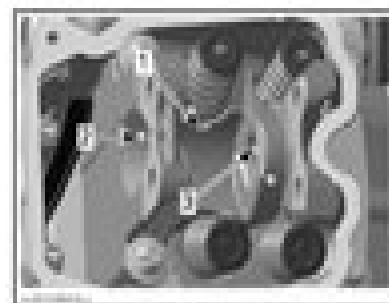


Check mating surface between cylinder and cylinder head for contamination. If so, clean both surfaces.

Clean oil support through the cylinder head from contamination.



1. Oil support to camshaft bearing cover (timing chain side)
2. Oil support to camshaft bearing cover (timing chain side)
3. Oil support to camshaft bearing cover (spark plug side)

Inspecting the Cylinder Head Camshaft Bearing

Measure camshaft bearing in cylinder head.



1. Camshaft bearing cover (spark plug side)

CAMSHAFT BEARING (TIMING CHAIN SIDE)	
Flow	35.000 mm to 35.025 mm (1.378 in to 1.3799 in)
Service limit	35.045 mm (1.3798 in)

CAMSHAFT BEARING (SPARK PLUG SIDE)	
Flow	33.900 mm to 33.925 mm (1.3347 in to 1.3374 in)
Service limit	33.945 mm (1.3377 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.

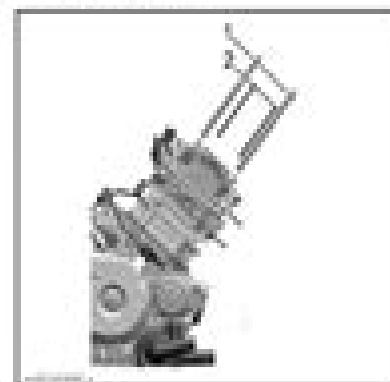


1. Timing chain guide (fixed) (ensure not mounted in position)

Install a NEW cylinder head gasket.

Install cylinder head screws.

NOTICE Check for proper lengths of the cylinder head screws.

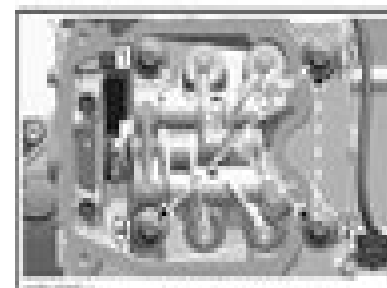


1. Timing chain guide (fixed)

CYLINDER HEAD SCREW IDENTIFICATION

LOCATION NO. 1	M10 x 130
LOCATION NO. 2	M8 x 100

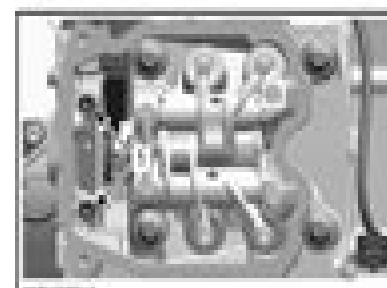
Tighten M10 cylinder head screws FIRST as per following specifications.



Tighten M8 cylinder head screws as per following specifications.

TIGHTENING TORQUE		
M10 Cylinder head screws	Step A	35 Nm ± 1 Nm (25.5 ft-lb ± 0.7 ft-lb)
	Step B	180° ± 1°

Tighten M8 cylinder head screws as per following specification.



TIGHTENING TORQUE	
M8 Cylinder head screws	10 Nm ± 1 Nm (0.73 ft-lb ± 0.74 ft-lb)

Check timing chain guide (follower) 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 IPN 529 036 234	
VALVE SPRING COMPRESSOR CUP IPN 529 036 270	



Compress valve spring (compressor IPN 529 036 234) of the valve.

Remove valve coilers.



1. Valve spring compressor
2. Valve spring compressor cup
3. Valve coiler

Remove tools and withdraw valve spring retainer and valve spring.

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