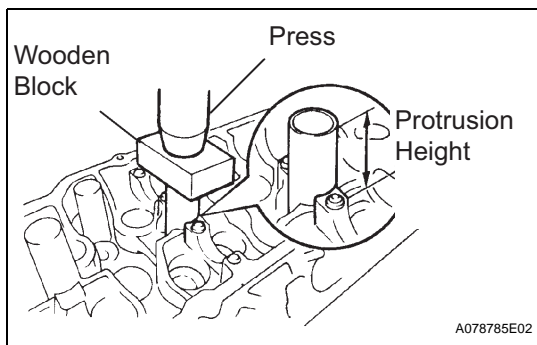
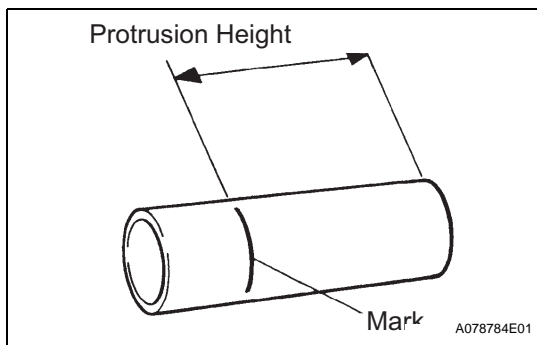
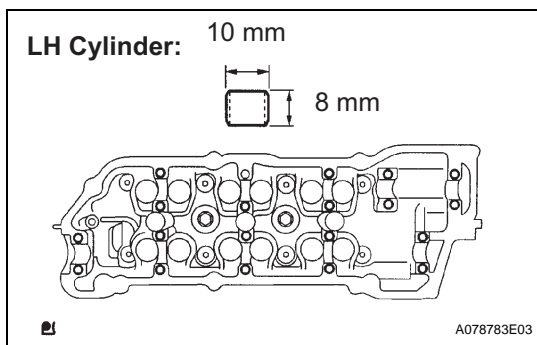
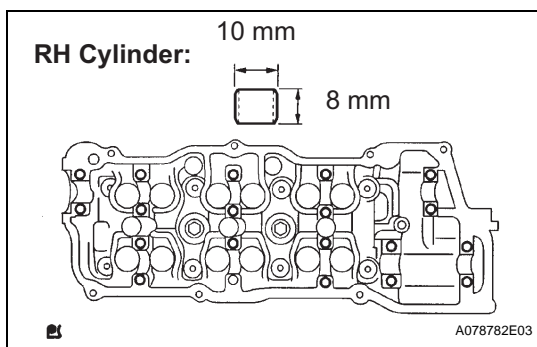


## REASSEMBLY



### 1. INSTALL RING W/HEAD PIN

- (a) Using a plastic-faced hammer, tap in a new ring pin to the specified protrusion height (RH cylinder).

**Protrusion height:**  
3 mm (0.12 in.)

### 2. INSTALL RING PIN

- (a) Using a plastic-faced hammer, tap in a new ring pin to the specified protrusion height (LH cylinder).

**Protrusion height:**  
3 mm (0.12 in.)

### 3. INSTALL SPARK PLUG TUBE

- (a) Using paint, mark the standard position from the edge.

**Standard protrusion height:**  
42.4 to 43.4 mm (1.669 to 1.709 in.)

**HINT:**

Use either end of the spark plug tube.

- (b) Apply adhesive to the spark plug tube where it will be pressed into the cylinder head.

**Adhesive:**

**Part No. 08833-00070 THREE BOND 1324 or equivalent**

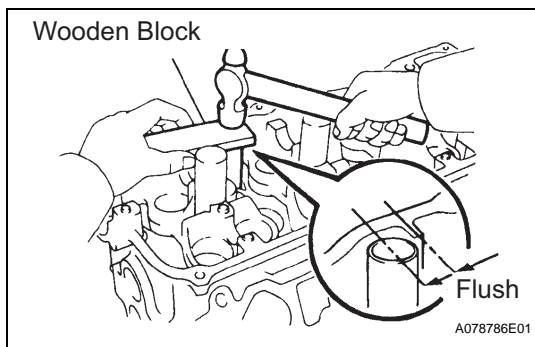
**NOTICE:**

- Install the spark plug tube within 3 minutes after applying adhesive.
- Do not deform the spark plug tube.
- Do not expose the seal to coolant within 1 hour after installing.

