

• 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

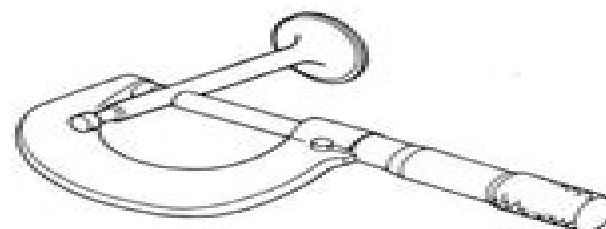
• VALVE STEM O.D.

	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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web above in all three auto positions the pumps shall be stopped by hand only as it will be common practice to run the diesel and electrical fire pump at least once a week for a couple of minutes and to prevent any damage to the pumps a return pipe

to the reservoir sized for approximately 35 of the pump s duty point flow is to be

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