

• 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

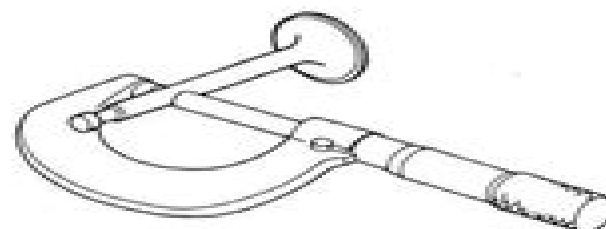
• VALVE STEM O.D.

	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)



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D Siedentop

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Table of Contents Hs622 Shop Manual

1. Understanding the eBook Hs622 Shop Manual
 - The Rise of Digital Reading Hs622 Shop Manual
 - Advantages of eBooks Over Traditional Books
2. Identifying Hs622 Shop Manual
 - Exploring Different Genres
 - Considering Fiction vs. Non-Fiction
 - Determining Your Reading Goals
3. Choosing the Right eBook Platform
 - Popular eBook Platforms
 - Features to Look for in an Hs622 Shop Manual
 - User-Friendly Interface
4. Exploring eBook Recommendations from Hs622 Shop Manual
 - Personalized Recommendations
 - Hs622 Shop Manual User Reviews and Ratings
 - Hs622 Shop Manual and Bestseller Lists
5. Accessing Hs622 Shop Manual Free and Paid eBooks

-
- Hs622 Shop Manual Public Domain eBooks
 - Hs622 Shop Manual eBook Subscription Services
 - Hs622 Shop Manual Budget-Friendly Options
6. Navigating Hs622 Shop Manual eBook Formats
 - ePub, PDF, MOBI, and More
 - Hs622 Shop Manual Compatibility with Devices
 - Hs622 Shop Manual Enhanced eBook Features
 7. Enhancing Your Reading Experience
 - Adjustable Fonts and Text Sizes of Hs622 Shop Manual
 - Highlighting and Note-Taking Hs622 Shop Manual
 - Interactive Elements Hs622 Shop Manual
 8. Staying Engaged with Hs622 Shop Manual
 - Joining Online Reading Communities
 - Participating in Virtual Book Clubs
 - Following Authors and Publishers Hs622 Shop Manual
 9. Balancing eBooks and Physical Books Hs622 Shop Manual
 - Benefits of a Digital Library
 - Creating a Diverse Reading Collection Hs622 Shop Manual
 10. Overcoming Reading Challenges
 - Dealing with Digital Eye Strain
 - Minimizing Distractions
 - Managing Screen Time
 11. Cultivating a Reading Routine Hs622 Shop Manual
 - Setting Reading Goals Hs622 Shop Manual
 - Carving Out Dedicated Reading Time
 12. Sourcing Reliable Information of Hs622 Shop Manual
 - Fact-Checking eBook Content of Hs622 Shop Manual
 - Distinguishing Credible Sources
 13. Promoting Lifelong Learning
 - Utilizing eBooks for Skill Development

- Exploring Educational eBooks

14. Embracing eBook Trends

- Integration of Multimedia Elements
- Interactive and Gamified eBooks

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