- (c) Using a press and wooden block, install the spark plug tube to the required protrusion height.

**NOTICE:**

**Be careful not to drip the adhesive.**

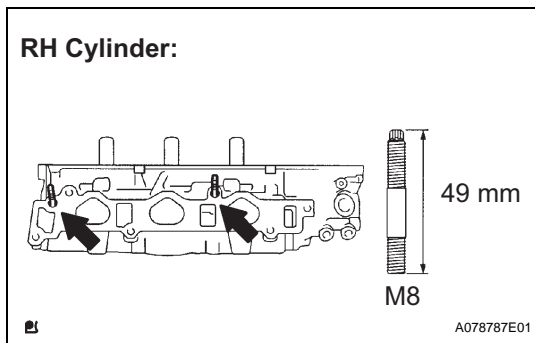


#### 4. INSTALL PCV PIPE

- (a) Using a wooden block and hammer, tap in 2 new PCV pipes until its top edge is flush with the cylinder head edge (RH cylinder).

**NOTICE:**

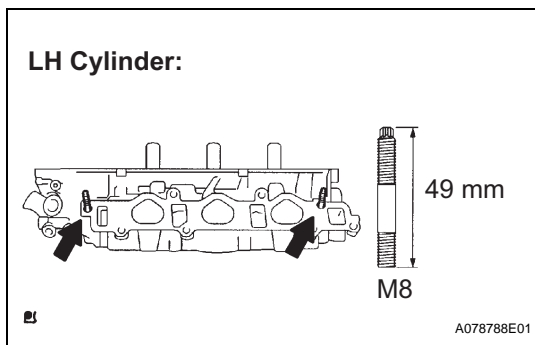
**Be careful not to damage the cylinder head edge.**



#### 5. INSTALL STUD BOLT

- (a) Install the stud bolts on the intake side (RH cylinder).

**Torque: 7.5 N\*m (76 kgf\*cm, 66 in.\*lbf)**



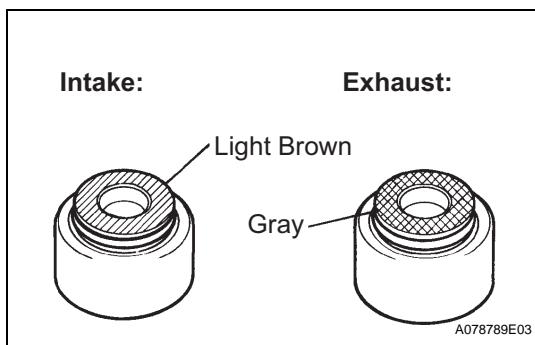
- (b) Install the stud bolts on the intake side (LH cylinder).

**Torque: 7.5 N\*m (76 kgf\*cm, 66 in.\*lbf)**

#### 6. INSTALL STUD BOLT

- (a) Install the stud bolts on the exhaust side.

**Torque: 15 N\*m (153 kgf\*cm, 11 ft.\*lbf)**



#### 7. INSTALL VALVE STEM OIL O SEAL OR RING

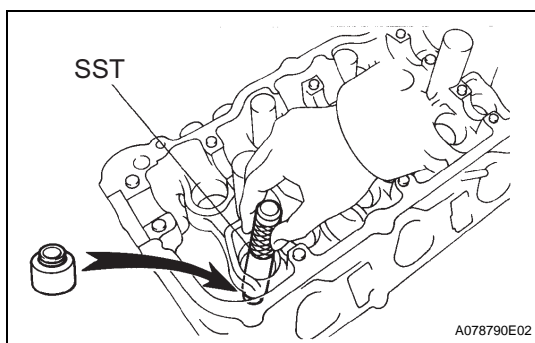
- (a) Apply a light coat of engine oil on the valve stem.

**NOTICE:**

**Pay much attention assembling the oil seal for intake and exhaust. Assembling the wrong one may cause an improper installation.**

**HINT:**

The intake valve oil seal is light brown and the exhaust valve oil seal is gray.

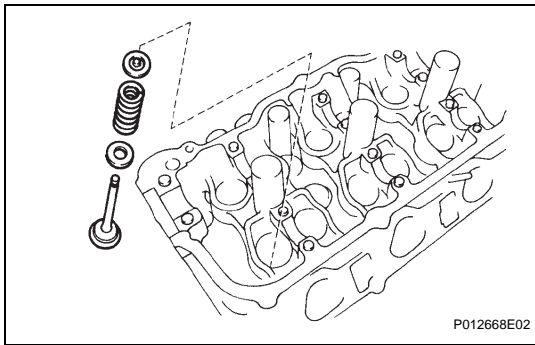


- (b) Using SST, push in a new oil seal.

