

## • 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 | $25.5 \pm 0.5 \text{ mm (1.004} \pm 0.020 \text{ in)}$ |
|---------------|--------------------------------------------------------|

### 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

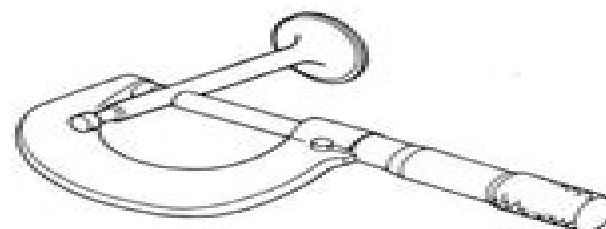
### • VALVE STEM O.D.

|    | 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<br>(0.0008 – 0.0018 in) | 0.10 mm (0.004 in) |
| EX | 0.06 – 0.087 mm<br>(0.002 – 0.0034 in)  | 0.12 mm (0.005 in) |



# Hs622 Shop Manual

**Rosina Ehmann**



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