



Fig. 1-9 ① Valve guide driver (007942-3290200)



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 (007908-3290000)

**NOTE:**

After installing a new valve guide, be sure to finish its inside surface with reamer (Tool No. 007984-2000000).

**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. 007908-3290000). Tappet wrench consists of tappet wrench A and B.

**NOTE:**

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

# [Honda Xl250 1972 Prts Manuel](#)

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