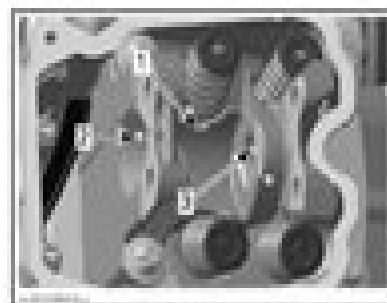


Check mating surface between cylinder and cylinder head for contamination. If so, clean both surfaces.

Clean oil support through the cylinder head from contamination.



1. Oil support to cylinder head timing chain guide
2. Oil support to cylinder head timing chain guide
3. Oil support to cylinder head timing chain guide

Inspecting the Cylinder Head Camshaft Bearing

Measure camshaft bearing in cylinder head.



1. Camshaft bearing
2. Camshaft bearing

| CAMSHAFT BEARING (TIMING CHAIN SIDE) | |
|--------------------------------------|---|
| Item | 35.000 mm to 35.025 mm (1.378 in to 1.3799 in) |
| Service limit | 35.045 mm (1.3799 in) |

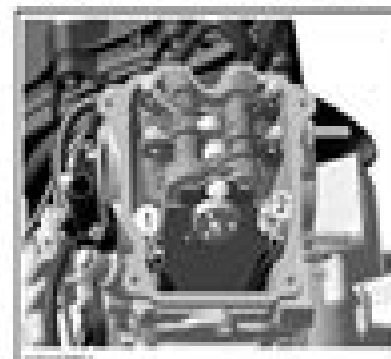
| CAMSHAFT BEARING (SPARK PLUG SIDE) | |
|------------------------------------|--|
| Item | 33.000 mm to 33.025 mm (1.299 in to 1.307 in) |
| Service limit | 33.045 mm (1.307 in) |

Installing the Cylinder Head

For installation, reverse the removal procedure. Pay attention to the following details.

Ensure dowel pins are in place.

NOTICE Timing chain guide (fixed) has to be fixed between cylinder and cylinder head.

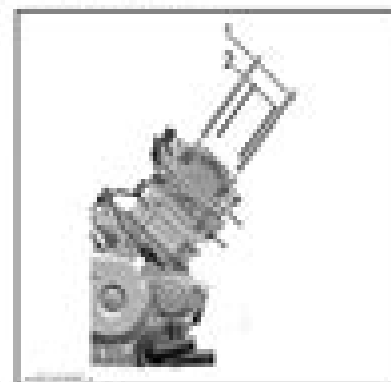


1. Timing chain guide (flexible) was mounted in previous
2. Timing chain guide (fixed) between cylinder and cylinder head
3. Timing chain guide (fixed) between cylinder and cylinder head

Install a NEW cylinder head gasket.

Install cylinder head screws.

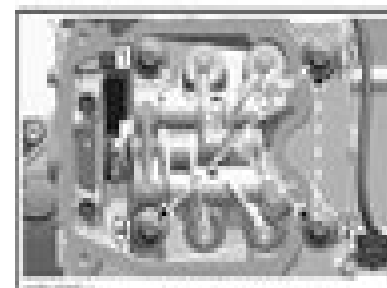
NOTICE Check for proper lengths of the cylinder head screws.



1. Timing chain guide (flexible)
2. Timing chain guide (flexible)

| CYLINDER HEAD SCREW IDENTIFICATION | |
|------------------------------------|-----------|
| LOCATION NO. 1 | M10 x 130 |
| LOCATION NO. 2 | M8 x 100 |

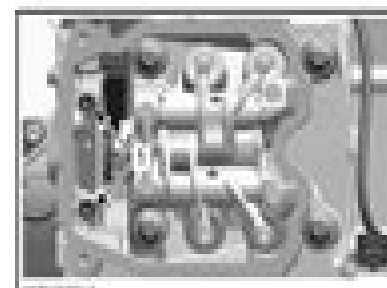
Tighten M10 cylinder head screws FIRST as per following specifications.



Tighten M8 cylinder head screws as per following specifications.

| TIGHTENING TORQUE | | |
|--------------------------|--------|---|
| M10 Cylinder head screws | Step A | 25 Nm x 13 Nm (15.5 ft-lb x 9.5 ft-lb) |
| | Step B | 180° x 1° |

Tighten M8 cylinder head screws as per following specification.



1. M8 screws
2. M8 screws

| TIGHTENING TORQUE | |
|-------------------------|---|
| M8 Cylinder head screws | 10 Nm x 1 Nm (6.5 ft-lb x 0.7 ft-lb) |

Check timing chain guide (flexible) side for movement.

VALVE SPRINGS

Removing the Valve Spring

Refer to following procedures in this subsection to remove:

- CAMSHAFT
- CYLINDER HEAD

Compress valve spring.

| REQUIRED TOOL | |
|--|---|
| VALVE SPRING COMPRESSOR (PN 529 036 234) | 1 |
| VALVE SPRING COMPRESSOR (UP (PN 529 036 270) | 1 |



1. Valve spring compressor
2. Valve spring compressor

Remove valve coilers.



1. Valve spring compressor
2. Valve spring compressor
3. Valve spring

Remove tools and withdraw valve spring retainer and valve spring.

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Wenbin Ji



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