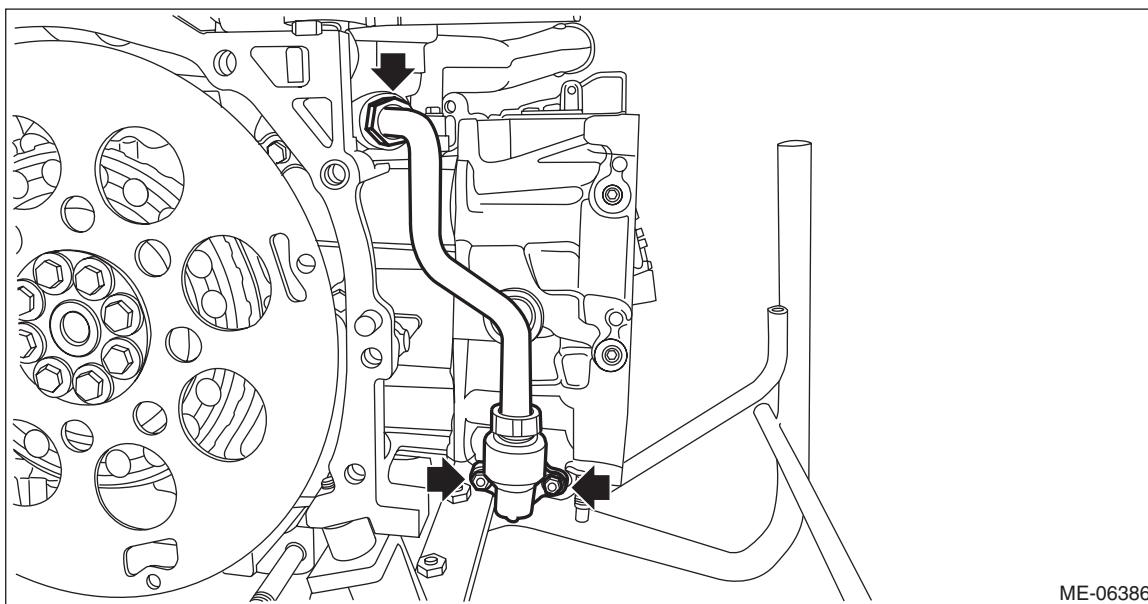


## 21. Cylinder Head

### A: REMOVAL

#### 1. CYLINDER HEAD RH

- 1) Remove the engine from the vehicle. <Ref. to ME(H4DO)-46, REMOVAL, Engine Assembly.>
- 2) Remove the intake manifold. <Ref. to FU(H4DO)-23, REMOVAL, Intake Manifold.>
- 3) Remove the tumble generator valve assembly RH. <Ref. to FU(H4DO)-81, REMOVAL, Tumble Generator Valve Assembly.>
- 4) Remove the chain cover. <Ref. to ME(H4DO)-95, REMOVAL, Chain Cover.>
- 5) Remove the rocker cover RH. <Ref. to ME(H4DO)-139, ROCKER COVER RH, REMOVAL, Rocker Cover.>
- 6) Remove the cam carrier RH. <Ref. to ME(H4DO)-153, CAM CARRIER RH, REMOVAL, Cam Carrier.>
- 7) Remove the EGR pipe assembly from the water pipe assembly and the cylinder block RH.



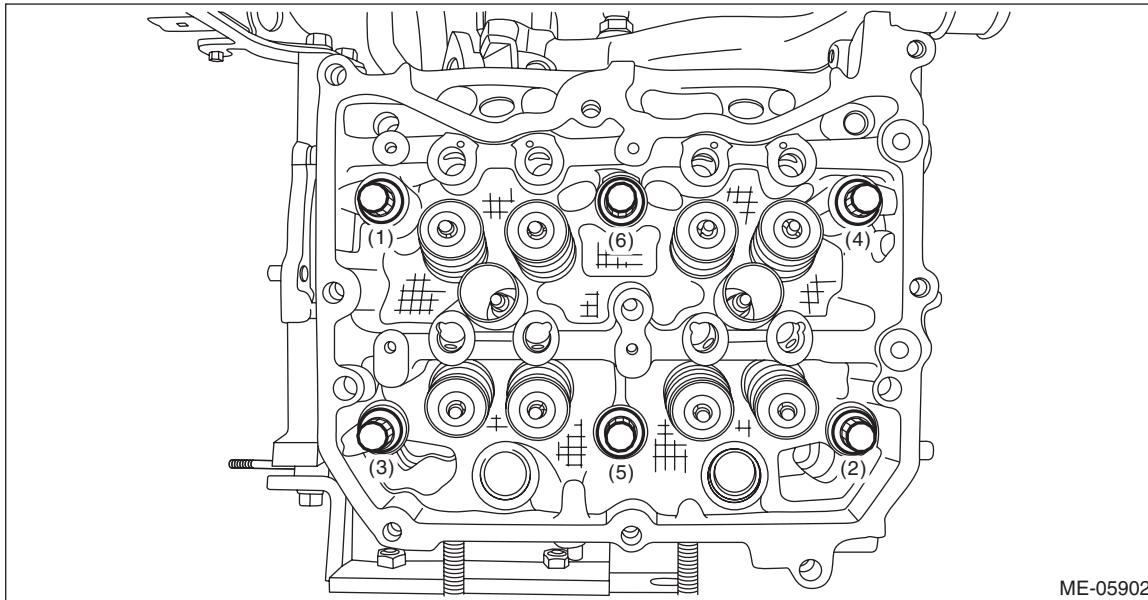
# Cylinder Head

## MECHANICAL

8) Loosen the bolts holding the cylinder head RH equally, a little at a time in numerical sequence as shown in the figure, and while leaving the cylinder head bolts (1) and (4) engaged by three or four threads, remove the other cylinder head bolts.

**NOTE:**

Leaving the cylinder head bolts (1) and (4) engaged by three or four threads prevents the cylinder head RH from falling.



9) While tapping the cylinder head RH with a plastic hammer, separate it from cylinder block RH.

10) Remove the bolts (1) and (4) to remove cylinder head RH.

11) Remove the cylinder head gasket RH.

**CAUTION:**

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

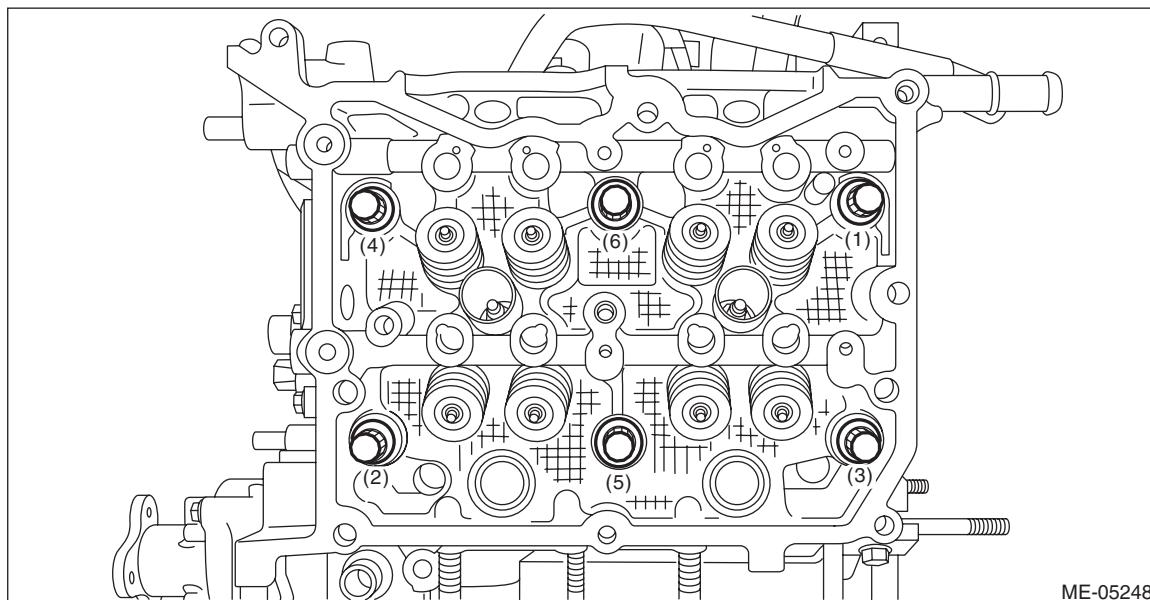
12) Remove the liquid gasket from cylinder head RH and cam carrier RH.

