

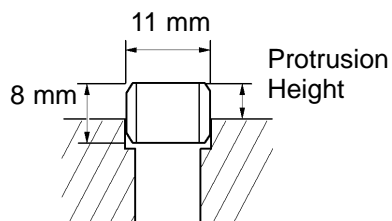
REASSEMBLY

1. INSTALL RING PIN

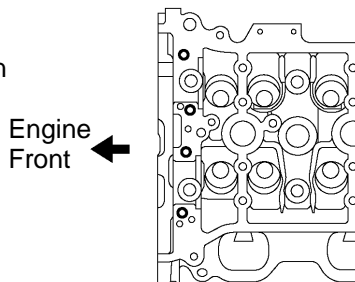
Using a plastic-faced hammer, tap in the new ring pins until they reach the specified protrusion height.

Specified protrusion height:

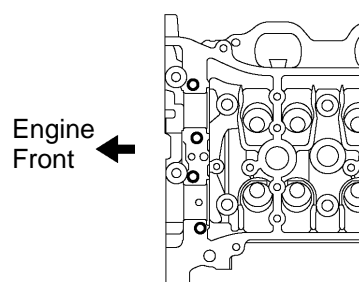
2.7 to 3.3 mm (0.106 to 0.130 in.)



Cylinder Head RH Side:



Cylinder Head LH Side:



2. INSTALL STRAIGHT PIN

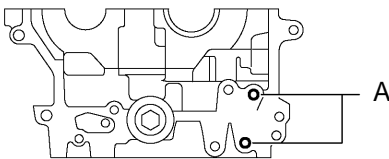
Using a plastic-faced hammer, tap in the new straight pins until they reach the specified protrusion height.

Specified protrusion height:

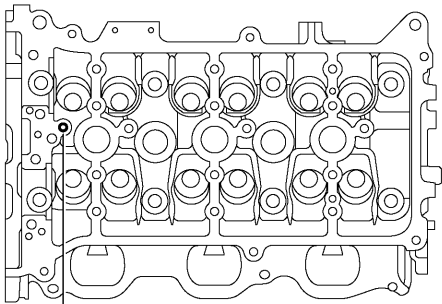
A	17.5 to 19.5 mm (0.689 to 0.768 in.)
B	7.5 to 8.5 mm (0.295 to 0.335 in.)
C	7.0 to 9.0 mm (0.276 to 0.354 in.)

Cylinder Head RH Side:

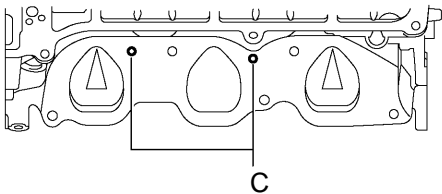
Front Side:



Upper Side:

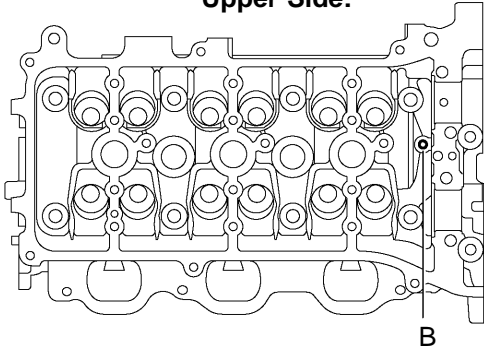


Intake Manifold Side:

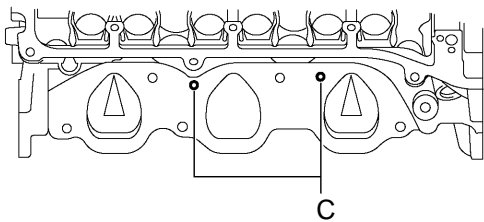


Cylinder Head LH Side:

