

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



Fig. 1-10 (i) Oil holes

(2) Rubber inserts

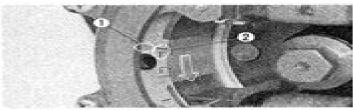


Fig. 1-11 (i) Index merii (j) "T" mark



Fig. 1-12 (i). (j) 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

- 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.
- Installation of cylinder head gasket. Install cylinder head gasket in right place; otherwise internal gases may leak.
- Inspection of oil holes.
 Make sure all oil holes (one in each camshaft bearing and two in oil sump) are not clogged.
- Inspection of rubber inserts.
 Make sure all rubber inserts are inserted in place, since they are provided to pevent resonance.

NOTE

Tighten the cylinder block and head bolts slowly in a crisscross 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.

- Remove inlet and exhaust tappet covers.
- Remove generator cover.
- 3. Hand-rotate generator rotor CCW (Counter clock-wise) 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.) Exhaust: 0.06 mm (0.003 in.) (cold condition)

 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.

INCOME:

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

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- 1. Understanding the eBook Honda Xl250 1972 Prts Manuel
 - The Rise of Digital Reading Honda Xl250 1972 Prts Manuel
 - Advantages of eBooks Over Traditional Books
- 2. Identifying Honda Xl250 1972 Prts Manuel
 - Exploring Different Genres
 - o 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 Xl250 1972 Prts Manuel
 - User-Friendly Interface
- 4. Exploring eBook Recommendations from Honda Xl250 1972 Prts Manuel
 - Personalized Recommendations
 - ∘ Honda Xl250 1972 Prts Manuel User Reviews and Ratings
 - Honda Xl250 1972 Prts Manuel and Bestseller Lists

- 5. Accessing Honda Xl250 1972 Prts Manuel Free and Paid eBooks
 - Honda Xl250 1972 Prts Manuel Public Domain eBooks
 - Honda Xl250 1972 Prts Manuel eBook Subscription Services
 - Honda Xl250 1972 Prts Manuel Budget-Friendly Options
- 6. Navigating Honda Xl250 1972 Prts Manuel eBook Formats
 - o ePub, PDF, MOBI, and More
 - Honda Xl250 1972 Prts Manuel Compatibility with Devices
 - Honda Xl250 1972 Prts Manuel Enhanced eBook Features
- 7. Enhancing Your Reading Experience
 - Adjustable Fonts and Text Sizes of Honda Xl250 1972 Prts Manuel
 - Highlighting and Note-Taking Honda Xl250 1972 Prts Manuel
 - Interactive Elements Honda Xl250 1972 Prts Manuel
- 8. Staying Engaged with Honda Xl250 1972 Prts Manuel
 - Joining Online Reading Communities
 - Participating in Virtual Book Clubs
 - Following Authors and Publishers Honda Xl250 1972 Prts Manuel
- 9. Balancing eBooks and Physical Books Honda Xl250 1972 Prts Manuel
 - Benefits of a Digital Library
 - Creating a Diverse Reading Collection Honda Xl250 1972 Prts Manuel
- 10. Overcoming Reading Challenges
 - o Dealing with Digital Eye Strain
 - Minimizing Distractions
 - Managing Screen Time
- 11. Cultivating a Reading Routine Honda Xl250 1972 Prts Manuel
 - Setting Reading Goals Honda Xl250 1972 Prts Manuel
 - Carving Out Dedicated Reading Time
- 12. Sourcing Reliable Information of Honda Xl250 1972 Prts Manuel
 - Fact-Checking eBook Content of Honda Xl250 1972 Prts Manuel
 - 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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