## 2. CYLINDER HEAD LH

- 1) Remove the engine from the vehicle. <Ref. to ME(H4DO)-46, REMOVAL, Engine Assembly.>
- 2) Remove the intake manifold. <Ref. to FU(H4DO)-23, REMOVAL, Intake Manifold.>
- 3) Remove the tumble generator valve assembly LH. <Ref. to FU(H4DO)-81, REMOVAL, Tumble Generator Valve Assembly.>
- 4) Remove the chain cover. <Ref. to ME(H4DO)-95, REMOVAL, Chain Cover.>
- 5) Remove the rocker cover LH. <Ref. to ME(H4DO)-142, ROCKER COVER LH, REMOVAL, Rocker Cover.>
- 6) Remove the cam carrier LH. <Ref. to ME(H4DO)-158, CAM CARRIER LH, REMOVAL, Cam Carrier.>
- 7) Remove the A/C compressor. <Ref. to AC-57, REMOVAL, Compressor.>
- 8) Loosen the bolts holding the cylinder head LH equally, a little at a time in numerical sequence as shown in the figure, and while leaving the cylinder head bolts (1) and (4) engaged by three or four threads, remove the other cylinder head bolts.

**NOTE:**

Leaving the cylinder head bolts (1) and (4) engaged by three or four threads prevents the cylinder head LH from falling.



- 9) While tapping the cylinder head LH with a plastic hammer, separate it from cylinder block LH.
- 10) Remove the cylinder head bolts (1) and (4) to remove cylinder head LH.
- 11) Remove the cylinder head gasket LH.

**CAUTION:**

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

- 12) Remove the liquid gasket from cylinder head LH and cam carrier LH.

## B: INSTALLATION

### 1. CYLINDER HEAD RH

1) Clean the bolt holes in the cylinder block RH.

**CAUTION:**

**To avoid erroneous tightening of the bolts, clean out the bolt holes sufficiently by blowing with compressed air to eliminate engine coolant etc.**

2) Apply liquid gasket to both sides of the cylinder head gasket RH as shown in the figure.

**NOTE:**

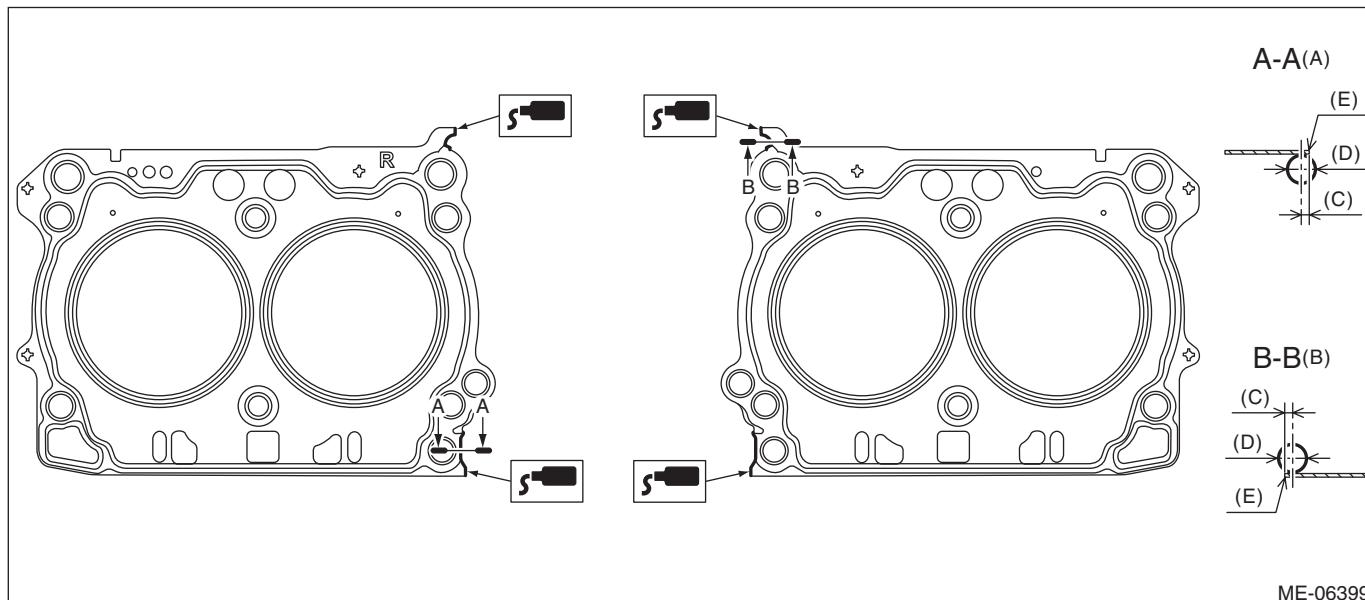
- Use a new cylinder head gasket RH.
- Before applying liquid gasket, degrease the mating surface of cylinder blocks RH and cylinder head RH.
- Install within 5 min. after applying liquid gasket.

**Liquid gasket:**

**THREE BOND 1217G (Part No. 0877Y0100) or equivalent**

**Liquid gasket applying diameter:**

**$3\pm1$  mm (0.1181 $\pm$ 0.0394 in)**



(A) Liquid gasket applying position to the cylinder head side (C) 1 mm (0.0394 in) or less (E) Cylinder head gasket edge  
(B) Liquid gasket applying position to the cylinder block side (D)  $\phi 3\pm1$  mm (0.1181 $\pm$ 0.0394 in)

3) Attach the cylinder head gasket RH.

**NOTE:**

Check that liquid gasket RH is squeezed out from the cylinder head gasket.

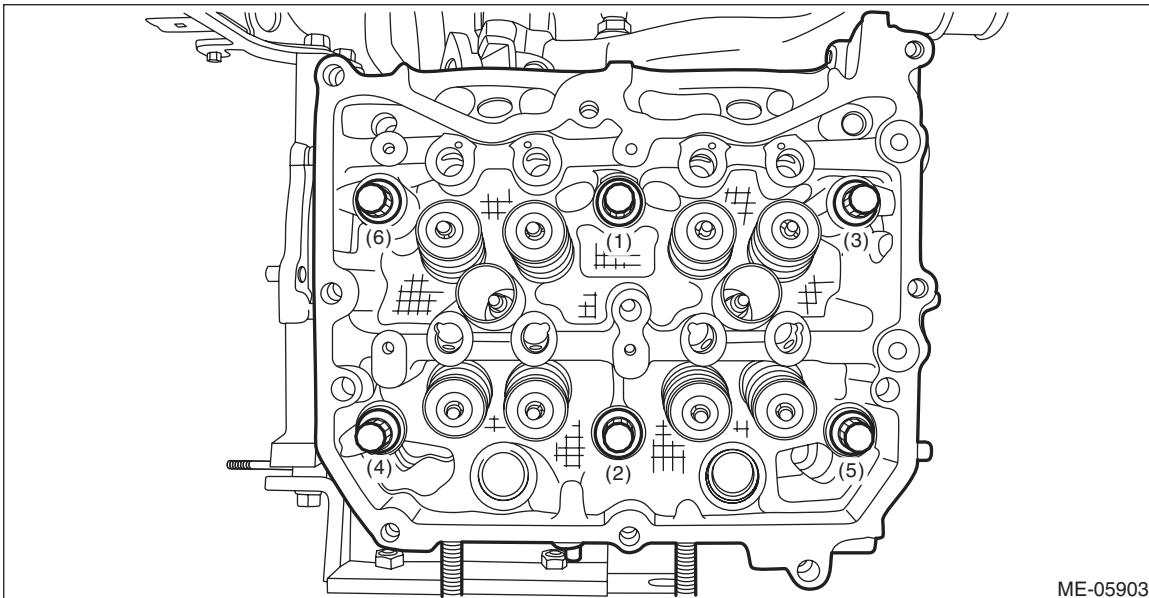
4) Install the cylinder head RH to the cylinder block RH.

**CAUTION:**

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

(1) Clean the cylinder head bolt threads and apply sufficient engine oil to the washer and cylinder head bolts threads.

