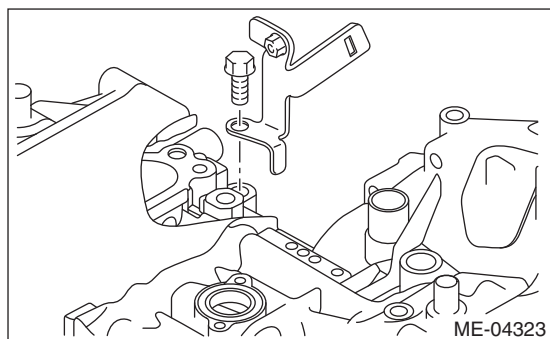


## 19. Cylinder Head

### A: REMOVAL

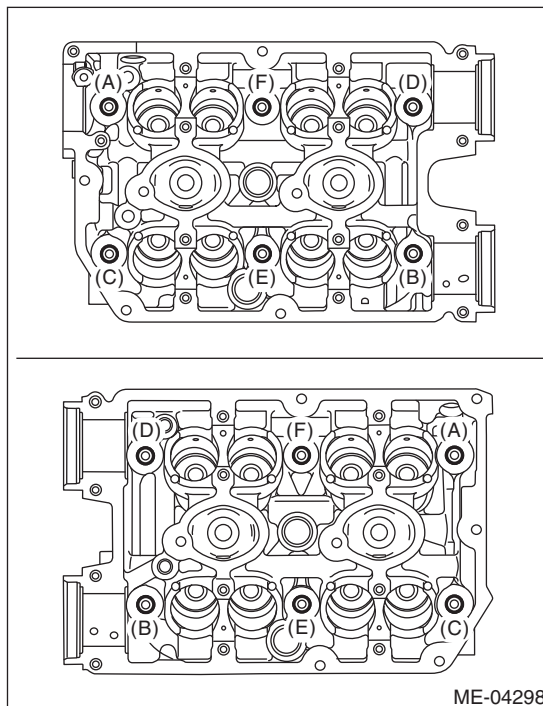
- 1) Remove the intake manifold. <Ref. to FU(H4DOTC)-17, REMOVAL, Intake Manifold.>
- 2) Remove the crank pulley. <Ref. to ME(H4DOTC)-44, REMOVAL, Crank Pulley.>
- 3) Remove the timing belt cover. <Ref. to ME(H4DOTC)-46, REMOVAL, Timing Belt Cover.>
- 4) Remove the timing belt. <Ref. to ME(H4DOTC)-51, REMOVAL, Timing Belt.>
- 5) Remove the cam sprocket. <Ref. to ME(H4DOTC)-60, REMOVAL, Cam Sprocket.>
- 6) Remove the bolt which holds A/C compressor bracket onto cylinder head. (LH side only)
- 7) Remove the oil pipe. <Ref. to LU(H4SO)-29, REMOVAL, Oil Pipe.>
- 8) Remove the clip stay.



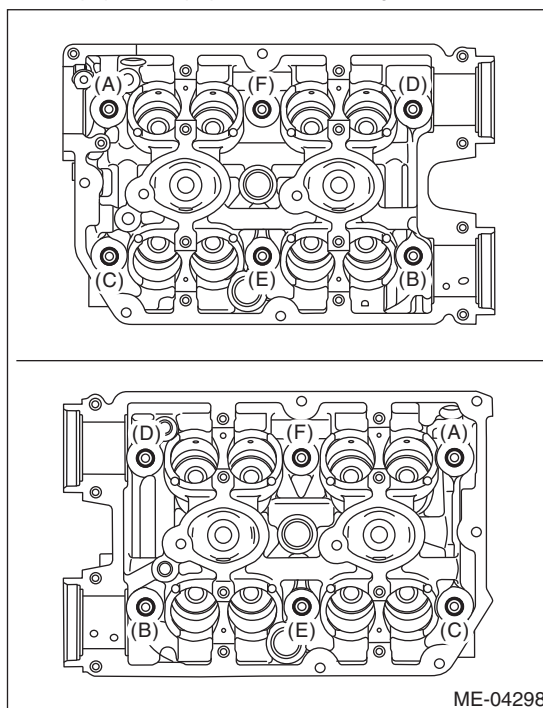
- 9) Remove the camshaft. <Ref. to ME(H4DOTC)-62, REMOVAL, Camshaft.>
- 10) Remove the oil level gauge guide. (LH side only)
- 11) Remove the cylinder head bolts in alphabetical order shown in the figure.

