

CYLINDER HEAD OVERHAUL

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Renewing the Valve Guides

Remove and dismantle the cylinder head (Refer to Sub-section A131).

Thoroughly clean the cylinder head.

The dismantled cylinder head must be supported on locally made wood blocks — two for inlet guides and two for exhaust guides — on a press bed so that the guides being worked on are vertical.

The replacement valve guides are pre-finished and do not require reaming.

To Remove

Special Tools

Mandrel	21876 M
Guide locating tool	21875 L

Equipment

Wood blocks, locally made

Insert the mandrel 21876 M in the guide to be removed (Fig. 1) and press it out.

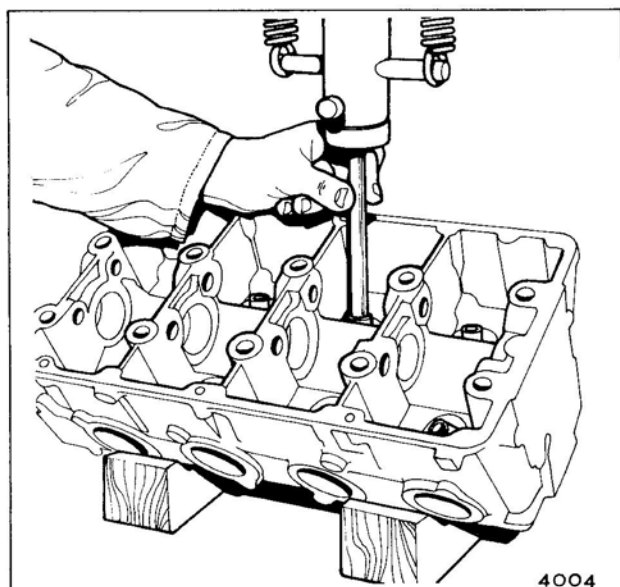


Fig. 1 Removing a valve guide

To Fit

The fitting operation should be carried out in two stages to ensure that the guide is entering the cylinder head squarely.

Lubricate the outside of the new guide, place it in the bore, chamfered end first, insert the mandrel 21876 M and press the guide in, checking it for squareness, until the full diameter is engaged.

Release the press, remove the mandrel and fit the locating tool 21875 L over the guide (Fig. 2) and press the guide in until the shoulder of the tool is in contact with the cylinder head.

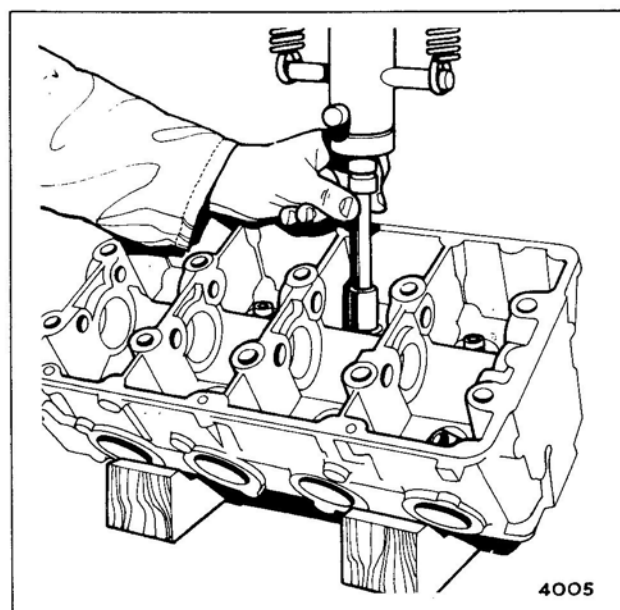


Fig. 2 Fitting a new valve guide

Remove the tools. Examine each end of the guide for burrs, removing them if present, and check that the valve stem slides freely in the guide.