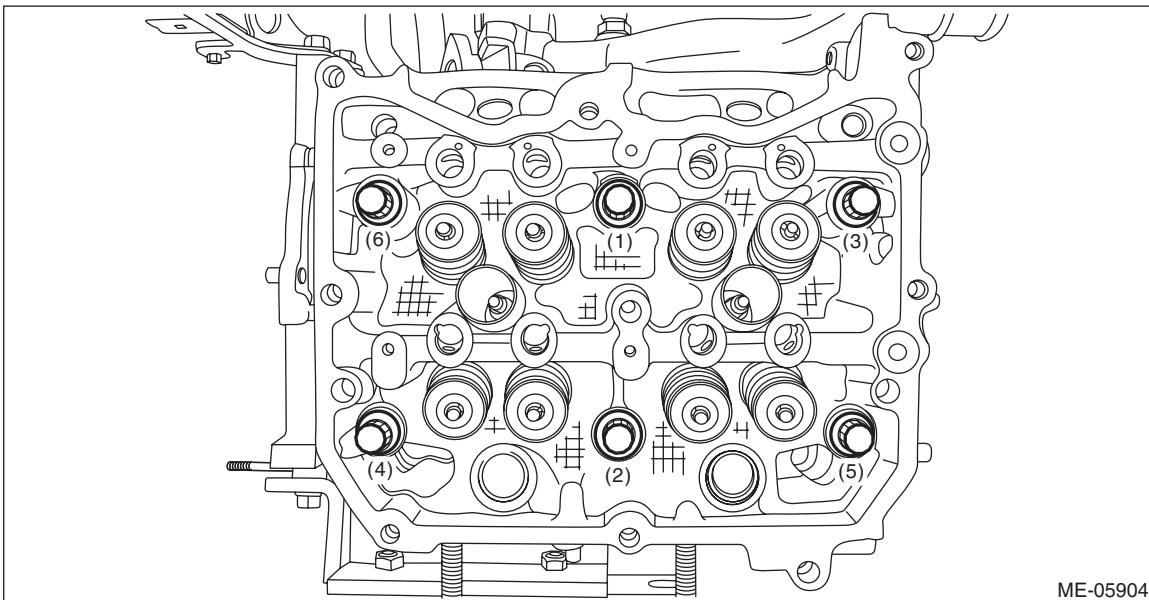
(2) Mount the cylinder head RH onto the cylinder block RH, and tighten all bolts with a torque of 29 N·m (3.0 kgf-m, 21.4 ft-lb) in numerical order as shown in the figure.



(3) Tighten all cylinder head bolts further with a torque of 100 N·m (10.2 kgf-m, 73.8 ft-lb) in numerical order as shown in the figure.

**CAUTION:**

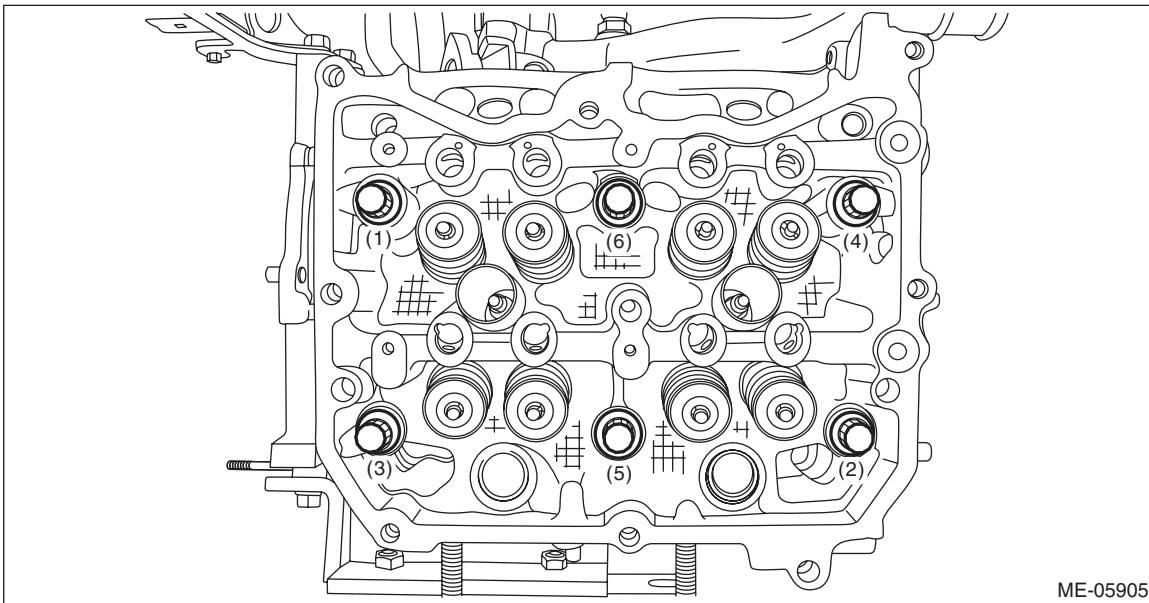
**If the bolt makes stick-slip sound during tightening, repeat the procedure from step 1). In that case, the cylinder head gasket RH can be reused. But it is necessary to remove liquid gasket completely from cylinder block RH, cylinder head RH and cylinder head gasket RH and re-apply to them.**



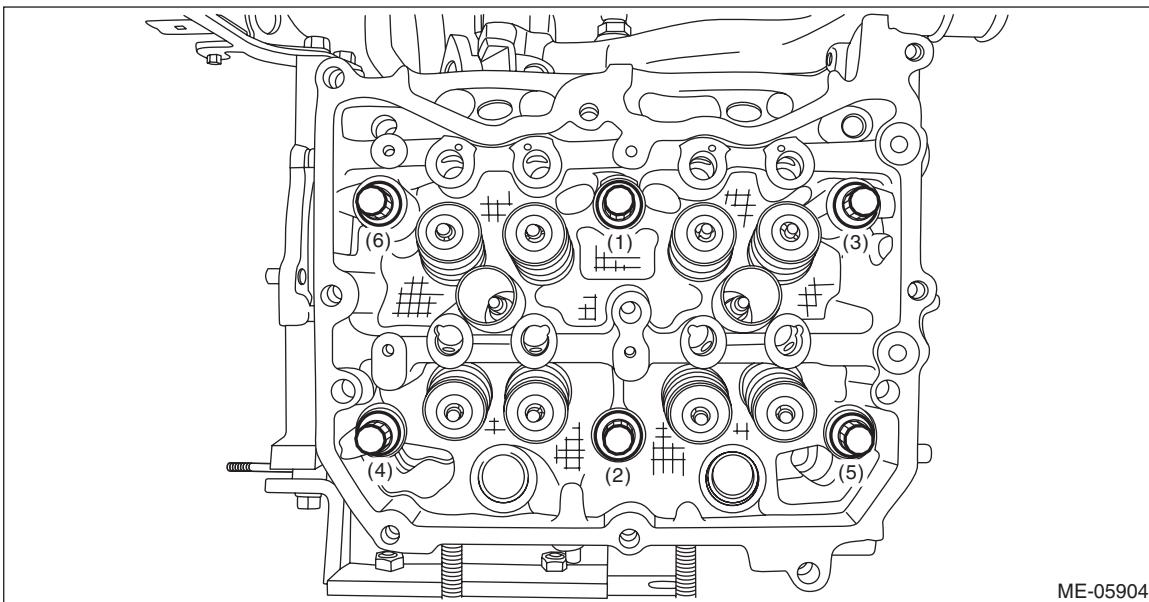
# Cylinder Head

## MECHANICAL

(4) Loosen all cylinder head bolts  $180^\circ$  in numerical order as shown in the figure, and then loosen all cylinder head bolts  $180^\circ$  further in numerical order as shown in the figure.



(5) Tighten all cylinder head bolts with a torque of 42 N·m (4.3 kgf-m, 31.0 ft-lb) in numerical order as shown in the figure.



# Cylinder Head

MECHANICAL

(6) Using ST2, tighten all cylinder head bolts with specified angle in numerical order as shown in the figure.

