

• VALVE GUIDE REPLACEMENT

- 1) Drive the valve guide out of the cylinder head, using the valve guide driver (special tool).
- 2) Clean the valve guide bore, coat the new valve guide with oil, and drive it into the head as shown.



Seating depth	$25.5 \pm 0.5 \text{ mm (1.004} \pm 0.020 \text{ in)}$
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CAUTION

- Protect the head gasket surface to prevent damage during the driving operation.

- 3) After replacing the valve guide, ream the valve guide I.D. using the VALVE GUIDE REAMER (special tool).

CAUTION

- Always turn the reamer clockwise, never counter-clockwise. Continue to turn the reamer clockwise as you remove it from the valve guide.

b. INSPECTION

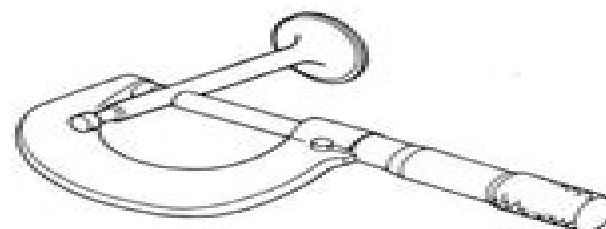
• VALVE STEM O.D.

	Standard	Service limit
IN	5.48 mm (0.216 in)	5.318 mm (0.2093 in)
EX	5.44 mm (0.214 in)	5.275 mm (0.2077 in)

• VALVE GUIDE I.D.

	Standard	Service limit
	5.50 mm (0.217 in)	5.572 mm (0.2194 in)

	Standard	Service limit
IN	0.02 – 0.044 mm (0.0008 – 0.0018 in)	0.10 mm (0.004 in)
EX	0.06 – 0.087 mm (0.002 – 0.0034 in)	0.12 mm (0.005 in)



Hs622 Shop Manual

Wolfgang Guggemos

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