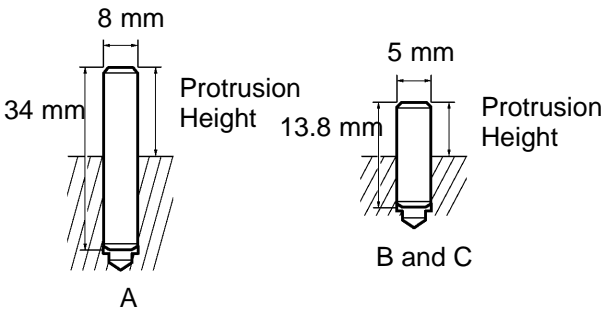
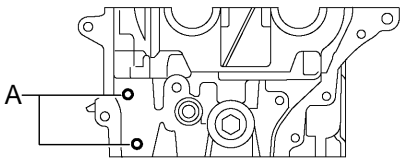
Upper Side:



Intake Manifold Side:



Front Side:



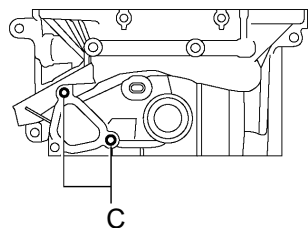
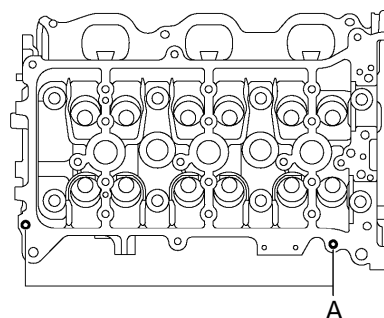
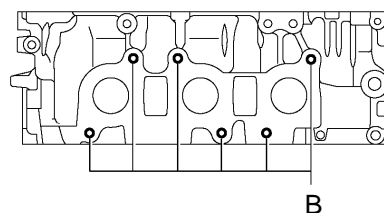
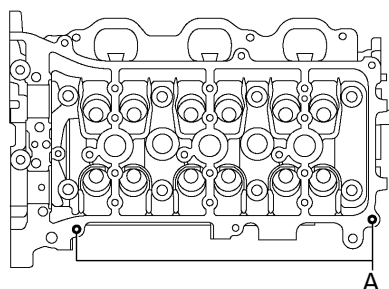
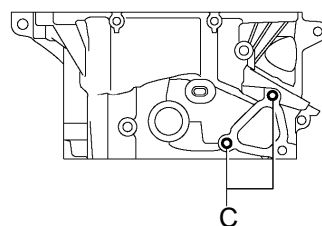
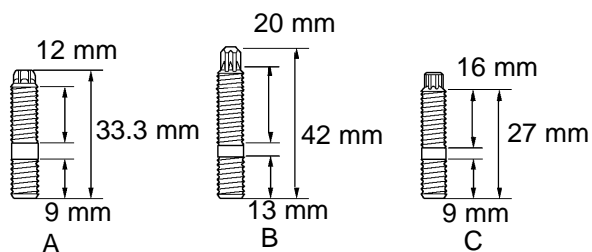
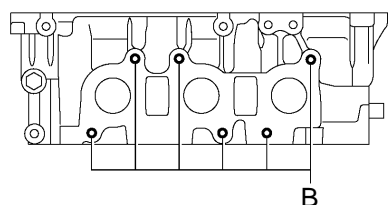
3. INSTALL STUD BOLT

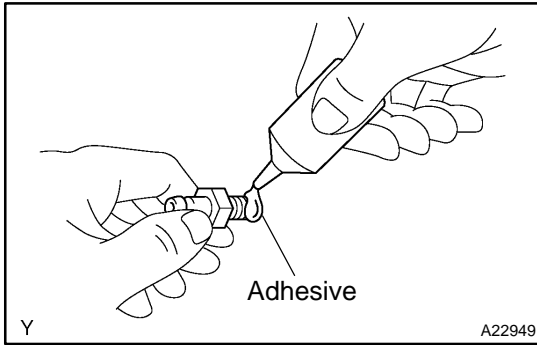
Using the Torx® socket wrench E5 and E7, install the stud bolts.