NOTE:

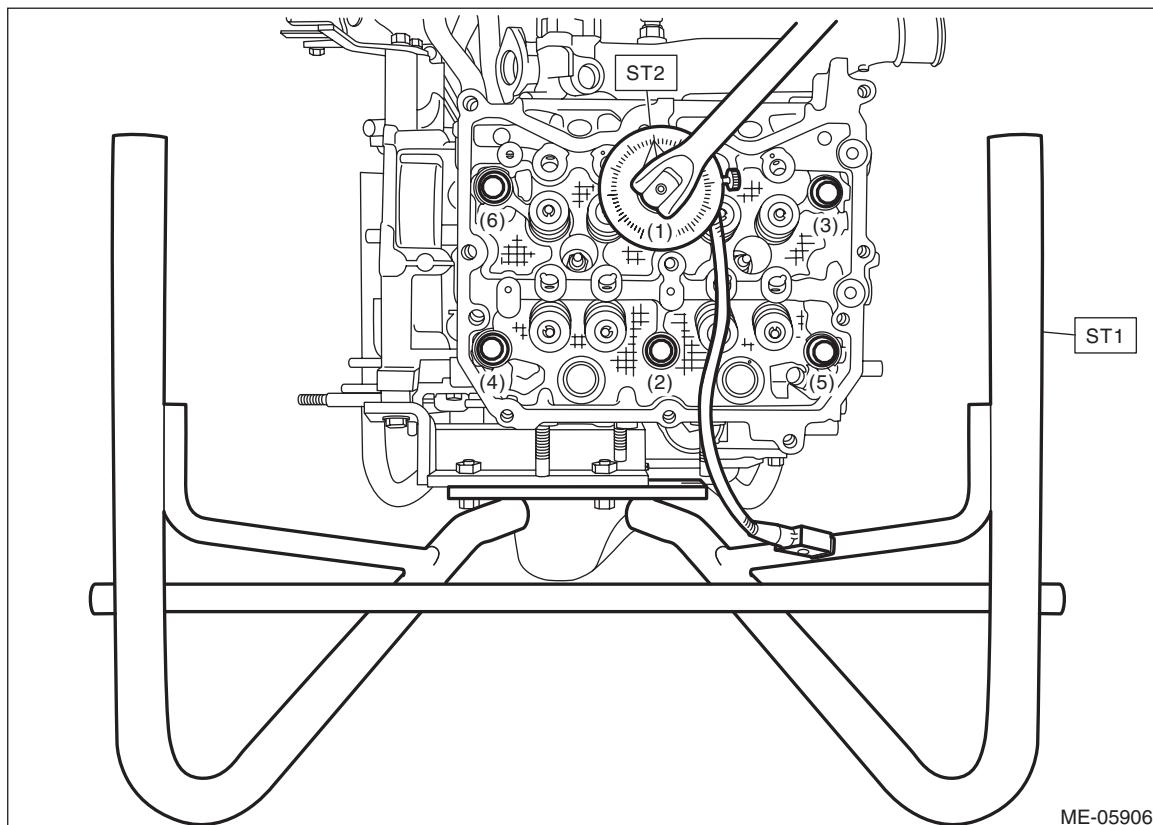
Attach the magnet used for securing the ST2 (ANGLE GAUGE) to ST1.

ST1 499817100 ENGINE STAND

ST2 18854AA000 ANGLE GAUGE

**Tightening angle:**

$80^\circ \pm 2^\circ$



# Cylinder Head

## MECHANICAL

(7) Using ST2, tighten the cylinder head bolts (2 places) with specified angle in numerical order as shown in the figure.

NOTE:

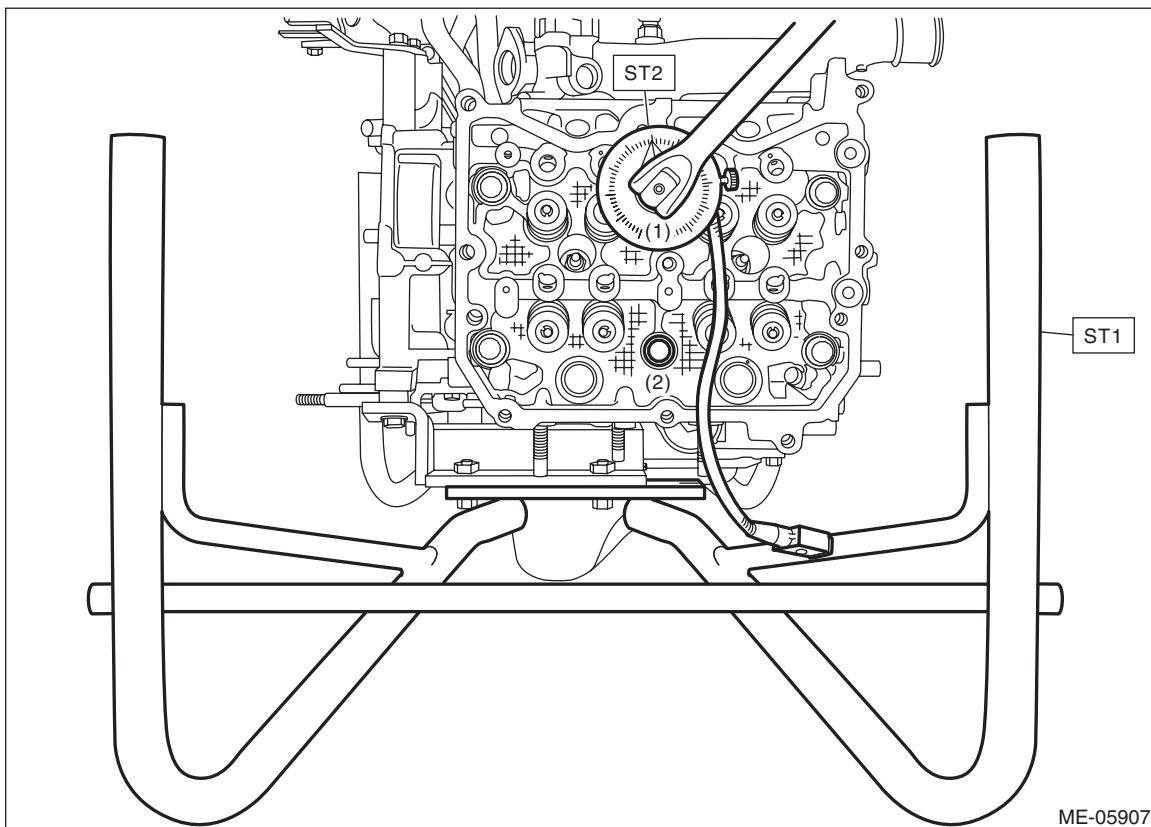
Attach the magnet used for securing the ST2 (ANGLE GAUGE) to ST1.

ST1 499817100 ENGINE STAND

ST2 18854AA000 ANGLE GAUGE

**Tightening angle:**

$75^\circ \pm 2^\circ$



(8) Using ST2, tighten the cylinder head bolts (4 places) with specified angle in numerical order as shown in the figure.

NOTE:

- After tightening, if the liquid gasket is squeezed out onto the seal surface of the chain cover, completely remove any squeezed-out liquid gasket.

