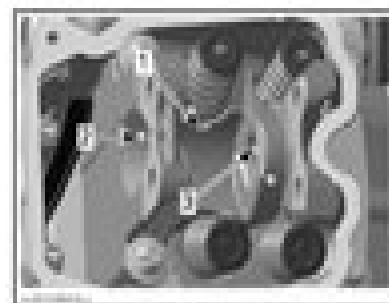


Check mating surface between cylinder and cylinder head for contamination. If so, clean both surfaces.

Clean oil support through the cylinder head from contamination.



- 1 Oil support to cylinder head camshaft bearing
- 2 Oil support to camshaft bearing cap during start up
- 3 Oil support to camshaft bearing cap during start up

Inspecting the Cylinder Head Camshaft Bearing

Measure camshaft bearing in cylinder head.



- 1 Camshaft bearing (start up side)

CAMSHAFT BEARING (TIMING CHAIN SIDE)	
Flow	35.000 mm to 35.025 mm (1.378 in to 1.379 in)
Service limit	35.045 mm (1.379 in)

CAMSHAFT BEARING (SPARK PLUG SIDE)	
Flow	33.000 mm to 33.021 mm (1.000 in to 1.017 in)
Service limit	33.045 mm (1.017 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.

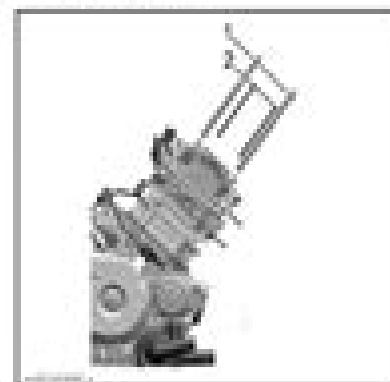


- 1 Timing chain guide (transfer into position during start up)

Install a NEW cylinder head gasket.

Install cylinder head screws.

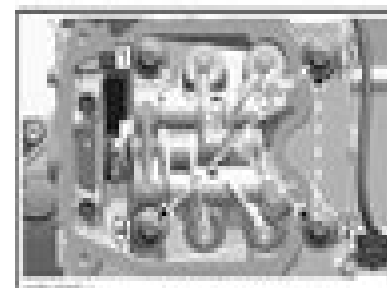
NOTICE Check for proper lengths of the cylinder head screws.



- 1 Dowel pin

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

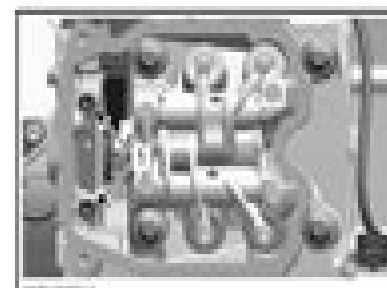
Tighten M10 cylinder head screws FIRST as per following specifications.



Tighten M8 cylinder head screws as per following specifications.

TIGHTENING TORQUE	
M10 Cylinder head screws	Step A
	20 Nm ± 1 Nm (15 lbfm ± 0.5 lbfm)
M8 Cylinder head screws	Step B
	10 Nm ± 1 Nm (8 lbfm ± 0.7 lbfm)

Tighten M8 cylinder head screws as per following specification.



- 1 M8 screws

TIGHTENING TORQUE	
M8 Cylinder head screws	10 Nm ± 1 Nm (8 lbfm ± 0.7 lbfm)

Check timing chain guide (transfer into place) 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 (transfer into place) of the valve

Remove valve coilers.



- 1 Valve spring compressor
- 2 Valve spring compressor cap
- 3 Valve spring

Remove tools and withdraw valve spring retainer and valve spring.

Manual For 2015 Commander Xt 1

**United States. Department of the
Army**



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