Valve Seat Inserts (SENR7410-04)

**SMCS** - 1103, 1104

2003/02/01

SENR74100052

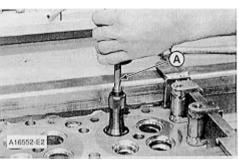
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### Remove Valve Seat Inserts

Tools Needed			A
983095	Handle Assembly		1.
983081	Extractor (intake)		1
983089	Extractor (Exhaust)		1

Start By:

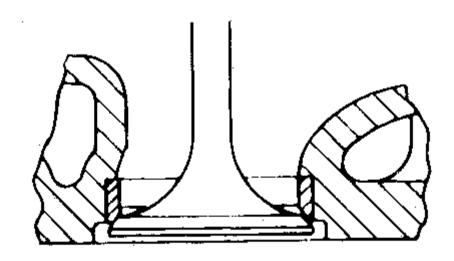
a. remove valves



- **1.** Remove valve seat inserts with Tool (A).
- **2.** Clean and remove burns from the valve seat bore.

# Install Valve Seat Inserts

Tools Needed		
983095	Handle Assembly	$0/_{\odot}1$
983081	Extractor (intake)	407
983089	Extractor (Exhaust)	1



88247-1E2

**1.** Lower the temperature of the valve and seat inserts and install them with Tool (A).

#### **NOTICE**

Do not make the diameter of the extractor in valve seat insert larger when the insert is installed in the cylinder head.

**2.** Grind vale seat insert according to the specifications given in Specifications.

End By:

a. install valves

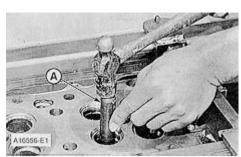
## Remove Valve Guides

30/11/22, 13:34 SIS 2.0

		Tools Needed	Α
7\$8859	Driver		†

#### Start By:

#### a. remove valves

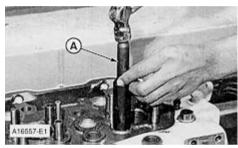


1. Remove valve guides with Tool (A).

### Install Valve Guides

		Tools Needed	6	A
7S8859	Driver		0	1.
5P2396	Bushing	0		Ψ

1. Put clean engine oil on the outside of the valve guides



2. Use Tool (A) to install valve guides. Guides must be extended 32.3 ± 0.8 mm (1.27 ± .03 in) from the surface of the head. The inside diameter of 10 in). . . . the guides must be 9.487 to 0.025 mm (.3735  $\pm$  .0010 in). The maximum diameter for used guides is 9.545 mm (.3758 in).

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### End By:

a. install valves

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