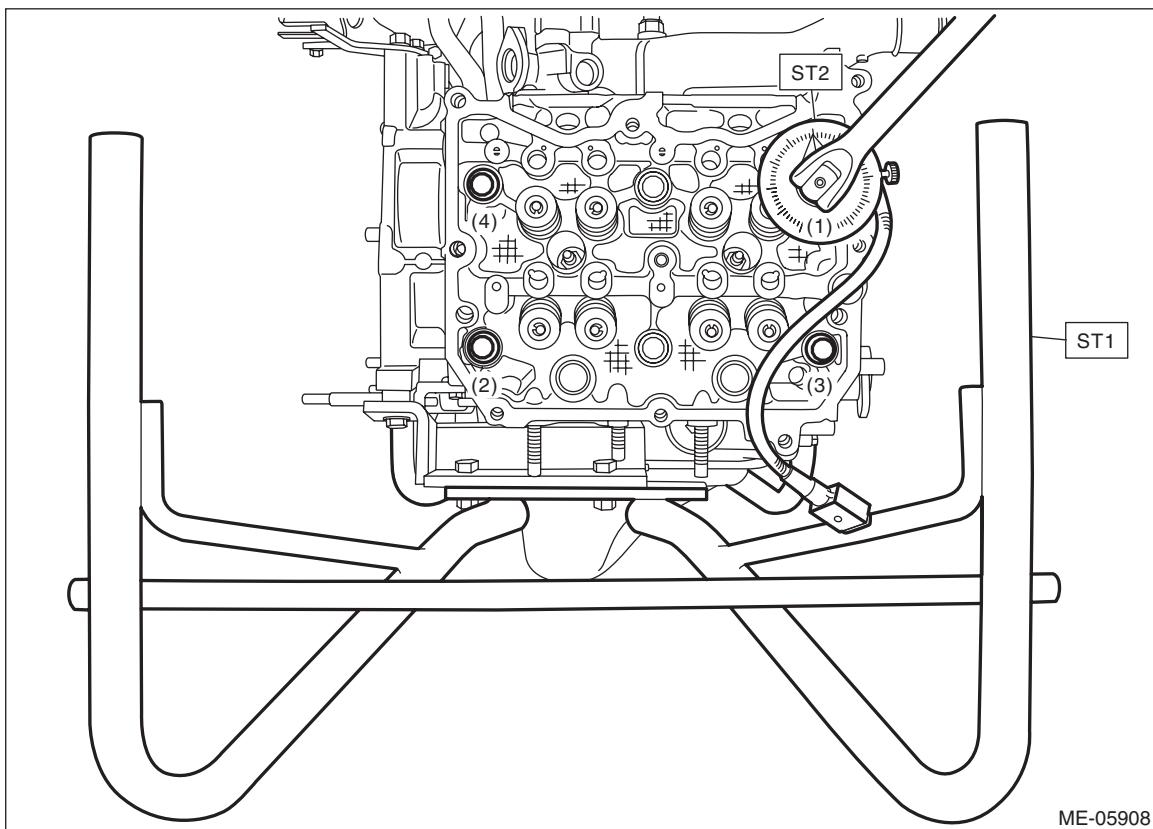
- Attach the magnet used for securing the ST2 (ANGLE GAUGE) to ST1.

ST1 499817100 ENGINE STAND

ST2 18854AA000 ANGLE GAUGE

**Tightening angle:**

$30^\circ \pm 2^\circ$



ME-05908

- 5) Install the EGR pipe assembly to the water pipe assembly and the cylinder block RH.

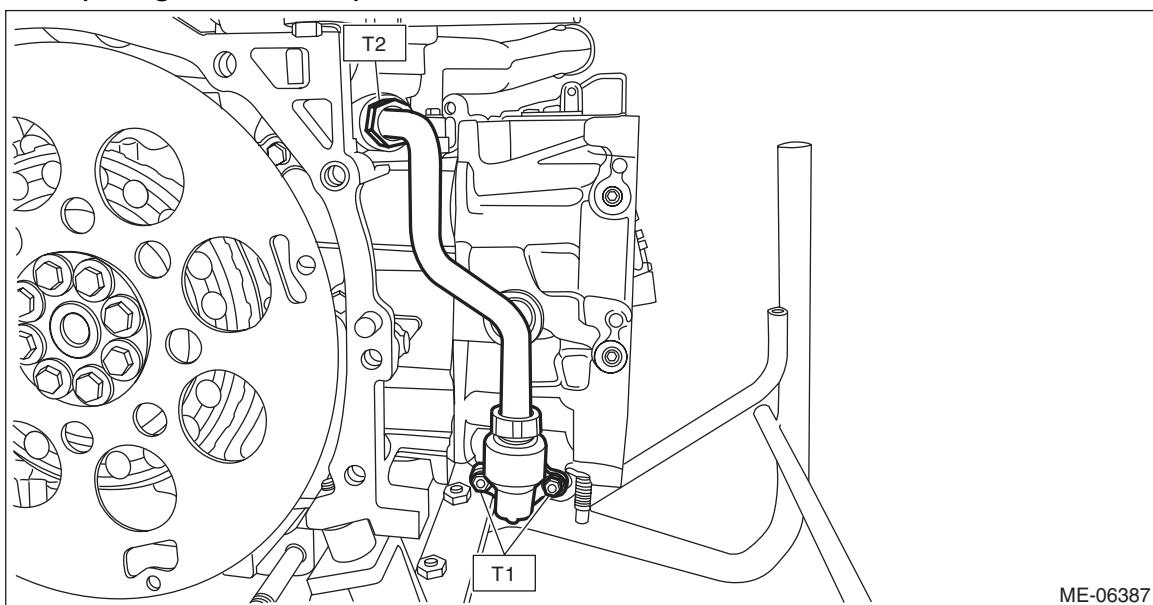
**NOTE:**

Use a new gasket.

**Tightening torque:**

T1: 6.4 N·m (0.7 kgf·m, 4.7 ft-lb)

T2: 51 N·m (5.2 kgf·m, 37.6 ft-lb)



ME-06387

- 6) Install the cam carrier RH. <Ref. to ME(H4DO)-164, CAM CARRIER RH, INSTALLATION, Cam Carrier.>

# Cylinder Head

## MECHANICAL

- 7) Install the rocker cover RH. <Ref. to ME(H4DO)-145, ROCKER COVER RH, INSTALLATION, Rocker Cover.>
- 8) Install the chain cover. <Ref. to ME(H4DO)-100, INSTALLATION, Chain Cover.>
- 9) Install the tumble generator valve assembly RH. <Ref. to FU(H4DO)-82, INSTALLATION, Tumble Generator Valve Assembly.>
- 10) Install the intake manifold. <Ref. to FU(H4DO)-32, INSTALLATION, Intake Manifold.>
- 11) Install the engine to the vehicle. <Ref. to ME(H4DO)-59, INSTALLATION, Engine Assembly.>

## 2. CYLINDER HEAD LH

- 1) Clean the bolt holes in the cylinder block LH.

### CAUTION:

**To avoid erroneous tightening of the bolts, clean out the bolt holes sufficiently by blowing with compressed air to eliminate engine coolant etc.**

- 2) Apply liquid gasket to both sides of the cylinder head gasket LH as shown in the figure.

### NOTE:

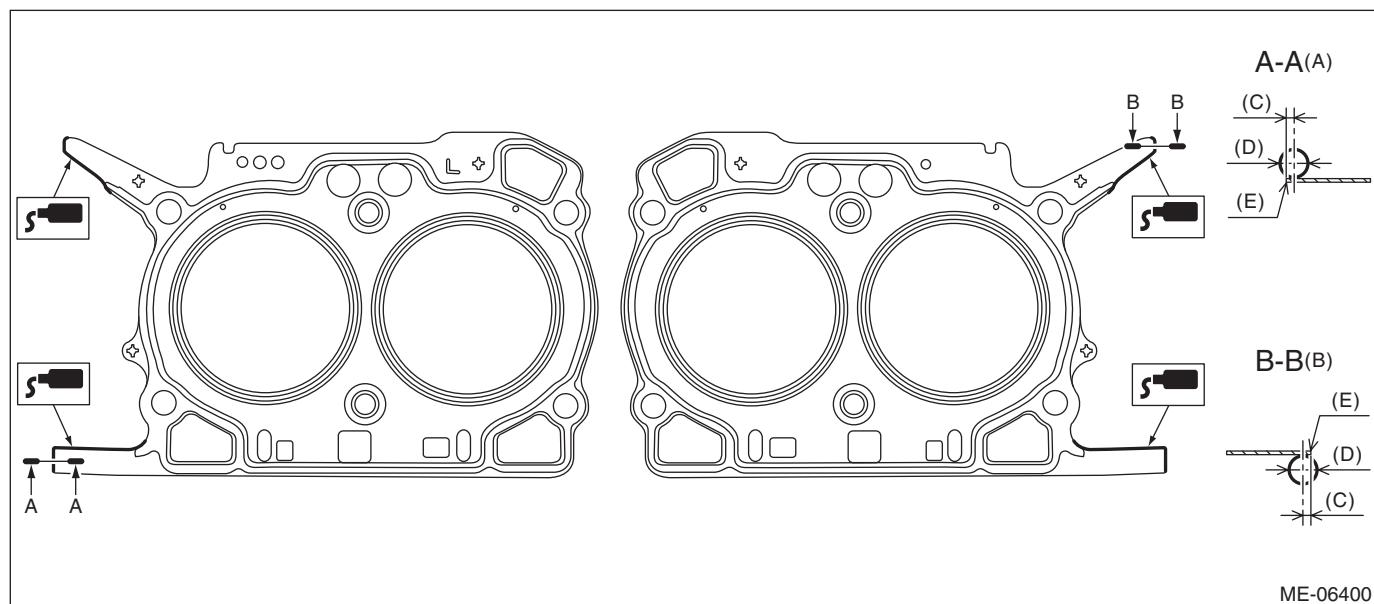
- Use a new cylinder head gasket LH.
- Before applying liquid gasket, degrease the mating surface of cylinder blocks LH and cylinder head LH.
- Install within 5 min. after applying liquid gasket.