### NOTE:

Leave the bolts (A) and (D) engaged by three or four threads to prevent the cylinder head from falling.



- 12) While tapping the cylinder head with a plastic hammer, separate it from cylinder block. Remove the bolts (A) and (D) to remove cylinder head.



- 13) Remove the cylinder head gasket.

### CAUTION:

Be careful not to scratch the mating surface of cylinder head and cylinder block.

## B: INSTALLATION

1) Install the cylinder head and gasket on cylinder block.

### CAUTION:

**Be careful not to scratch the mating surface of cylinder head and cylinder block.**

### NOTE:

Use a new cylinder head gasket.

2) Tighten the cylinder head bolts.

(1) Apply a thin coat of engine oil to washer and bolt thread.

(2) Tighten all bolts to 29 N·m (3.0 kgf·m, 21.4 ft-lb) in alphabetical order.

(3) Tighten all bolts further to 69 N·m (7.0 kgf·m, 50.9 ft-lb) in alphabetical order.

(4) Loosen all the bolts by 180° in the reverse order of installing, and loosen them further by 180°.

(5) Tighten all bolts to 49 N·m (5.0 kgf·m, 36.1 ft-lb) in alphabetical order.

(6) Tighten all bolts by 80 to 90° in alphabetical order.

(7) Tighten all bolts further by 40 to 45° in alphabetical order.

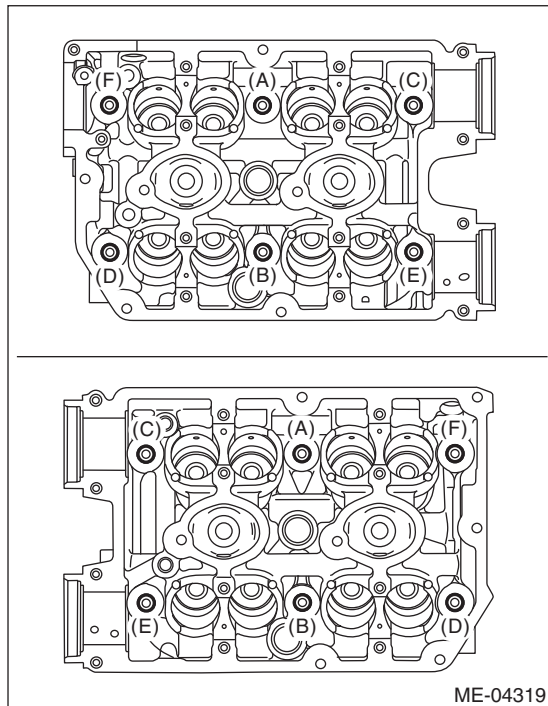
### CAUTION:

**The tightening angle of the bolt should not exceed 45°.**

(8) Tighten bolts (A) and (B) further by 40 — 45°.

### CAUTION:

**Make sure the total “re-tightening angle” of the step (7) and (8) does not exceed 90°.**



ME-04319

3) Install the oil level gauge guide. (LH side only)

### Tightening torque:

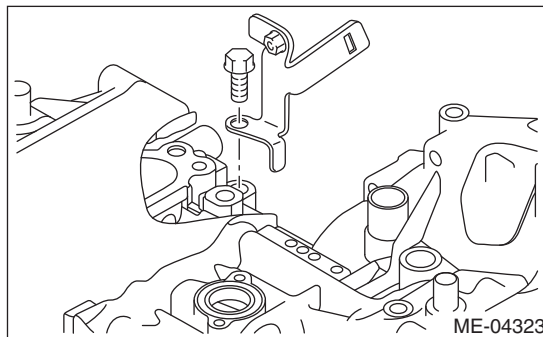
**6.4 N·m (0.7 kgf·m, 4.7 ft-lb)**

4) Install the camshaft. <Ref. to ME(H4DOTC)-65, INSTALLATION, Camshaft.>

5) Install the clip stay.

### Tightening torque:

**36 N·m (3.7 kgf·m, 26.6 ft-lb)**



6) Install the oil pipe. <Ref. to LU(H4SO)-31, INSTALLATION, Oil Pipe.>

7) Install the A/C compressor bracket on cylinder head. (LH side only)

### Tightening torque:

**36 N·m (3.7 kgf·m, 26.6 ft-lb)**

8) Install the cam sprocket. <Ref. to ME(H4DOTC)-60, INSTALLATION, Cam Sprocket.>

9) Install the timing belt. <Ref. to ME(H4DOTC)-53, INSTALLATION, Timing Belt.>

10) Adjust the valve clearance. <Ref. to ME(H4DOTC)-29, ADJUSTMENT, Valve Clearance.>

11) Install the rocker cover.