Torque:

4.0 N·m (41 kgf·cm, 35 in·lbf) for stud bolt A, C

19.5 N·m (199 kgf·cm, 14 ft·lbf) for stud bolt B

Cylinder Head RH Side:**Rear Side:****Upper Side:****Exhaust Manifold Side:****Cylinder Head LH Side:****Upper Side:****Rear Side:****Exhaust Manifold Side:**



4. INSTALL UNION

- (a) Apply adhesive to 2 or 3 threads of the bolt end.

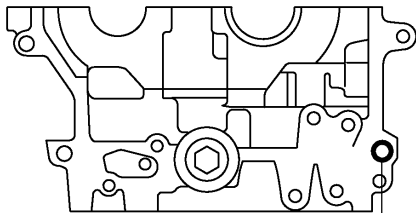
Adhesive:

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

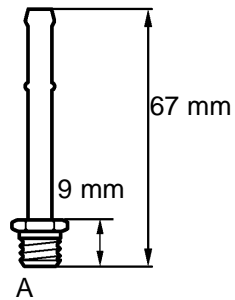
- (b) Using a deep socket wrench 12, install the unions.

Torque: 15 N·m (153 kgf·cm, 11 ft·lbf)

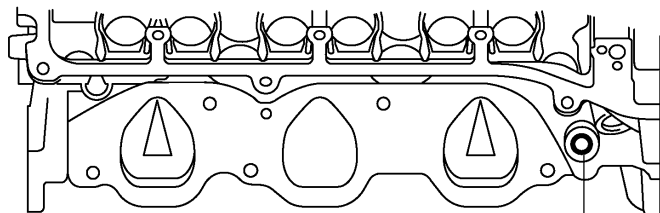
Cylinder Head RH (Front) Side:



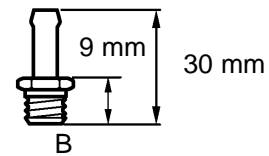
A



Cylinder Head LH (Intake Manifold) Side:

