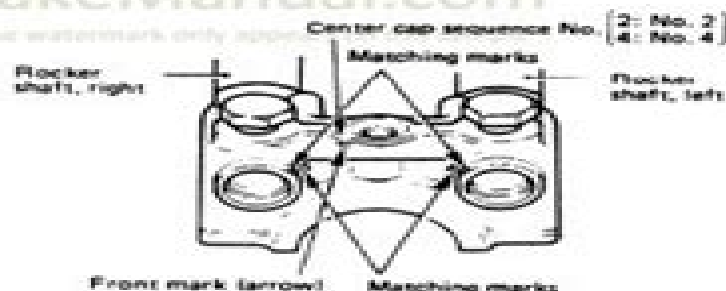


- (4) Build up the rocker shaft assemblies by putting on the parts as shown, starting with rocker shafts, followed by camshaft bearing caps, rocker springs and waved washers.

**NOTE**

No. of holes and colors will serve to correctly identify the rocker shafts and springs:

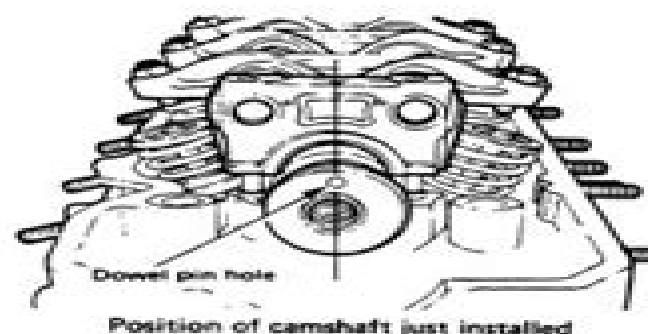
- Nos. 2 and 4 camshaft bearing caps have "2" and "4" punch-marked, respectively, on the top. No number is punch-marked on No. 3 cap.
- When fitting the rocker shaft to camshaft bearing caps, be sure to match the marks on the front end as shown.
- Install each camshaft bearing cap in place with its arrow mark on the top facing the front side.
- Position each waved washer in place with its convex side facing the rear (rocker arm) side.



Matching marks for positioning rocker shafts

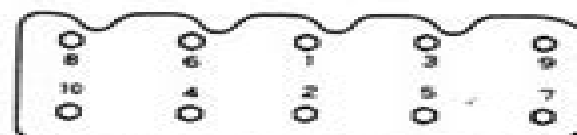
- (5) Mount the built-up rocker shaft assemblies on the cylinder head as guided by the bushing dowels. Position the camshaft in such a way that the dowel pin on its forward end locates itself straight above the camshaft axis, then insert the rocker shaft retainer and secure the retainer by tightening the nut.

Secure the bearing caps by tightening the nuts uniformly and sequentially, starting with No. 3 cap, followed by No. 2, No. 4, front and rear caps, in that order. Tighten each nut in two or three steps.



### Installation (4G33)

- Make sure that the gasket mating surfaces of the cylinder head and the block are clean and free of the old gasket debris and oil. Position the cylinder block as guided by the dowels. Gaskets are identified by markings on the upper front. A gasket stamped "33" is the one for 4G33.
- Mount the cylinder head assembly on the block. Do not slide the assembly over the gasket at this time. Secure the cylinder head assembly by tightening the bolts uniformly and sequentially, moving the wrench (special tool no. MD998001) from one bolt to another in the ascending order of numbers as shown. Be sure to tighten each bolt in three or four steps, completing each tightening by torquing the bolt to the specification.



Cylinder head bolt tightening sequence

# Manual Motor 4g52

**Karin Nielsen-Saines**



**Manual Motor 4g52:**

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