(1) Install the rocker cover gasket to the rocker cover. (Outer periphery and ignition coil section)

### NOTE:

Use a new rocker cover gasket.

(2) Apply liquid gasket to the specified point of the cylinder head.

### NOTE:

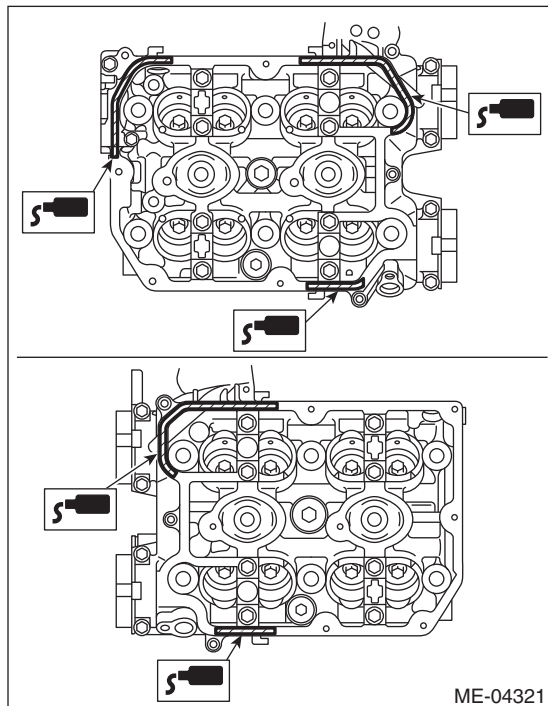
Install within 5 min. after applying liquid gasket.

# Cylinder Head

MECHANICAL

## Liquid gasket:

**THREE BOND 1217G (Part No. K0877Y0100)  
or equivalent**



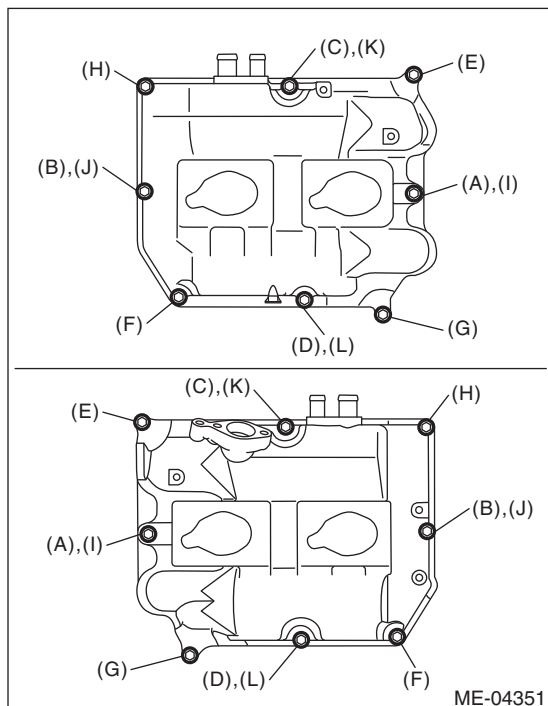
ME-04321

(3) Install the rocker cover to cylinder head. Ensure the gasket is properly positioned during installation.

(4) Temporarily tighten the rocker cover bolts in alphabetical order shown in the figure, and then tighten to specified torque in alphabetical order.

## Tightening torque:

**6.4 N·m (0.7 kgf-m, 4.7 ft-lb)**



ME-04351

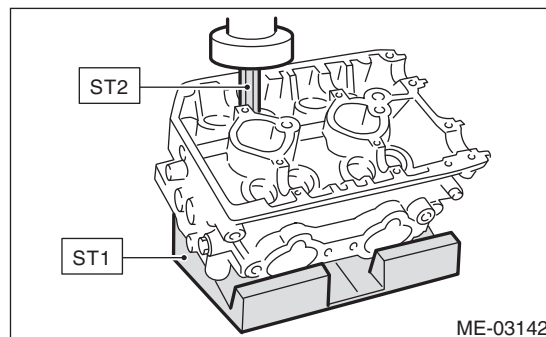
- 12) Connect the PCV hose to the rocker cover.
- 13) Install the timing belt cover. <Ref. to ME(H4DOTC)-49, INSTALLATION, Timing Belt Cover.>
- 14) Install the crank pulley. <Ref. to ME(H4DOTC)-44, INSTALLATION, Crank Pulley.>
- 15) Install the intake manifold. <Ref. to FU(H4DOTC)-21, INSTALLATION, Intake Manifold.>

