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2415-14

## VALVE GUIDE REPLACEMENT 14 mm Replacement Valve Guides

There are two different diameters of replacement valve guides for your engine. You can get either 14 mm or 11 mm OD replacement valve guides. Measure the replacement valve guides before you machine the cylinder head.

### Specifications

Valve guide OD \_\_\_\_\_ 14.008 to 14.038 mm  
 Bore cylinder head to \_\_\_\_\_ 13.987 to 14.013 mm  
 Installed height above top of valve guide boss  
 on cylinder head \_\_\_\_\_ 11.25 to 11.75 mm

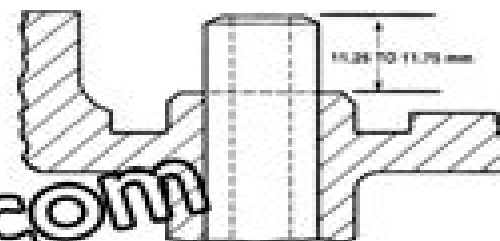
### STEP 41



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**890289U**  
 Drill the valve guide bores to 13.987 to 14.013 mm diameter.

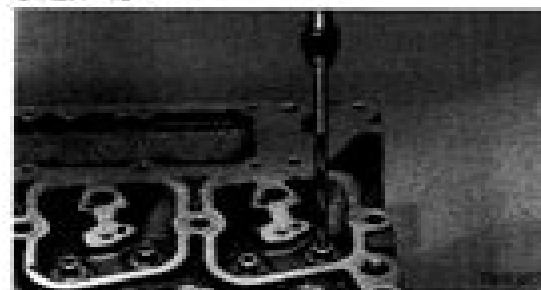
### STEP 42



890289U

Make a bushing 16.038 mm ID x 11.25 to 11.75 mm long. Install the bushing over the new valve guide. Press the new valve guide into the cylinder head until the press contacts the bushing.

### STEP 43



Drill the new valve guides to a diameter of 8.0 mm. Ream the new valve guides to a finished diameter of 8.019 to 8.039 mm.

# Case 550g Repair Manual

**Roman Wölfel**

A red circular graphic with a gradient, appearing as a stylized arrow or a partial circle, located to the right of the author's name.

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