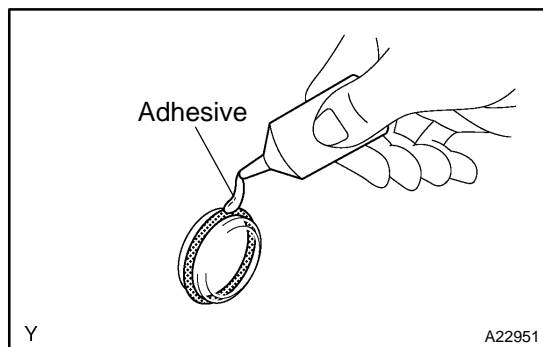


B



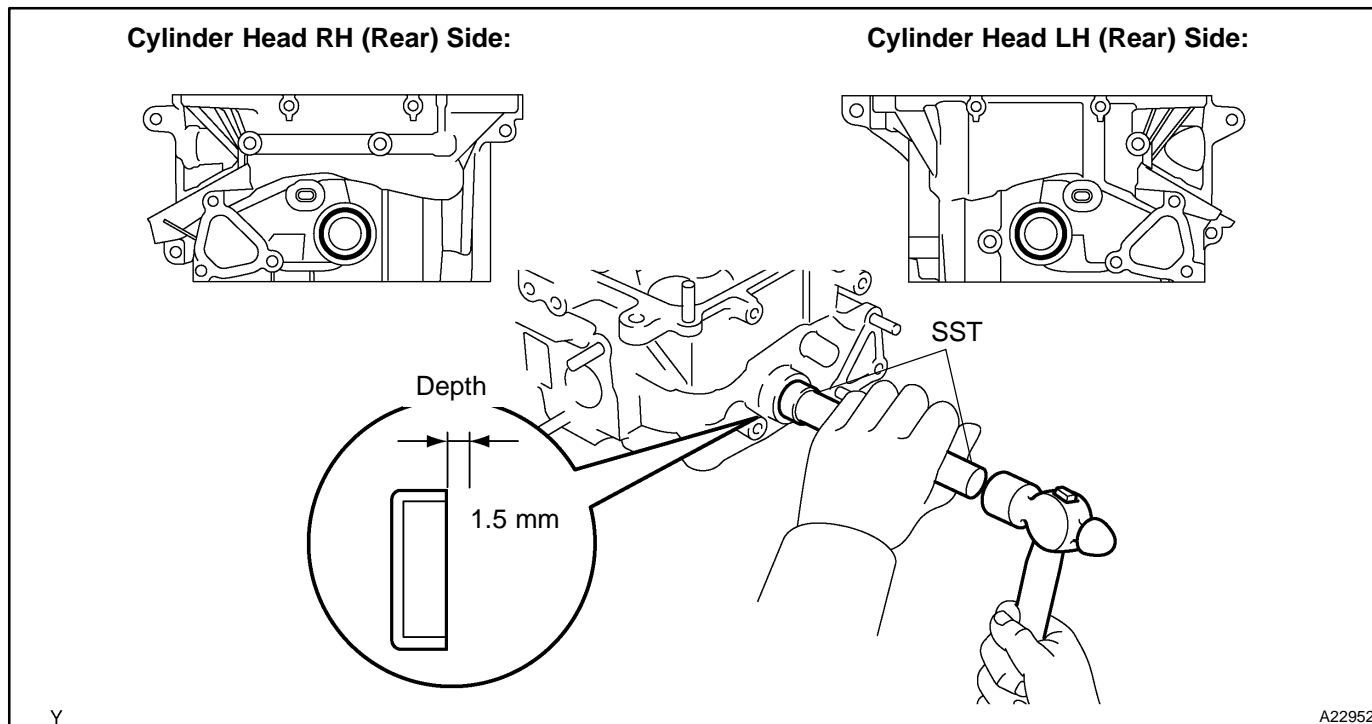
Y

A22950

**5. INSTALL TIGHT PLUG**

- (a) Apply adhesive around the tight plugs.
- (b) Using SST, tap in the tight plugs to the specified depth.
SST 09950-60010 (09951-00250), 09950-70010 (09951-07150)