**SST 09201-41020**

**NOTICE:**

**Failure to use SST will cause the seal to be damaged or improperly seated.**

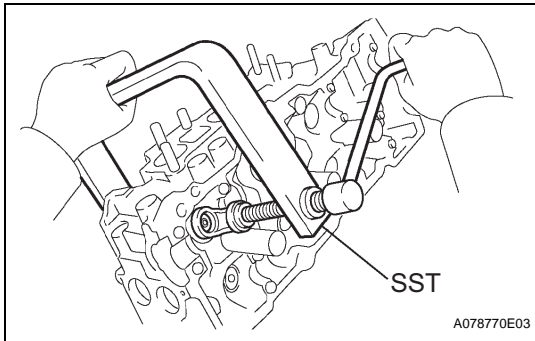


## 8. INSTALL INTAKE VALVE

- (a) Install the valve, spring seat, valve spring, and spring retainer.

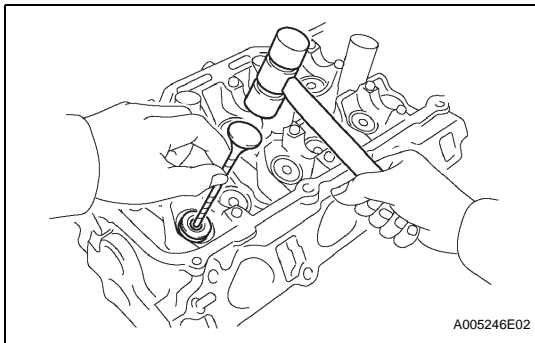
**NOTICE:**

**Install the same part in the same combination to the original locations.**



- (b) Using SST, compress the valve spring and place the 2 keepers around the valve stem.

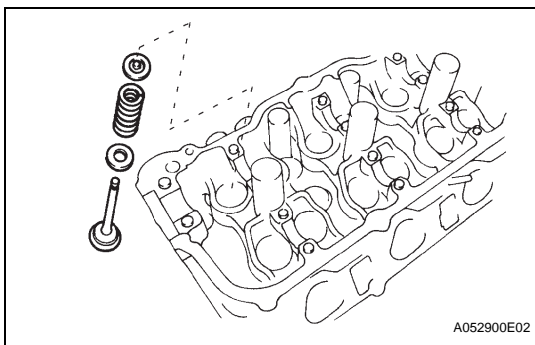
**SST 09202-70020 (09202-00010)**



- (c) Using a plastic-faced hammer and a discarded valve (the tip is wrapped with tape), lightly tap the installed valve to fit into place.

**NOTICE:**

**Be careful not to damage the installed valve stem tip.**

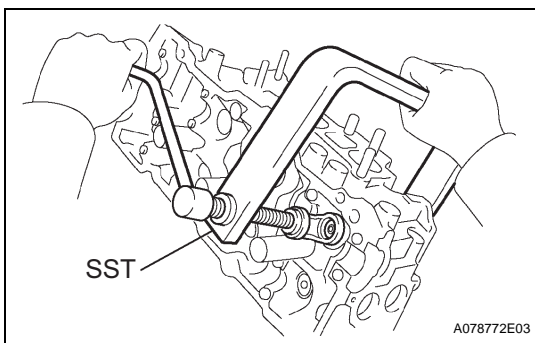


## 9. INSTALL EXHAUST VALVE

- (a) Install the valve, spring seat, valve spring, and spring retainer.

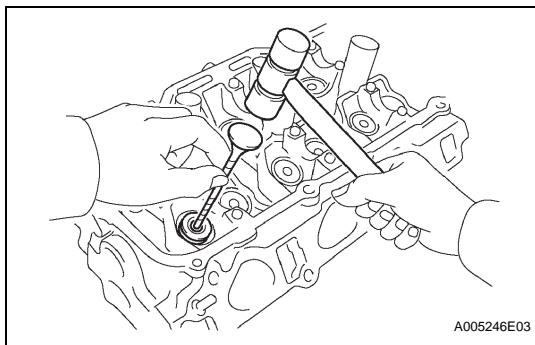
**NOTICE:**

**Install the same parts in the same combination to the original locations.**



- (b) Using SST, compress the valve spring and place the 2 keepers around the valve stem.