### Liquid gasket:

**THREE BOND 1217G (Part No. 0877Y0100) or equivalent**

### Liquid gasket applying diameter:

**$3\pm1$  mm (0.1181±0.0394 in)**



(A) Liquid gasket applying position to the cylinder head side	(C) 1 mm (0.0394 in) or less	(E) Cylinder head gasket edge
(B) Liquid gasket applying position to the cylinder block side	(D) $\phi 3\pm1$ mm (0.1181±0.0394 in)	

- 3) Attach the cylinder head gasket LH.

### NOTE:

Check that liquid gasket is squeezed out from the cylinder head gasket LH.

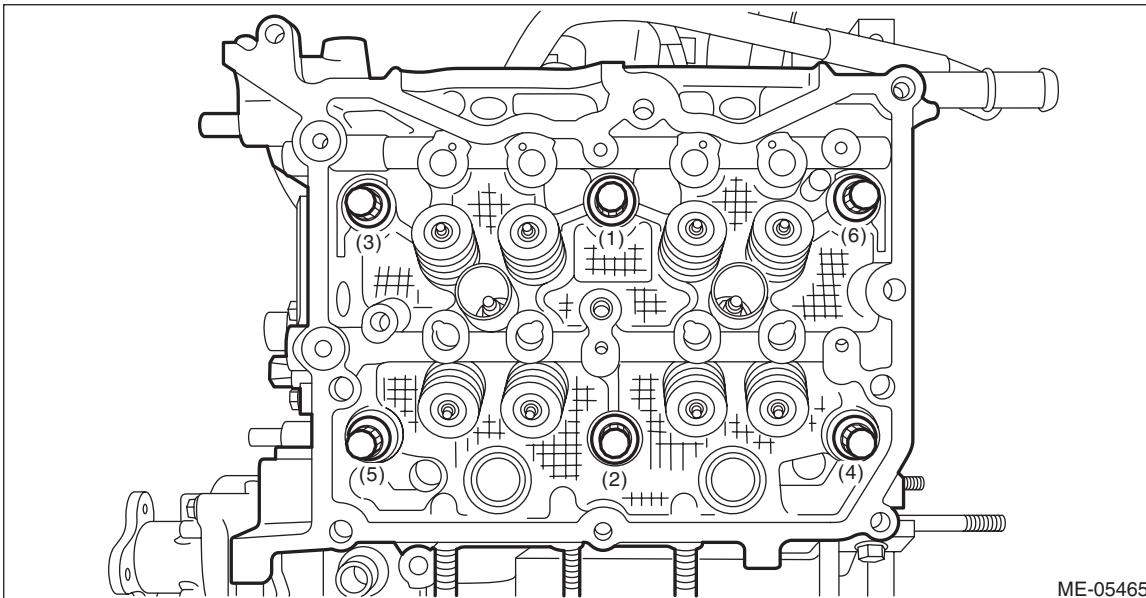
4) Install the cylinder head LH to the cylinder block LH.

**CAUTION:**

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

(1) Clean the cylinder head bolt threads and apply sufficient engine oil to the washer and cylinder head bolts threads.

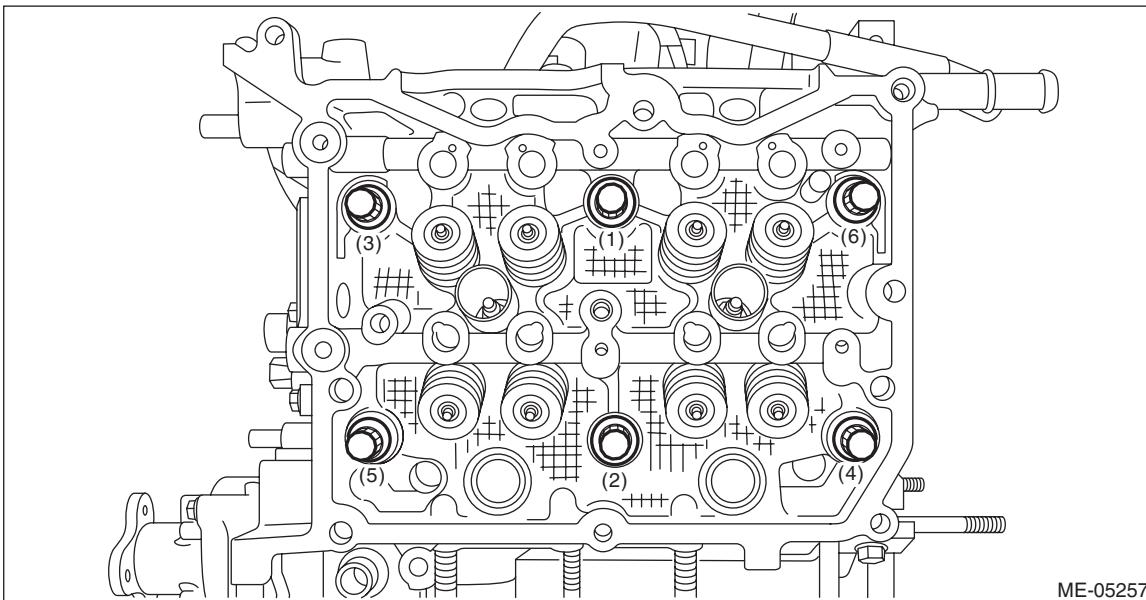
(2) Mount the cylinder head LH onto the cylinder block LH, then tighten all bolts with a torque of 29 N·m (3.0 kgf-m, 21.4 ft-lb) in numerical order as shown in the figure.



(3) Tighten all cylinder head bolts further with a torque of 100 N·m (10.2 kgf-m, 73.8 ft-lb) in numerical order as shown in the figure.

**CAUTION:**

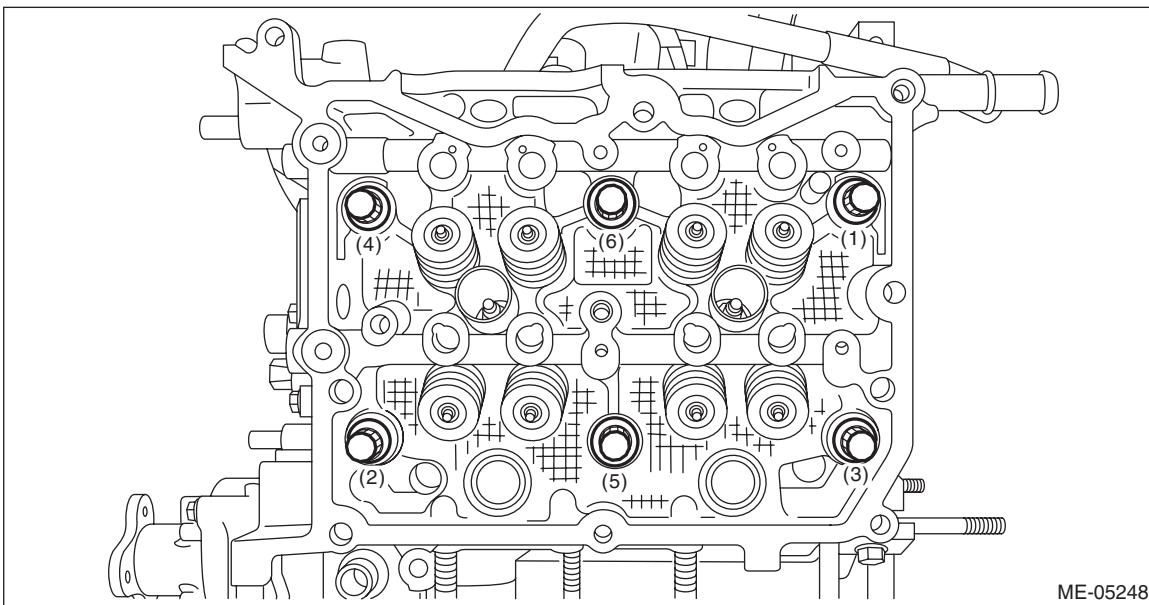
**If the bolt makes stick-slip sound during tightening, repeat the procedure from step 1). In that case, the cylinder head gasket LH can be reused. But it is necessary to remove liquid gasket completely from cylinder block LH, cylinder head LH and cylinder head gasket LH and re-apply to them.**



