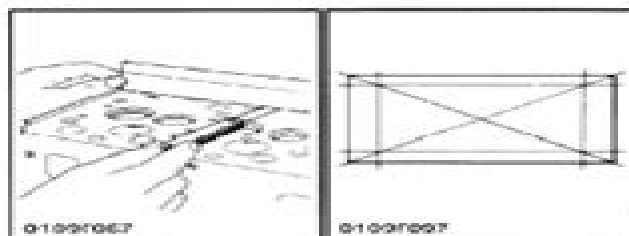


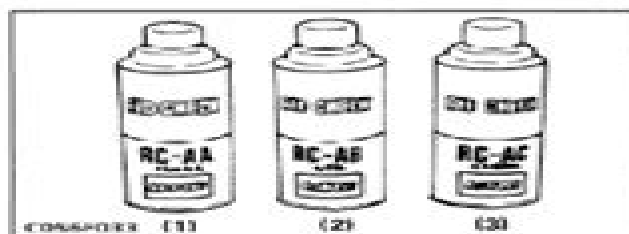
SERVICING

[1] CYLINDER HEAD



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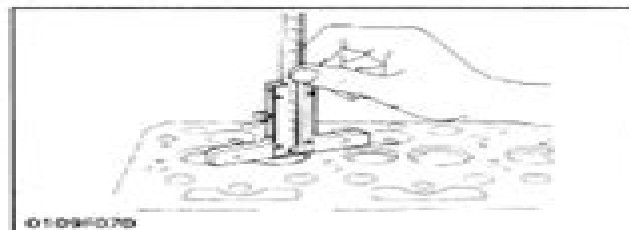
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(2)

(3)



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Cylinder Head Surface Flatness

1. Thoroughly clean the cylinder head surface.
2. Place a straight-edge on the cylinder head's four sides and two diagonal as shown in the figure. Measure the clearance with a feeler gauge.
3. If the measurement exceeds the allowable limit, correct it with a surface grinder.

■ **NOTE**

- Do not place the straight-edge on the combustion chamber.

■ **IMPORTANT**

- Be sure to check the valve recessing after correcting.

Flatness	Allowable limit	0.05 mm (0.0020 in.)
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Cylinder Head Flaw

1. Prepare a red check (Code no: 07909-31371).
2. Clean the surface of the cylinder head with detergent (1).
3. Spray the cylinder head surface with the red permeative liquid (2).
4. Wash away the red permeative liquid on the cylinder head surface with the detergent (1).
5. Spray the cylinder head surface with white developer (3). If flawed, it can be identified as red marks.

Valve Recessing

1. Clean the cylinder head, the valve face and seat.
2. Insert the valve into guide.
3. Measure the valve recessing with a depth gauge.
4. If the measurement exceeds the allowable limit, replace the valve.
If it still exceeds the allowable limit after replacing the valve, correct the valve seat face of the cylinder head with a valve seat cutter (Code No: 07909-33102) or valve seat grinder. Then, correct the cylinder head surface with a surface grinder, or replace the cylinder head.

Valve recessing	Factory specification	0.75 to 0.95 mm 0.0295 to 0.0374 in.
	Allowable limit	1.2 mm 0.047 in.

Kubota Df750 Service Manual

JPNZ (Firm)



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