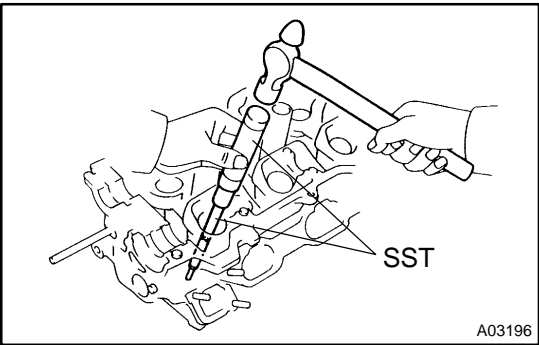


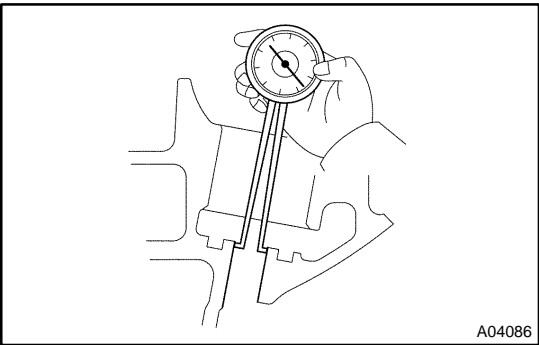
## REPLACEMENT

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



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

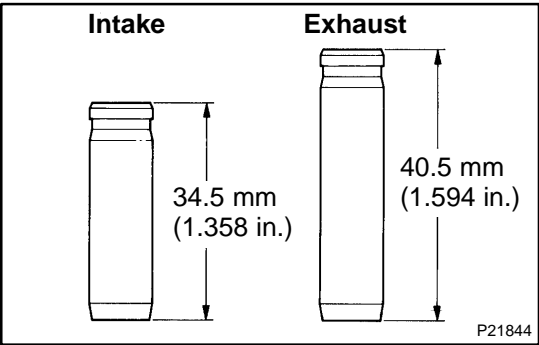
Both intake and exhaust

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

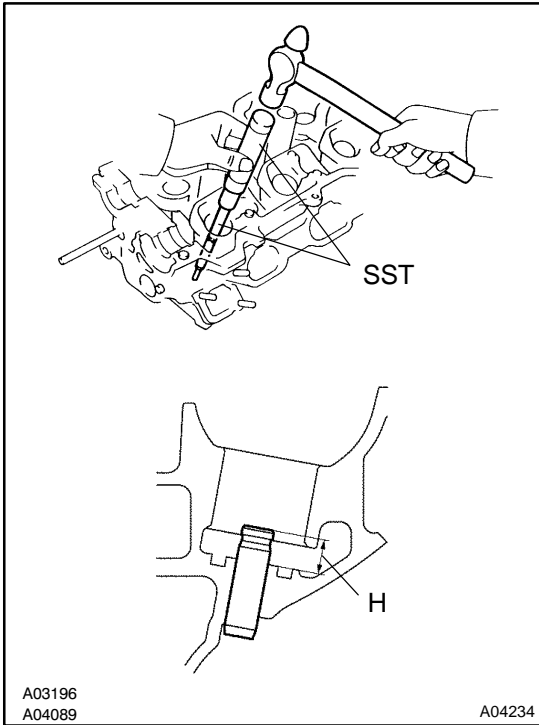
- (d) Select a new guide bushing (STD or O/S 0.05).  
If the bushing bore diameter of the cylinder head is greater than 10.306 mm (0.4057 in.), machine the bushing bore to this dimension:

**10.335 – 10.356 mm (0.4069 – 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.

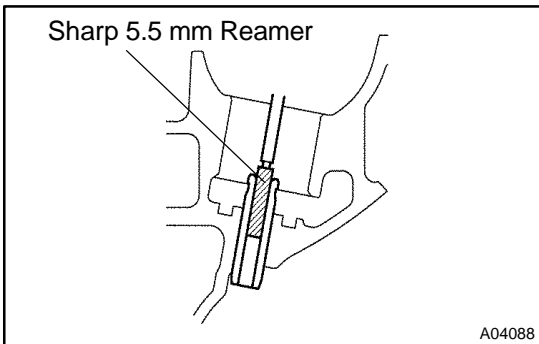


- (e) Gradually heat the cylinder head to 80 – 100°C (176 – 212°F).
- (f) Using SST and a hammer, tap in a new guide bushing to the specified protrusion height.

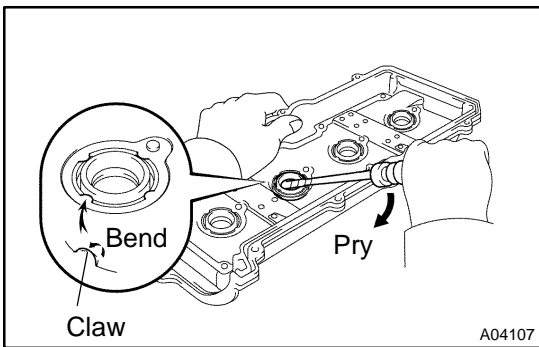
SST 09201-01055, 09950-70010 (09951-07100)

**Protrusion height (H):**

|         |                                  |
|---------|----------------------------------|
| Intake  | 9.2 – 9.8 mm (0.362 – 0.386 in.) |
| Exhaust | 8.2 – 8.8 mm (0.323 – 0.346 in.) |



- (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.

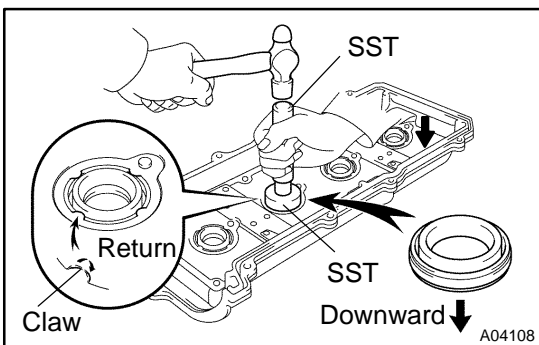


**2. REPLACE SPARK PLUG TUBE GASKETS**

- (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 (09551-00240, 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.