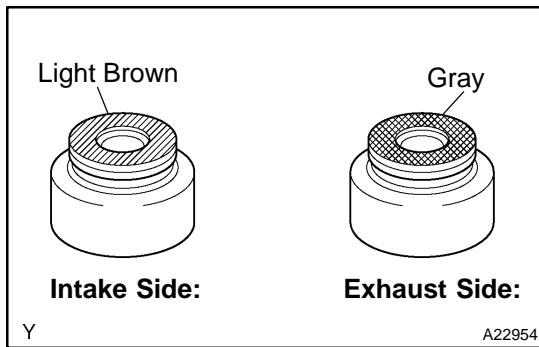
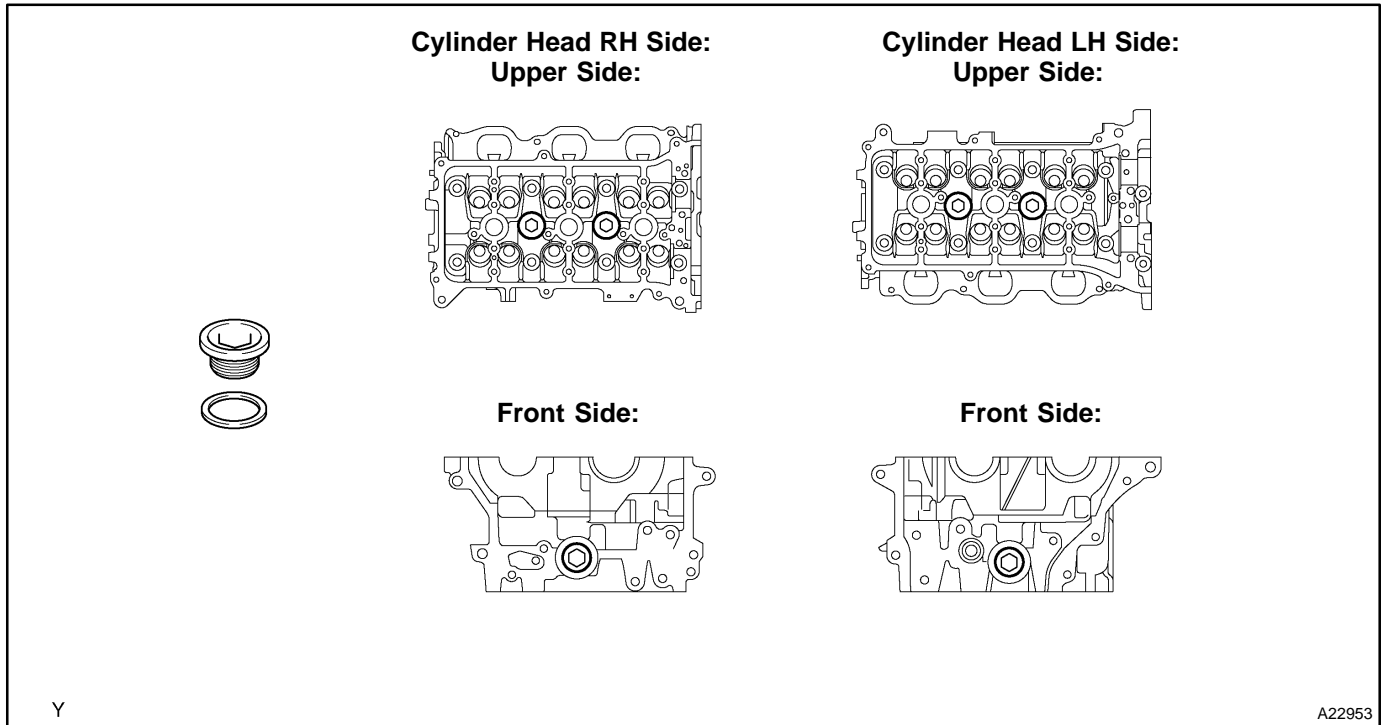
Specified depth: 1.5 mm (0.059 in.)



6. INSTALL STRAIGHT SCREW PLUG

- (a) Using a straight hexagon wrench 14, install a new gasket and straight screw plug.

Torque: 80 N·m (816 kgf·cm, 59 ft·lbf)

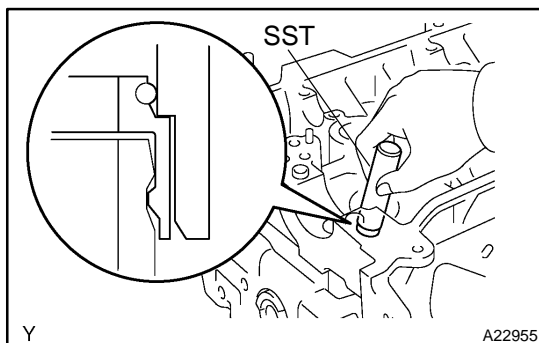


7. INSTALL VALVE STEM OIL SEAL

HINT:

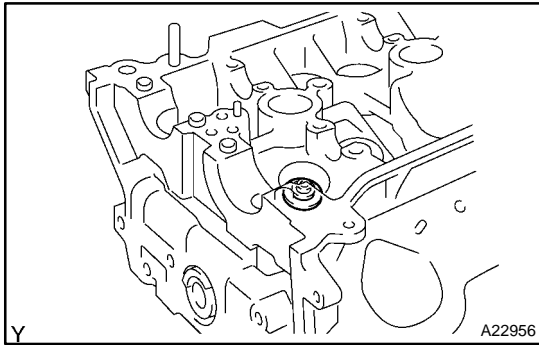
The intake valve stem oil seal is light brown and the exhaust valve stem oil seal is gray.