**SST 09202-70020 (09202-00010)**



- (c) Using a plastic-faced hammer and a discarded valve (the tip is wrapped with tape), lightly tap the installed valve to fit into place.

**NOTICE:**

**Be careful not to damage the installed valve stem tip.**

**10. INSTALL VALVE LIFTER**

- (a) Apply a light coat of engine oil on the valve lifter.

**NOTICE:**

**Install the same part in the same combination to the original locations.**

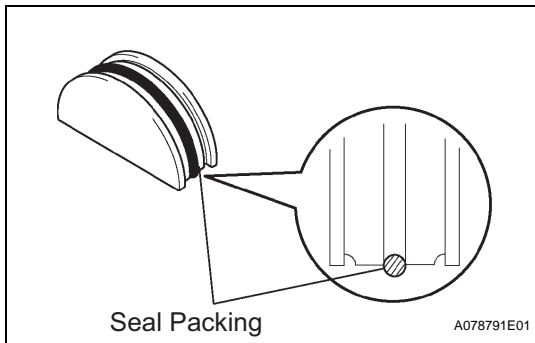
- (b) Install the valve lifter.  
 (c) Check that the valve lifter rotates smoothly by hand.

**11. INSTALL SEMICIRCULAR PLUG**

- (a) Remove any old seal packing (FIPG) material.  
 (b) Apply seal packing to the semi-circular plug grooves.

**Seal packing :**

**Part No. 08826-00080 or equivalent**



Seal Packing

A078791E01

- (c) Install the 2 semi-circular plugs to the cylinder heads.

**NOTICE:**

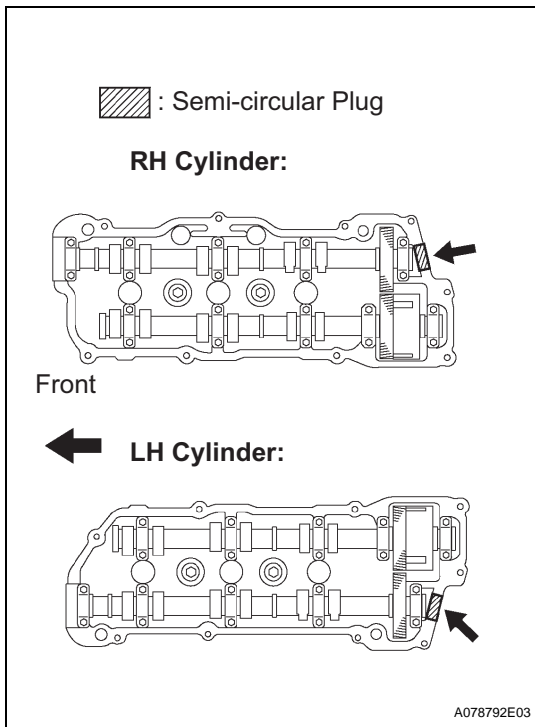
- Install the plugs so that it is flush with the top of the cylinder head.
- Install the semi-circular plugs within 3 minutes after applying seal packing.
- Do not expose the seal to engine oil within 2 hours after installing.

**12. INSTALL W/HEAD STRAIGHT SCREW PLUG NO.1**

- (a) Using a straight hexagon wrench 14, install 2 new gaskets and the 2 screw plugs (RH cylinder).  
**Torque: 44 N\*m (449 kgf\*cm, 32 ft.\*lbf)**

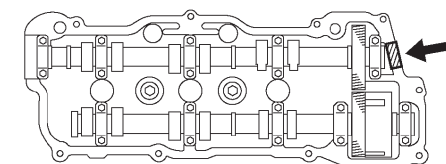
**13. INSTALL W/HEAD STRAIGHT SCREW PLUG NO.2**

- (a) Using a straight hexagon wrench 14, install 2 new gaskets and the 2 screw plugs (LH cylinder).  
**Torque: 44 N\*m (449 kgf\*cm, 32 ft.\*lbf)**



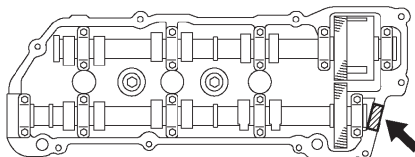
▨ : Semi-circular Plug

**RH Cylinder:**



Front

← **LH Cylinder:**



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