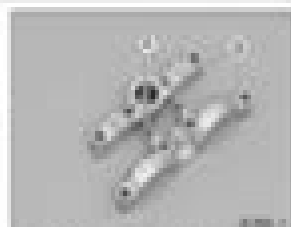


Cams/Shafts

- Apply grease to the lube ports of the oil pump (4).
- Assemble:
 - Camshaft Caps (8)
 - Oil Pipes
- While keeping the camshaft caps in parallel, install them to the cylinder head.



- Apply molybdenum disulfide oil to the threads of the camshaft cap bolts.
- Tighten all camshaft cap bolts evenly and tightly, and then tighten them with specified torque.

(Follow the numbers ① - ⑧ of tightening sequence on the camshaft cap.)

Torque - Camshaft Cap Bolts: 8.8 Nm (6.5 lbf·ft, 87 in·lb)



- Install the camshaft chain tensioner (see Camshaft Chain Tensioner Installation).
- Check the camshaft chain timing.
 - (Confirm the timing mark and punch mark align with the cylinder head upper surface.)
- If the timing mark and punch mark do not align with the cylinder head upper surface, recheck the camshafts.
 - (Turn the camshaft slowly.)
- If the camshaft does not turn smoothly, the timing is off. Repeat. Stop tuning immediately.

NOTE

The improper camshaft chain timing may damage the valves.

- Install:
 - Cylinder Head Cover (see Cylinder Head Cover Installation)
- Replace the timing inspection cap and flywheel nut cap O-rings with new ones.
- Apply grease to the O-rings.
- Tighten:

Torque - Timing Inspection Cap: 3.0 Nm (2.8 lbf·ft, 31 in·lb)

Flywheel Nut Cap: 3.0 Nm (2.8 lbf·ft, 31 in·lb)

Special Tool - Flyer Cap Driver: 570N·m (40 ft·lb)

Camshafts

Camshaft Chain Removal

- Remove:
 - Camshaft (see Camshaft Removal)
 - Flywheel (see Flywheel Removal in the Electrical System chapter)
 - Oil Pump (Overseas) Cover Bolt (4)
 - Lower Camshaft Chain Guide (2)
- Disengage the camshaft chain from the crankshaft.



Camshaft Chain Installation

- Engage the camshaft chain to the crankshaft.
- Install the lower camshaft chain guide.
- Tighten:

Torque - Oil Pump (Overseas) Cover Bolts: 8.8 Nm (6.5 lbf·ft, 87 in·lb)

- Install:
 - Flywheel (see Flywheel Installation in the Electrical System chapter)
 - Camshaft (see Camshaft Installation)

Camshaft and Camshaft Cap Wear Inspection

- Measure each clearance between the camshaft journal and camshaft cap using plastigage (crank gauge) (4).
- (Tighten the camshaft cap bolts after applying molybdenum disulfide oil to the thread of them.)

Torque - Camshaft Cap Bolts: 8.8 Nm (6.5 lbf·ft, 87 in·lb)

NOTE

- (Do not turn the camshaft when the plastigage is between the journal and camshaft cap.)



Camshaft Journal/Camshaft Cap Clearance

Standard: 0.025 - 0.050 mm (0.0010 - 0.0020 in.)

Service Limit: 0.10 mm (0.0039 in.)

- If any clearance exceeds the service limit, measure the diameter of each camshaft journal with a micrometer.

Camshaft Journal Diameter

Standard: 22.930 - 22.935 mm (0.9028 - 0.9031 in.)

Service Limit: 22.85 mm (0.9035 in.)

- If the camshaft journal diameter is less than the service limit, replace the camshaft with a new one, and measure the clearance again.
- If the clearance still exceeds out of the service limit, replace the cylinder head unit.

Kx450f Service Manual 2015 Model

Mark Coombs



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