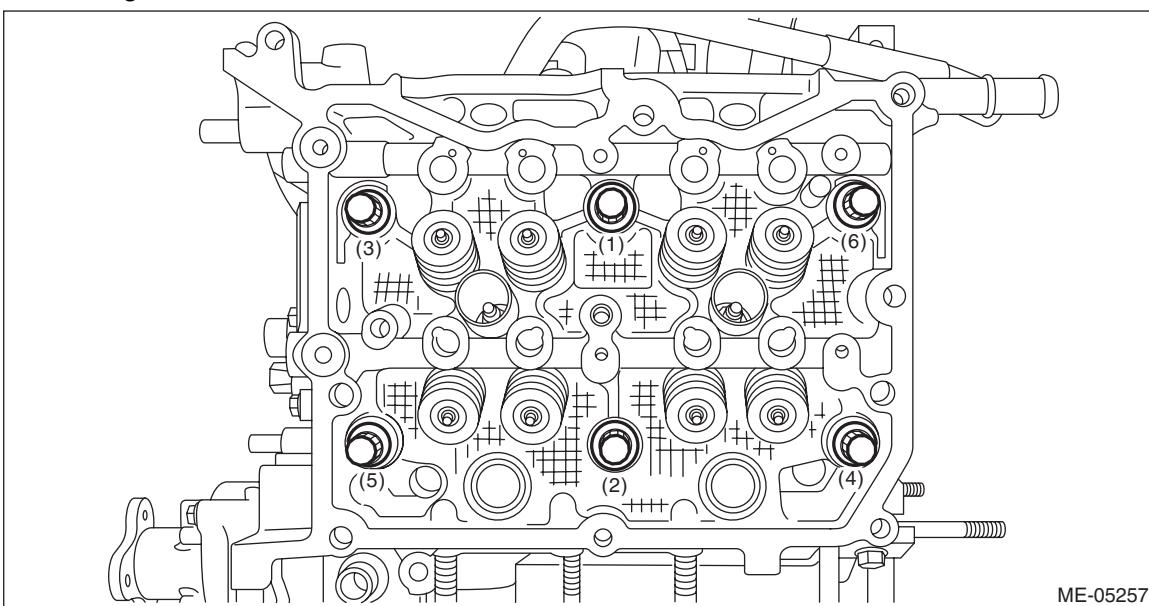
# Cylinder Head

## MECHANICAL

(4) Loosen all cylinder head bolts  $180^\circ$  in numerical order as shown in the figure, and then loosen all cylinder head bolts  $180^\circ$  further in numerical order as shown in the figure.



(5) Tighten all cylinder head bolts with a torque of 42 N·m (4.3 kgf-m, 31.0 ft-lb) in numerical order as shown in the figure.



# Cylinder Head

MECHANICAL

(6) Using ST2, tighten all cylinder head bolts with specified angle in numerical order as shown in the figure.

NOTE:

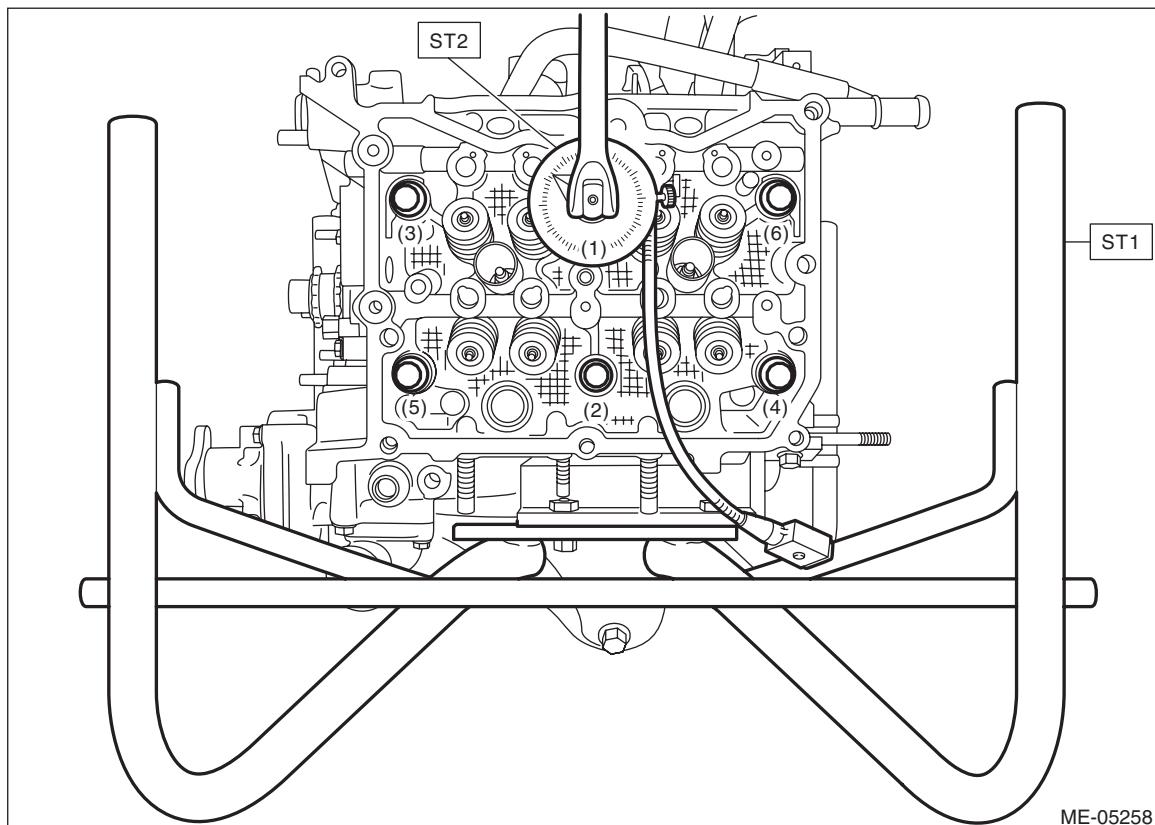
Attach the magnet used for securing the ST2 (ANGLE GAUGE) to ST1.

ST1 499817100 ENGINE STAND

ST2 18854AA000 ANGLE GAUGE

**Tightening angle:**

$80^\circ \pm 2^\circ$



ME-05258

# Cylinder Head

## MECHANICAL

(7) Using ST2, tighten the cylinder head bolts (2 places) with specified angle in numerical order as shown in the figure.

NOTE:

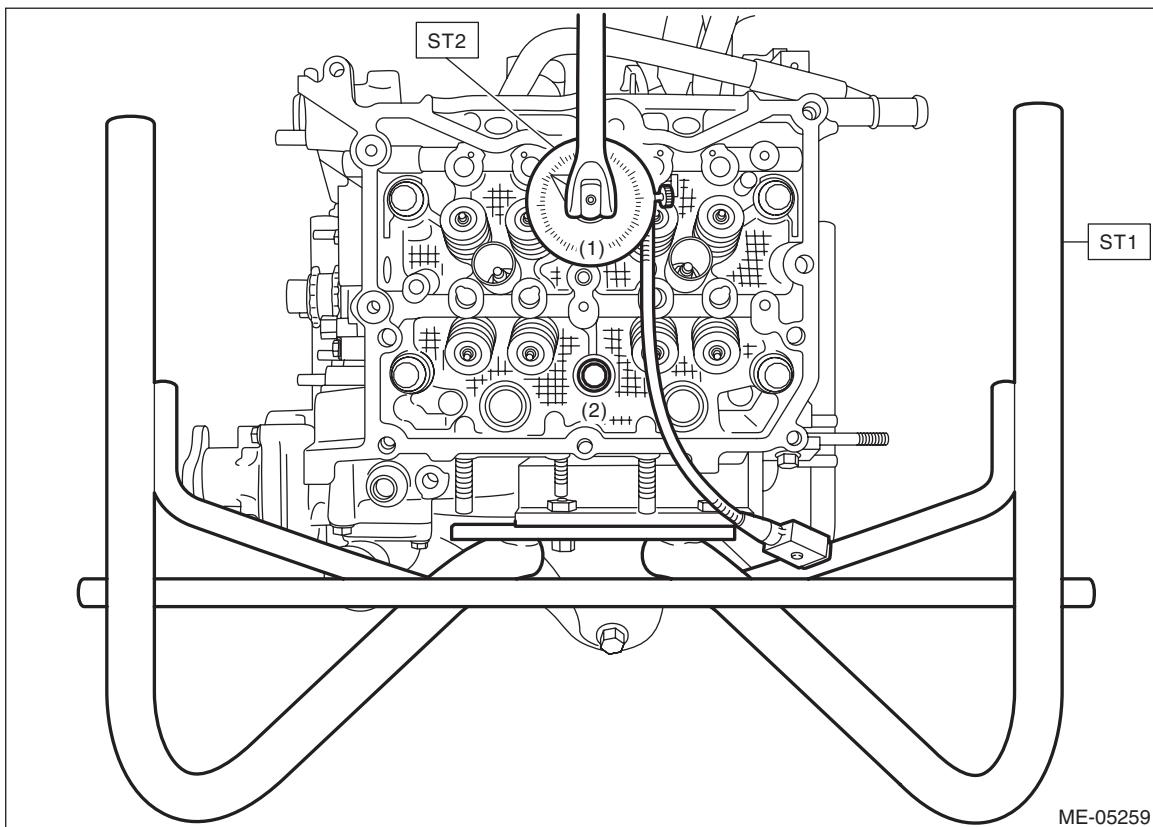
Attach the magnet used for securing the ST2 (ANGLE GAUGE) to ST1.

