Inlet and Exhaust Valve Seat Inserts - Remove and Install

SMCS - 1103-010

Removal Procedure

Table 1

<table>
<thead>
<tr>
<th>Tool</th>
<th>Part Number</th>
<th>Part Description</th>
<th>Qty</th>
</tr>
</thead>
<tbody>
<tr>
<td>A</td>
<td>166-7441</td>
<td>Valve Seat Extractor Tool Group</td>
<td>1</td>
</tr>
</tbody>
</table>

Start By:

A. Remove the inlet and exhaust valves. Refer to Disassembly and Assembly, "Inlet and Exhaust Valves - Remove and Install".

NOTICE

Keep all parts clean from contaminants.

Contaminants may cause rapid wear and shortened component life.

1. Use Tooling (A) to remove the valve seat inserts from the cylinder head.
2. Clean the bores in the cylinder head for the valve seat inserts. Remove any rough areas from the bores.

**Installation Procedure**

**Table 2**

<table>
<thead>
<tr>
<th>Tool</th>
<th>Part Number</th>
<th>Part Description</th>
<th>Qty</th>
</tr>
</thead>
<tbody>
<tr>
<td>B (1)</td>
<td>9U-6898</td>
<td>Valve Seat Driver (Exhaust)</td>
<td>1</td>
</tr>
<tr>
<td></td>
<td>9U-6897</td>
<td>Valve Seat Driver (Inlet)</td>
<td>1</td>
</tr>
</tbody>
</table>

(1) Part of 9U-7530 Engine Tool Group

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**NOTICE**

*Keep all parts clean from contaminants.*

*Contaminants may cause rapid wear and shortened component life.*

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View Image

Illustration 2  g00514539

Typical example

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View Image

1. Lower the temperature of new valve seat inserts (1). Use Tooling (B) to install the new valve seat inserts in the cylinder head.

   **Note:** Do not increase the diameter of the extractor in the valve seat insert when the insert is installed in the cylinder head.

2. Machine the valve seat inserts. Refer to Specifications, "Cylinder Head Valves".

**End By:** Install the inlet and exhaust valves. Refer to Disassembly and Assembly, "Inlet and Exhaust Valves - Remove and Install".

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Illustration 3  
Typical example

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