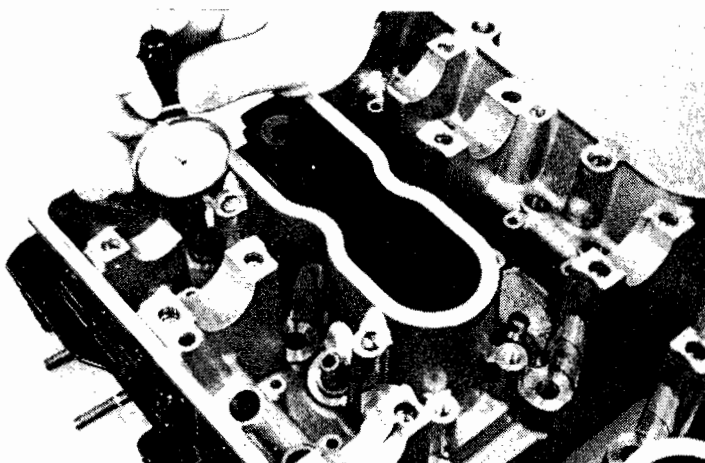
Reface the valve seats whenever the valve guides are replaced (Page 6-15).

VALVE GUIDE REPLACEMENT

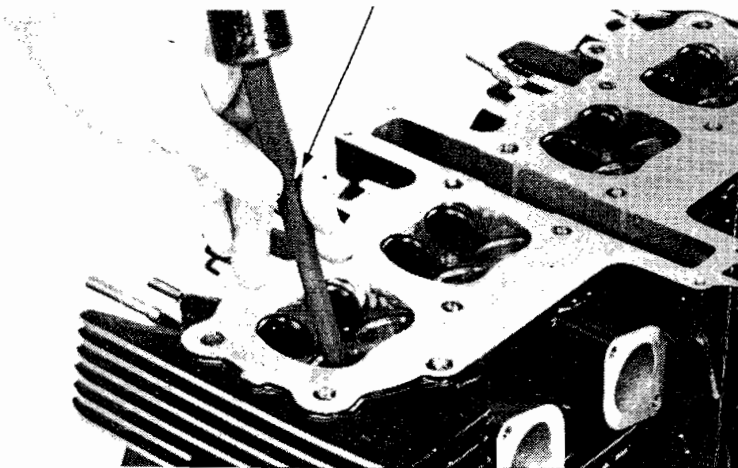
Support the cylinder head and drive the guide from the valve port out.

NOTE

When driving out the valve guide, be careful not to damage the head.



VALVE GUIDE REMOVER/DRIVER
07942-MA60000



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Install an oversize valve guide from the top of the head.

