

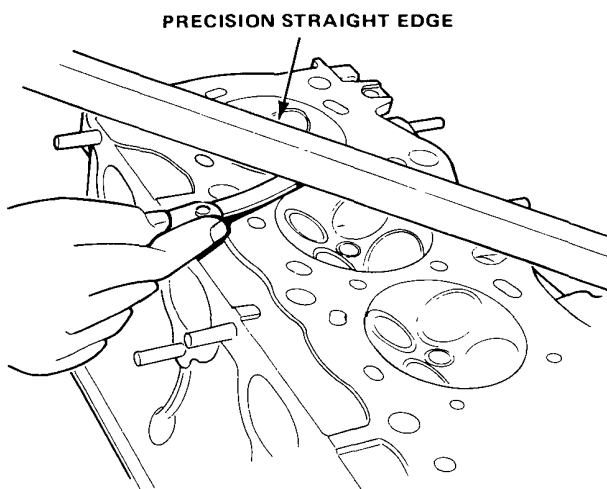
Cylinder Head

Warpage

NOTE: If camshaft bearing clearances (page 6-5) are not within specification, the head cannot be resurfaced.

If camshaft bearing radial clearances are within specifications, check head for warpage.

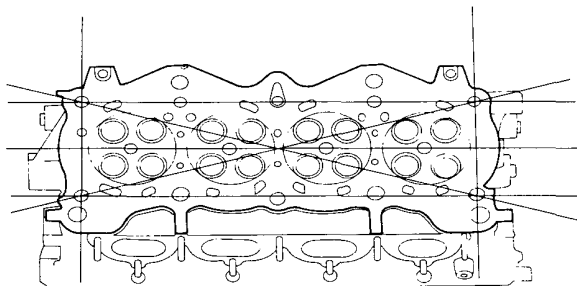
- If warpage is less than 0.05 mm (0.002 in.) cylinder head resurfacing is not required.
- If warpage is between 0.05 mm (0.002 in.) and 0.2 mm (0.008 in.), resurface cylinder head.
- Maximum resurface limit is 0.2 mm (0.008 in.) based on height of 132.0 mm (5.20 in.)



Cylinder Head Height:

New: 132.0 mm (5.20 in.)
Service Limit: 131.8 mm (5.19 in.)

Measure along edges, and 3 ways across center.



Valve Guide

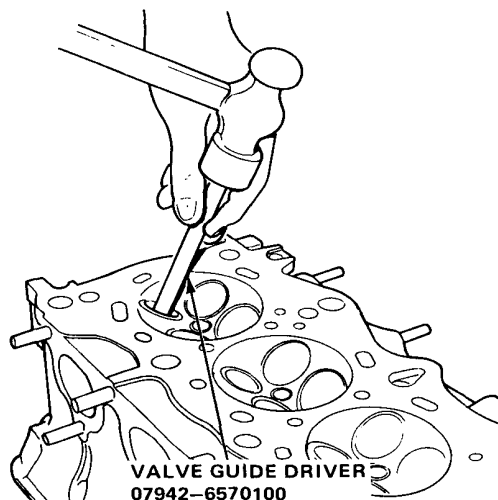
Replacement

NOTE:

- For best results, heat cylinder head to 150°C (300 °F) before removing or installing guides.
- It may be necessary to use an air hammer to remove some valve guides.

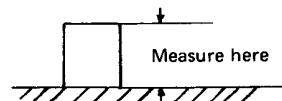
CAUTION: To avoid burns, use heavy gloves when handling heated cylinder head.

1. Drive the valve guide out from the bottom of the cylinder head.

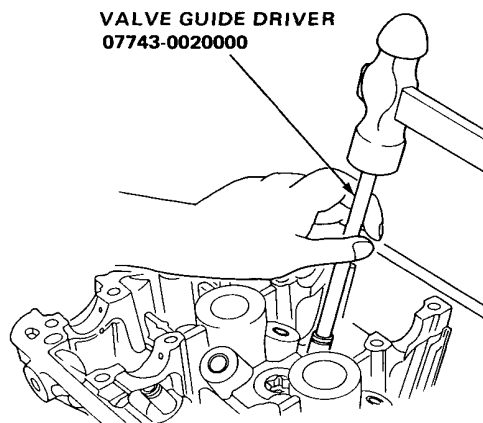


2. Drive in a new valve guide to the specified depth.

Intake: 20.0 mm (0.79 in.)
Exhaust: 19.0 mm (0.75 in.)



NOTE: If using adjustable valve guide driver 07743-0020000, adjust the collar depth to correspond with the measurements given above.

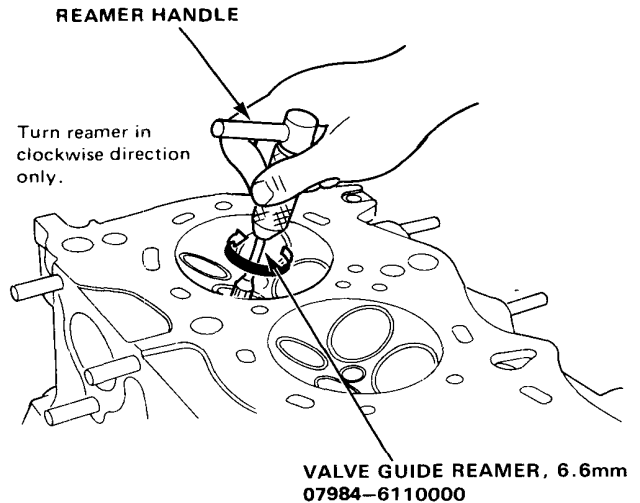


Valve Guide and Valve Spring

Valve Guide Reaming

NOTE: For new valve guides only.

1. Coat reamer and valve guide with cutting oil.
2. Rotate reamer clockwise the full length of the valve guide bore.
3. Continue to rotate reamer clockwise while removing.
4. Thoroughly wash the guide in detergent and water to remove any cutting residue.
5. Check clearance with valve (page 6-8).



Valve Spring Installation Sequence

NOTE: Exhaust and intake valve guide seals are NOT interchangeable.

