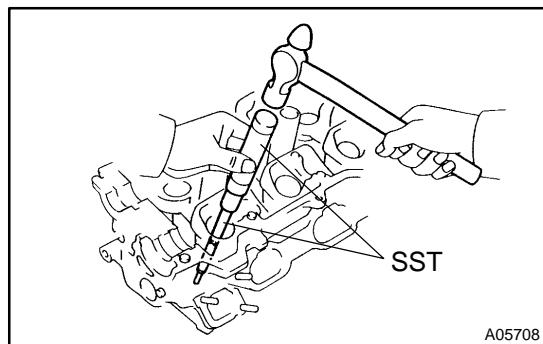


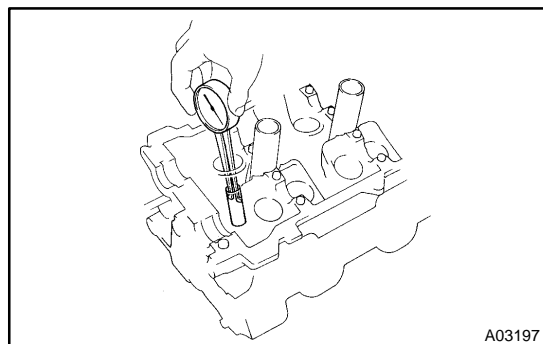
## REPLACEMENT

### 1. REPLACE VALVE GUIDE BUSHINGS

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



- (b) Using SST and a hammer, tap out the guide bushing.  
SST 09201-01055, 09950-70010 (09951-07100)



- (c) Using a caliper gauge, measure the bushing bore diameter of the cylinder head.

Both intake and exhaust

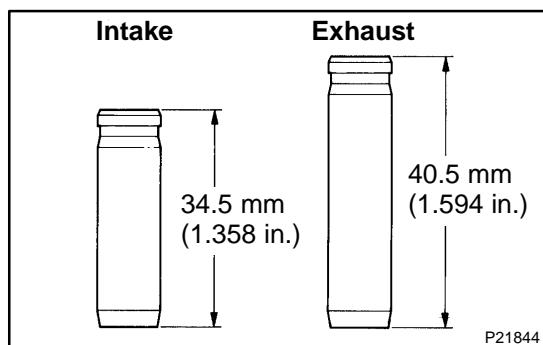
Bushing bore diameter mm (in.)	Bushing size
10.285 to 10.306 (0.4049 to 0.4057)	Use STD
10.335 to 10.356 (0.4069 to 0.4077)	Use O/S STD

- (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:

**10.335 to 10.356 mm (0.4069 to 0.4077 in.)**

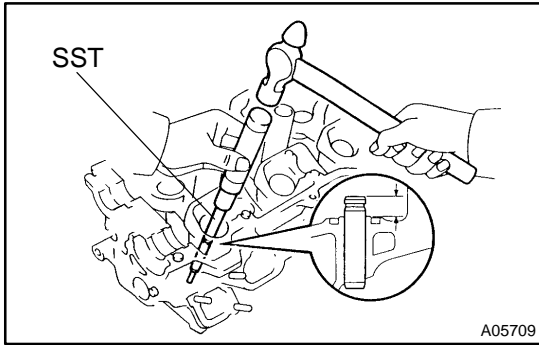
If the bushing bore diameter of the cylinder head is greater than 10.356 mm (0.4077 in.), replace the cylinder head.



#### HINT:

Different the bushings are used for the intake and exhaust.

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

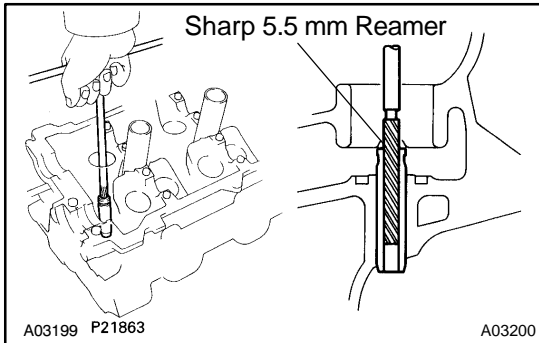


- (f) Using SST and a hammer, tap in a new guide bushing to the specified protrusion height.

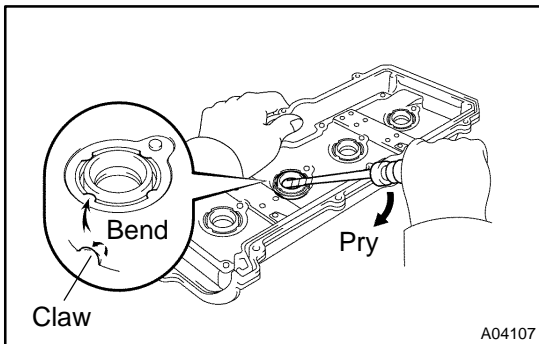
**Protrusion height:**

Intake	9.2 to 9.8 mm (0.362 to 0.386 in.)
Exhaust	8.2 to 8.8 mm (0.323 to 0.346 in.)

SST 09201-01055, 09950-70010 (09951-07100)



- (g) Using a sharp 5.5 mm reamer, ream the guide bushing to obtain the standard specified clearance (see page [EM-46](#)) between the guide bushing and valve stem.

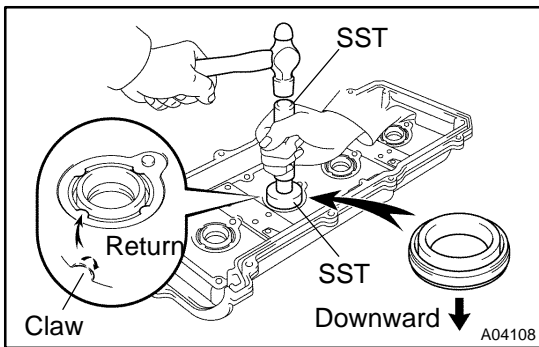


**2. REPLACE SPARK PLUG TUBE GASKETS**

- (a) Bend the 4 ventilation case claws installed on the cylinder head cover to an angle of 90° or more.  
(b) Using a screwdriver, pry out the gasket.

**NOTICE:**

**Be careful not to damage the cylinder head cover. Tape the screwdriver tip.**



- (c) Using SST and a hammer, tap in a new gasket until its surface is flush with the upper edge of the cylinder head cover.

SST 09950-60010 (09951-00240, 09951-00440, 09952-06010), 09950-70010 (09951-07100)

**NOTICE:**

**Be careful of the installation direction.**

- (d) Apply a light coat of MP grease to the gasket lip.  
(e) Return the 4 ventilation case claws to its original position.