- (a) Apply a light coat of engine oil to the valve guide bush.

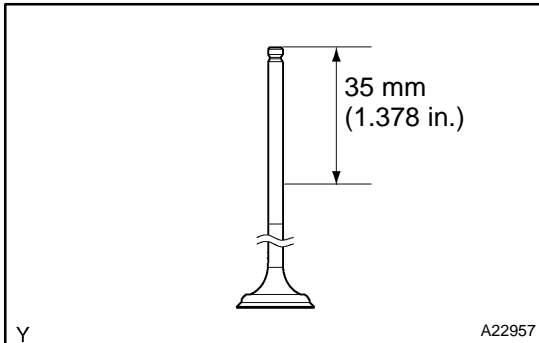


- (b) Using SST, push in a new valve stem oil seal.

SST 09201-41020

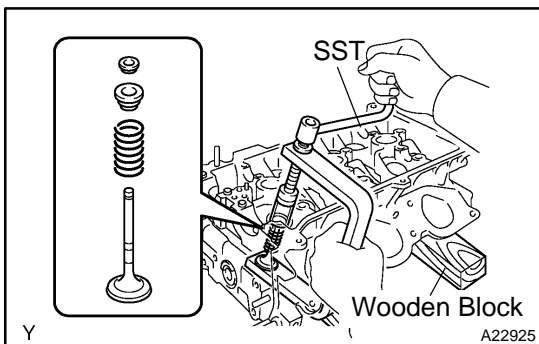


8. INSTALL VALVE SPRING SEAT



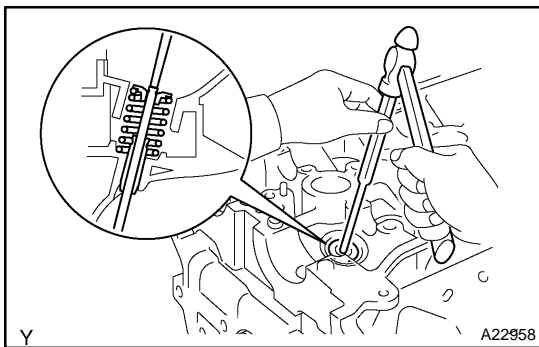
9. INSTALL VALVE

- (a) Apply engine oil to the valve as shown in the illustration.



- (b) Place the cylinder head on a wooden block.
 (c) Install the valve, inner compression spring and valve spring retainer.
 (d) Using SST, compress the inner compression spring and place the 2 valve spring retainer locks around the valve stem.

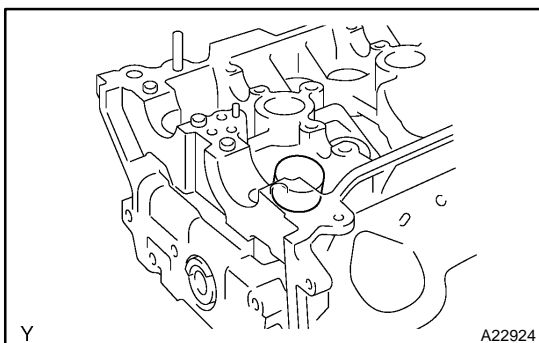
SST 09202-70020 (09202-00010)



- (e) Using a pin punch 5, lightly tap the valve stem tip to ensure a proper fit.

NOTICE:

Be careful not to damage the valve stem tip.



10. INSTALL VALVE LIFTER

- (a) Apply engine oil to the valve stem end and valve lifter, and install the valve lifter to the valve stem.
 (b) Check that the valve lifter rotates smoothly by hand.