## C: DISASSEMBLY

- 1) Remove the valve lifter.
- 2) Place the cylinder head on ST1.  
ST1 498267600 CYLINDER HEAD TABLE
- 3) Using ST2, compress the valve spring and remove the valve spring retainer key. Remove each valve and valve spring.  
ST2 499718000 VALVE SPRING REMOVER

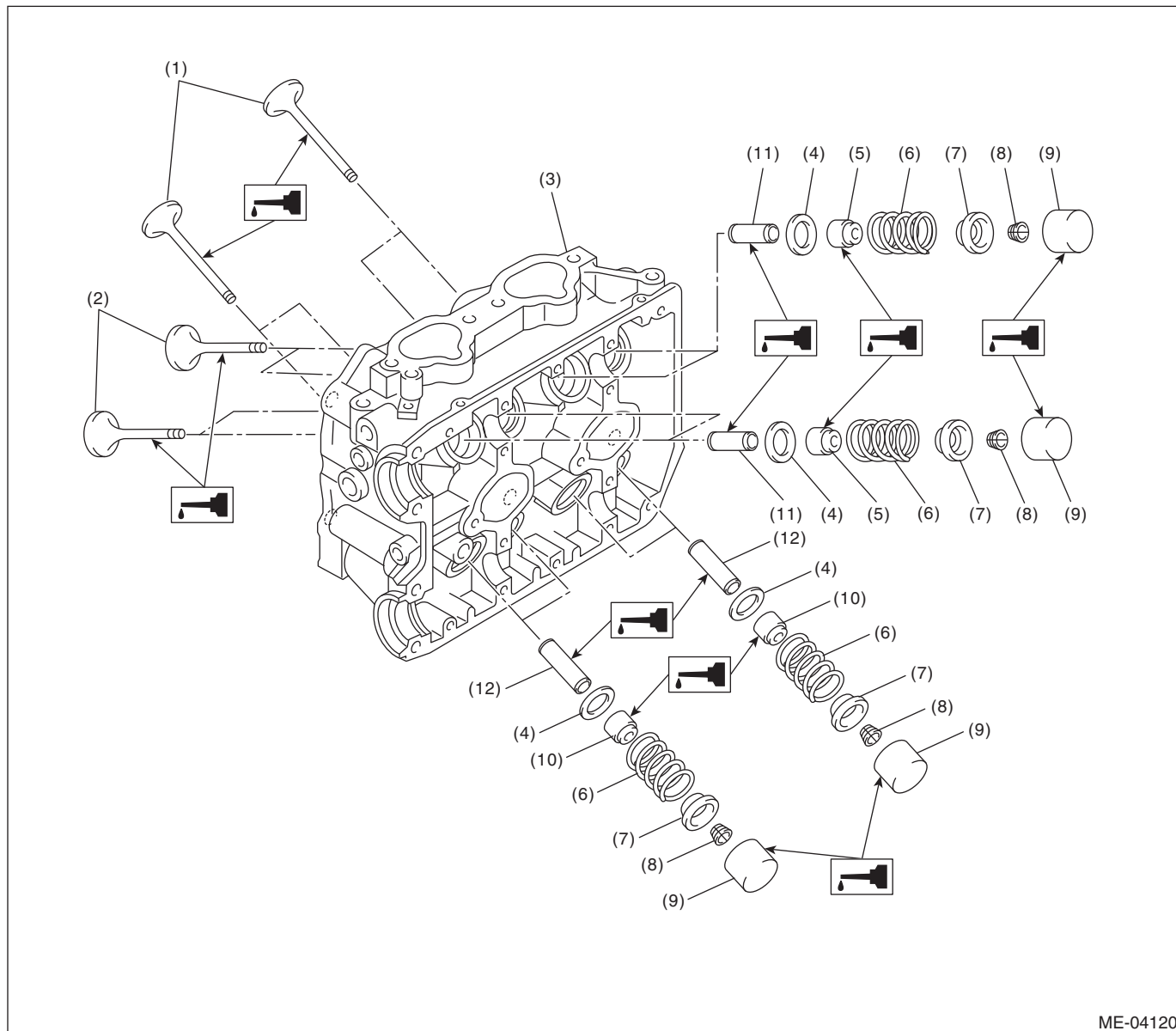
### NOTE:

