



Fig. 1-9 ① Valve guide driver (07942-3290200)

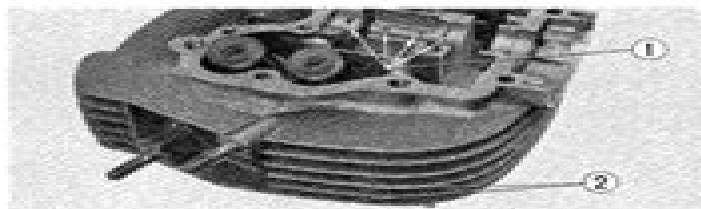


Fig. 1-10 ① Oil holes ② Rubber inserts



Fig. 1-11 ① Index mark ② "T" mark



Fig. 1-12 ①, ② Tappet wrench (07908-3290000)

NOTE:

After installing a new valve guide, be sure to finish its inside surface with reamer (Tool No. 07984-2000000).

Key to Assembly

1. Installation of valve springs.
Install valve spring on valve with its smaller pitch side facing valve head, since pitches of valve spring are not uniform.
2. Installation of cylinder head gasket.
Install cylinder head gasket in right place; otherwise internal gases may leak.
3. Inspection of oil holes.
Make sure all oil holes (one in each camshaft bearing and two in oil sump) are not clogged.
4. Inspection of rubber inserts.
Make sure all rubber inserts are inserted in place, since they are provided to prevent resonance.

NOTE:

Tighten the cylinder block and head bolts slowly in a criss-cross pattern. Tighten them to the specified torque.

Adjustment of Tappets

Too large tappet clearance may cause noisy tappet operation, and too small clearance may cause a damage to valves and insufficient power. This is why tappet clearance should be maintained properly.

1. Remove inlet and exhaust tappet covers.
2. Remove generator cover.
3. Hand-rotate generator rotor CCW (Counter clockwise) while watching the movement of cylinder inlet tappets. Stop rotating the rotor when index mark ① is aligned with mark "T" ② with piston at TDC (Top Dead Center) position on compression stroke. Inlet and exhaust valves should now be in fully closed position.
4. Check tappet clearance by inserting feeler gauge into between valve stem and tappet adjusting screw. If the clearance is correct, there will be a slight drag or resistance as the gauge is inserted. The standard tappet clearances are:
Inlet: 0.05 mm (0.002 in.) (cold condition)
Exhaust: 0.08 mm (0.003 in.)
5. Adjust the clearance by loosening lock nut ③ and turning tappet adjusting screw ④. Use tappet wrench (Tool No. 07908-3290000). Tappet wrench consists of tappet wrench A and B.

NOTE:

Make sure the adjustment has not been disturbed while tightening lock nut.

Honda XI 250 User Manual

**Thirumalaisamy P.
Velavancorresponding**

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Table of Contents Honda Xl 250 User Manual

1. Understanding the eBook Honda Xl 250 User Manual
 - The Rise of Digital Reading Honda Xl 250 User Manual
 - Advantages of eBooks Over Traditional Books
2. Identifying Honda Xl 250 User 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 Honda Xl 250 User Manual
 - User-Friendly Interface
4. Exploring eBook Recommendations from Honda Xl 250 User Manual
 - Personalized Recommendations
 - Honda Xl 250 User Manual User Reviews and Ratings
 - Honda Xl 250 User Manual and Bestseller Lists

5. Accessing Honda XI 250 User Manual Free and Paid eBooks
 - Honda XI 250 User Manual Public Domain eBooks
 - Honda XI 250 User Manual eBook Subscription Services
 - Honda XI 250 User Manual Budget-Friendly Options
6. Navigating Honda XI 250 User Manual eBook Formats
 - ePub, PDF, MOBI, and More
 - Honda XI 250 User Manual Compatibility with Devices
 - Honda XI 250 User Manual Enhanced eBook Features
7. Enhancing Your Reading Experience
 - Adjustable Fonts and Text Sizes of Honda XI 250 User Manual
 - Highlighting and Note-Taking Honda XI 250 User Manual
 - Interactive Elements Honda XI 250 User Manual
8. Staying Engaged with Honda XI 250 User Manual
 - Joining Online Reading Communities
 - Participating in Virtual Book Clubs
 - Following Authors and Publishers Honda XI 250 User Manual
9. Balancing eBooks and Physical Books Honda XI 250 User Manual
 - Benefits of a Digital Library
 - Creating a Diverse Reading Collection Honda XI 250 User Manual
10. Overcoming Reading Challenges
 - Dealing with Digital Eye Strain
 - Minimizing Distractions
 - Managing Screen Time
11. Cultivating a Reading Routine Honda XI 250 User Manual
 - Setting Reading Goals Honda XI 250 User Manual
 - Carving Out Dedicated Reading Time
12. Sourcing Reliable Information of Honda XI 250 User Manual
 - Fact-Checking eBook Content of Honda XI 250 User 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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