

Both Intake and Exhaust

Bushing bore diameter mm (in.)	Bushing size
10.285 - 10.306 (0.4049 - 0.4057)	Use STD
10.335 - 10.356 (0.4069 - 0.4077)	Use O/S

## REPLACEMENT

### 1. REPLACE VALVE GUIDE BUSHINGS

- (a) Gradually heat the cylinder head to 80 - 100°C (176 - 212°F).
- (b) Using SST and a hammer, tap out the guide bushing.  
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(c) Using a caliper gauge, measure the bushing bore diameter of the cylinder head.

(d) Select a new guide bushing (STD or O/S 0.05).

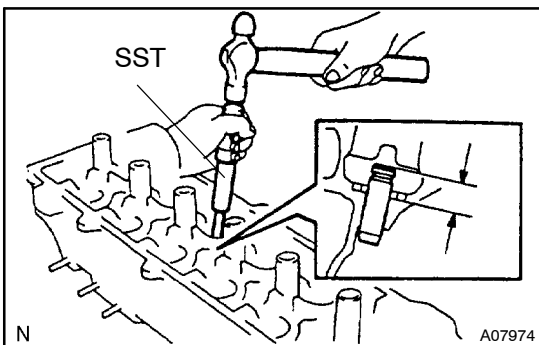
If the bushing bore diameter of the cylinder head is greater than 10.306 mm (0.4057 in.), machine the bushing bore to the following dimension:

**10.285 - 10.306 mm (0.40492 - 0.40575 in.)**

If the bushing bore diameter of the cylinder head is greater than 10.356 mm (0.4077 in.), replace the cylinder head.

HINT:

Different bushings are used for the intake and exhaust.



(e) Gradually heat the cylinder head to 80 - 100°C (176 - 212°F).

(f) Using SST and a hammer, tap in a new guide bushing to the specified protrusion height.

**Protrusion height:**

**Intake**

**12.7 - 13.1 mm (0.500 - 0.516 in.)**

**Exhaust**

**12.8 - 13.2 mm (0.504 - 0.520 in.)**

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(g) Using a sharp 5.5 mm reamer, ream the guide bushing to obtain the standard specified clearance (See page EM-41) between the guide bushing and valve stem.