- Mark each valve to prevent confusion.
- Pay careful attention not to damage the lips of intake valve oil seals and exhaust valve oil seals.
- Keep all the removed parts in order for re-installing in their original positions.
- For removal and installation procedures of the valve guide, intake valve oil seal and exhaust valve oil seal, refer to "INSPECTION". <Ref. to ME(H4DOTC)-76, VALVE GUIDE, INSPECTION, Cylinder Head.> <Ref. to ME(H4DOTC)-78, INTAKE AND EXHAUST VALVE OIL SEAL, INSPECTION, Cylinder Head.>



ME-03142

## D: ASSEMBLY



ME-04120

- |                       |                           |                             |
|-----------------------|---------------------------|-----------------------------|
| (1) Exhaust valve     | (5) Intake valve oil seal | (9) Valve lifter            |
| (2) Intake valve      | (6) Valve spring          | (10) Exhaust valve oil seal |
| (3) Cylinder head     | (7) Retainer              | (11) Intake valve guide     |
| (4) Valve spring seat | (8) Retainer key          | (12) Exhaust valve guide    |

### 1) Install the valve spring and valve.

- (1) Coat the valve stem of each valve with engine oil and insert the valve into valve guide.

#### NOTE:

When inserting the valve into valve guide, use special care not to damage the oil seal lip.

- (2) Set the cylinder head on ST1.

ST1 498267600 CYLINDER HEAD TABLE

- (3) Install the valve spring and retainer.

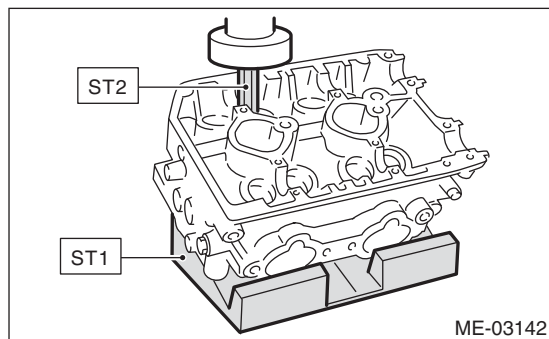
#### NOTE:

Be sure to install the valve spring with its close-coiled end facing the cylinder head.

# Cylinder Head

## MECHANICAL

- (4) Set the ST2 on valve spring.  
ST2 499718000 VALVE SPRING REMOVER



- (5) Compress the valve spring and fit the valve spring retainer key.  
(6) After installing, tap the valve spring retainers lightly with a plastic hammer for better seating.  
2) Apply oil to the surface of valve lifter.  
3) Install the valve lifter.

## E: INSPECTION

### 1. CYLINDER HEAD

- 1) Check for cracks or damage. Use liquid penetrant tester on the important sections to check for fissures. Check that there are no marks of gas leaking or water leaking on gasket installing surface.  
2) Measure the warping of the cylinder head surface that mates with cylinder block using a straight edge (A) and thickness gauge (B).  
If the warping exceeds the limit, correct the surface by grinding it with a surface grinder.

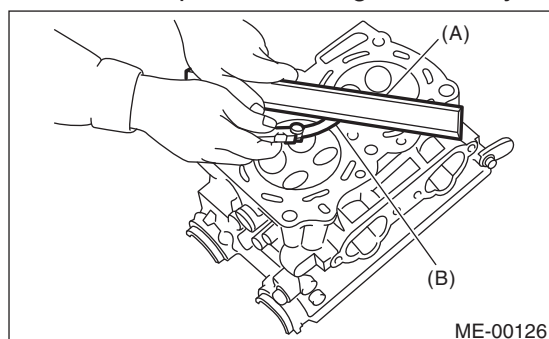
**Warping limit:**  
**0.035 mm (0.0014 in)**

**Grinding limit:**  
**0.3 mm (0.012 in)**

**Standard height of cylinder head:**  
**127.5 mm (5.02 in)**

#### NOTE:

Uneven torque for the cylinder head bolts can cause warping. When reinstalling, pay special attention to the torque so as to tighten evenly.



### 2. VALVE SEAT

Inspect the intake and exhaust valve seats, and correct the contact surfaces with a valve seat cutter if they are defective or when valve guides are replaced.

**Contacting width of valve and valve seat *W*:**

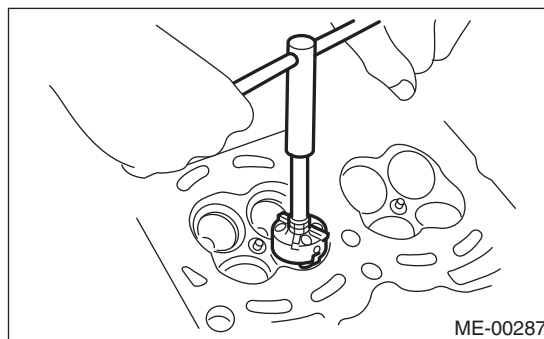
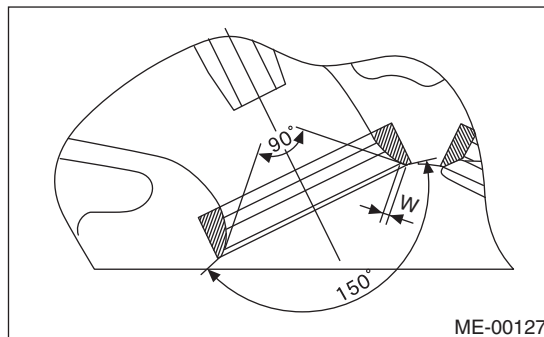
#### Standard

##### Intake

**0.6 — 1.4 mm (0.024 — 0.055 in)**

##### Exhaust

**1.2 — 1.8 mm (0.047 — 0.071 in)**



### 3. VALVE GUIDE

- 1) Check the clearance between valve guide and valve stem. The clearance can be checked by measuring respectively the outer diameter of valve stem with a micrometer and the inner diameter of valve guide with a caliper gauge.

**Clearance between the valve guide and valve stem:**

#### Standard

##### Intake

**0.030 — 0.057 mm (0.0012 — 0.0022 in)**

##### Exhaust

**0.040 — 0.067 mm (0.0016 — 0.0026 in)**

- 2) If the clearance between valve guide and valve stem exceeds the standard, replace the valve guide or valve itself, whichever shows the greater amount of wear or damage. See the following procedure for valve guide replacement.

**Valve guide inner diameter:**

**6.000 — 6.012 mm (0.2362 — 0.2367 in)**



## Valve stem outer diameters:

### Intake

5.955 — 5.970 mm (0.2344 — 0.2350 in)

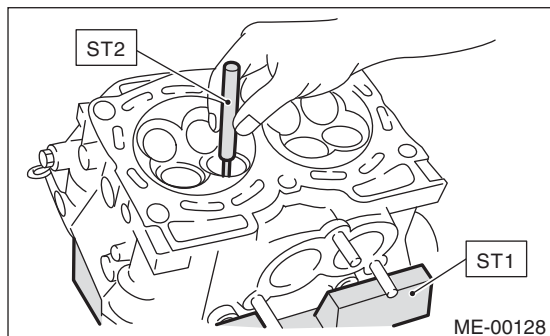
### Exhaust

5.945 — 5.960 mm (0.2341 — 0.2346 in)

(1) Place the cylinder head on ST1 with the combustion chamber upward so that valve guides fit the holes in ST1.

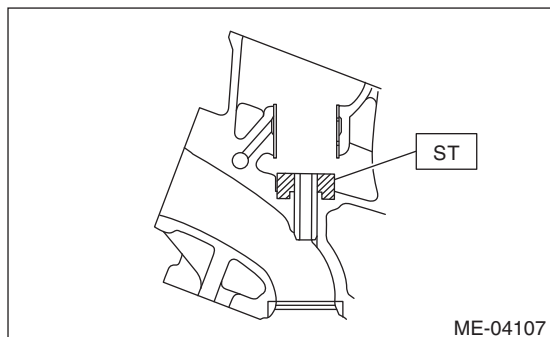
(2) Insert the ST2 into valve guide and press it down to remove the valve guide.

ST1 498267600 CYLINDER HEAD TABLE  
ST2 499767200 VALVE GUIDE REMOVER



(3) Turn the cylinder head upside down and place the ST as shown in the figure.

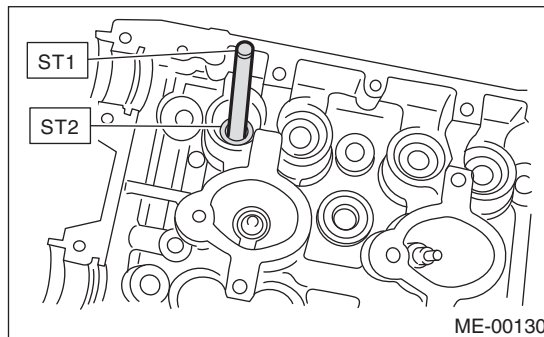
ST 18251AA020 VALVE GUIDE ADJUSTER



(4) Before installing a new valve guide, make sure that neither scratches nor damages exist on the inner surface of valve guide holes in cylinder head.

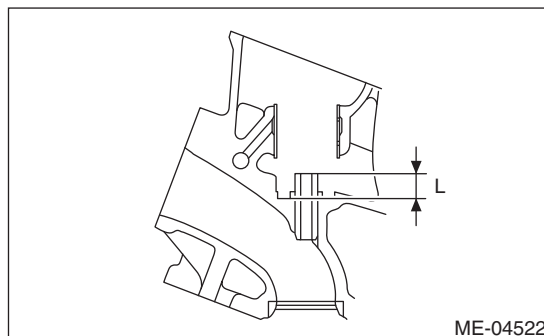
(5) Coat a new valve guide with sufficient oil, put it into the cylinder head, and insert the ST1 into the valve guide. Press in until the valve guide upper end is flush with the upper surface of ST2.

ST1 499767200 VALVE GUIDE REMOVER  
ST2 18251AA020 VALVE GUIDE ADJUSTER



(6) Check the valve guide protrusion amount "L".

**Valve guide protrusion amount L:**  
15.8 — 16.2 mm (0.622 — 0.638 in)



(7) Ream the inside of valve guide using ST. Put the ST in valve guide, and rotate the ST slowly clockwise while pushing it lightly. Bring the ST back while rotating it clockwise.

### NOTE:

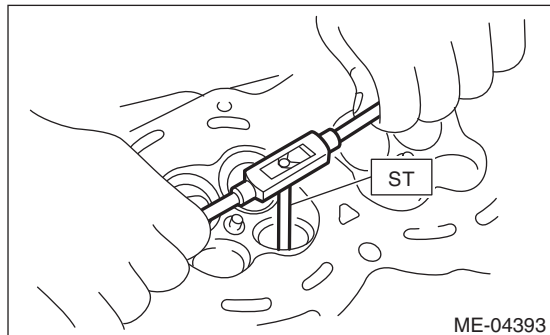
- Apply engine oil to the ST when reaming.
- If the inner surface of valve guide is damaged, the edge of ST should be slightly ground with oil stone.

# Cylinder Head

## MECHANICAL

- If the inner surface of valve guide becomes lustrous and the ST does not chip, use a new ST or remedy the ST.

ST 499767400 VALVE GUIDE REAMER



(8) After reaming, clean the valve guide to remove chips.

(9) Recheck the contact condition between valve and valve seat after replacing the valve guide.

## 4. INTAKE AND EXHAUST VALVE

1) Inspect the flange and valve stem of valve, and replace the valve with a new part if damaged, worn, deformed, or if dimension "H" in the figure is outside of the specified limit.

**Head edge thickness H:**

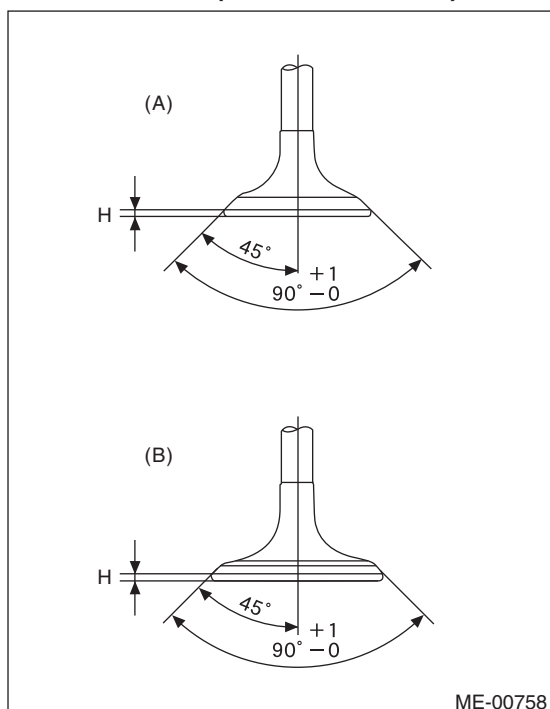
**Standard**

**Intake (A)**

**1.0 — 1.4 mm (0.039 — 0.055 in)**

**Exhaust (B)**

**1.3 — 1.7 mm (0.051 — 0.067 in)**



2) Put a small amount of grinding compound on the valve seat surface, and lap the valve and valve seat surface. Replace with a new valve oil seal after lapping.

**NOTE:**

It is possible to differentiate between the intake valve and the exhaust valve by their overall length.

**Valve overall length:**

**Intake**

**104.4 mm (4.110 in)**

**Exhaust**

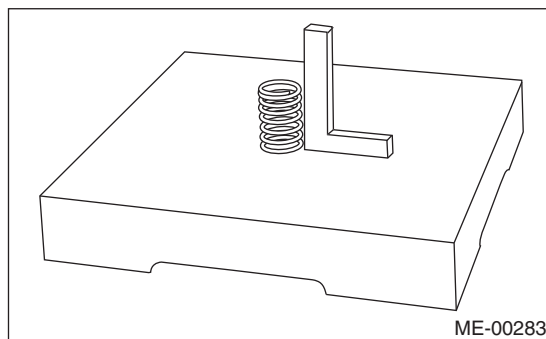
**104.65 mm (4.1201 in)**

## 5. VALVE SPRING

1) Check the valve springs for damage, free length, and tension. Replace the valve spring if it is not within the standard value presented in the table.

2) To measure the squareness of the valve spring, stand the valve spring on a surface plate and measure its deflection at the top of valve spring using a right angle gauge.

Free length	mm (in)	47.32 (1.863)
Tension/spring height N (kgf, lbf)/mm (in)	Set	205 — 235 (20.90 — 23.96, 46.09 — 52.84)/36.0 (1.417)
	Lift	426 — 490 (43.44 — 49.96, 95.78 — 110.17) /26.5 (1.043)
Squareness		2.5°, 2.1 mm (0.083 in) or less



## 6. INTAKE AND EXHAUST VALVE OIL SEAL

1) For the following, replace the oil seal with a new part. See the procedure 2) and subsequent for replacement procedures.

- When the lip is damaged.
- When the spring is out of the specified position.
- When readjusting the surfaces of valve and valve seat.
- When replacing the valve guide.

2) Place the cylinder head on ST1, and use ST2 to press-fit the oil seal.

ST1 498267600 CYLINDER HEAD TABLE

ST2 498857100 VALVE OIL SEAL GUIDE

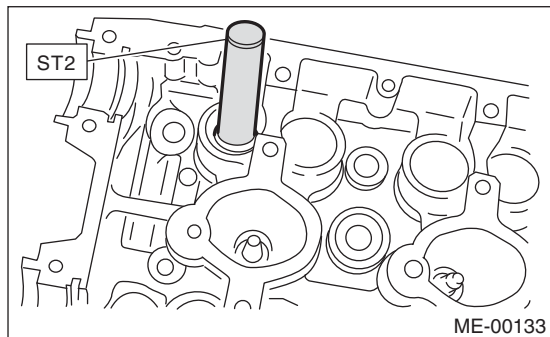
**NOTE:**

- Apply engine oil to oil seal before press-fitting.
- When press-fitting the oil seal, do not use a hammer or strike in.
- The intake valve oil seals and exhaust valve oil seals are distinguished by their colors.

**Color of rubber part:**

**Intake [Gray]**

**Exhaust [Green]**



- 4) Check the clearance between valve lifter and valve lifter mating surface. The clearance can be determined from the measured value of the valve lifter outer diameter and valve lifter mating surface inner diameter. If it is not within the standard or there is uneven wear in the inner surface, replace the cylinder head.

**Clearance between valve lifter and valve lifter mating surface:**

**Standard**

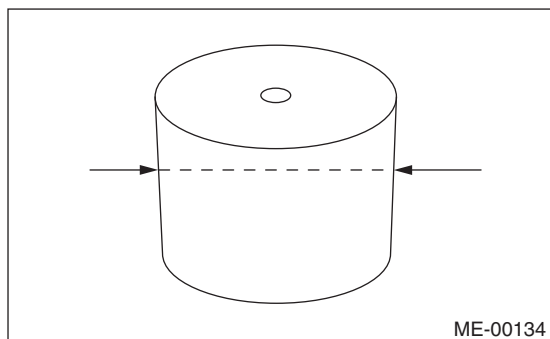
**0.019 — 0.057 mm (0.0007 — 0.0022 in)**

## 7. VALVE LIFTER

- 1) Perform visual check on the valve lifter.
- 2) Measure the valve lifter outer diameter.

**Outer diameter of valve lifter:**

**34.959 — 34.975 mm (1.3763 — 1.3770 in)**



- 3) Measure the inner diameter of valve lifter mating surface on cylinder head.

**Inner diameter of valve lifter mating surface:**

**34.994 — 35.016 mm (1.3777 — 1.3786 in)**