ST1 499817100 ENGINE STAND

ST2 18854AA000 ANGLE GAUGE

**Tightening angle:**

$75^\circ \pm 2^\circ$



(8) Using ST2, tighten the cylinder head bolts (4 places) with specified angle in numerical order as shown in the figure.

**NOTE:**

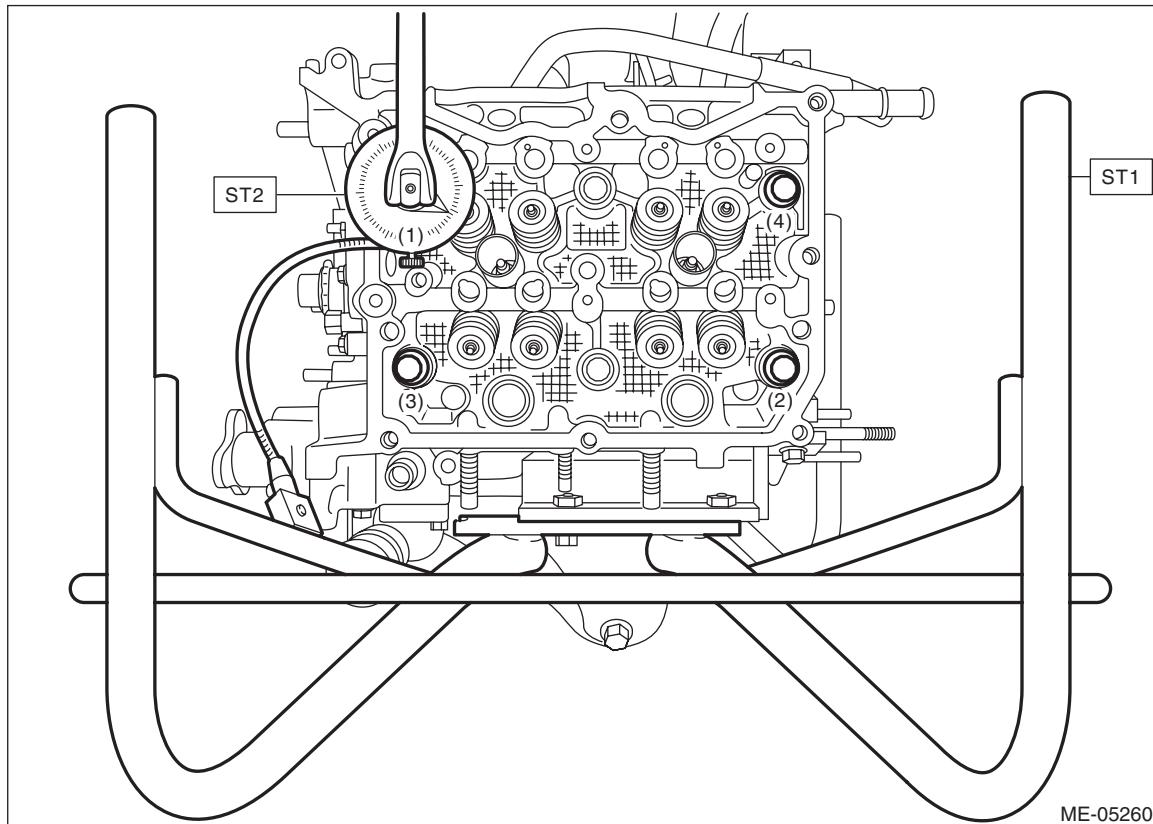
- After tightening, if the liquid gasket is squeezed out onto the seal surface of the chain cover, completely remove any squeezed-out liquid gasket.
- Attach the magnet used for securing the ST2 (ANGLE GAUGE) to ST1.

ST1 499817100 ENGINE STAND

ST2 18854AA000 ANGLE GAUGE

**Tightening angle:**

$30^\circ \pm 2^\circ$



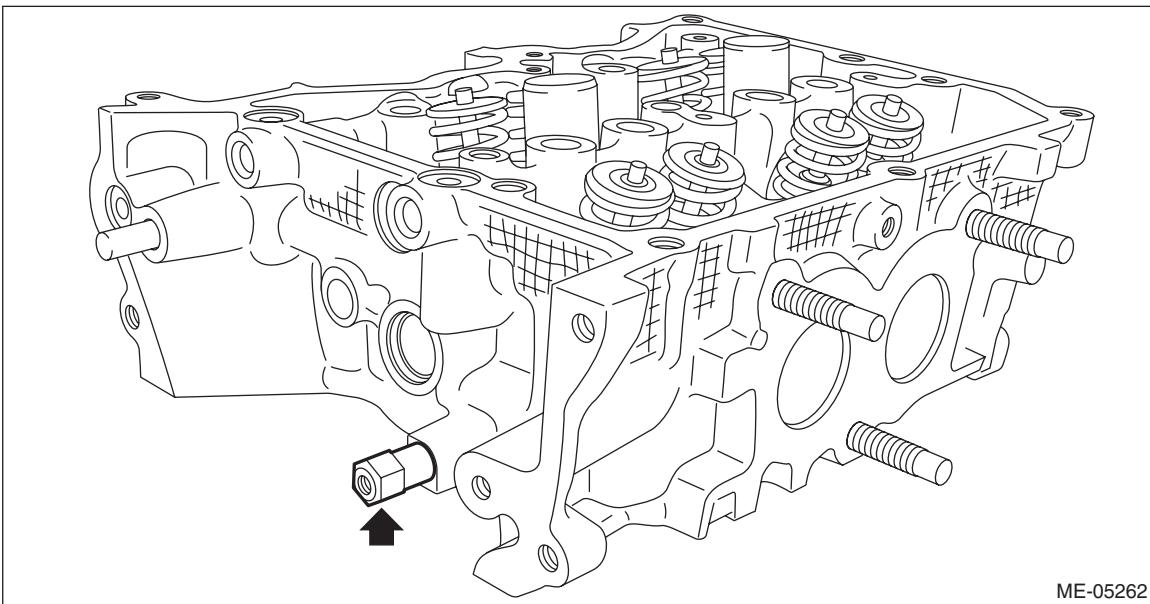
- 5) Install the A/C compressor. <Ref. to AC-61, INSTALLATION, Compressor.>
- 6) Install the cam carrier LH. <Ref. to ME(H4DO)-174, CAM CARRIER LH, INSTALLATION, Cam Carrier.>
- 7) Install the rocker cover LH. <Ref. to ME(H4DO)-148, ROCKER COVER LH, INSTALLATION, Rocker Cover.>
- 8) Install the chain cover. <Ref. to ME(H4DO)-100, INSTALLATION, Chain Cover.>
- 9) Install the tumble generator valve assembly LH. <Ref. to FU(H4DO)-82, INSTALLATION, Tumble Generator Valve Assembly.>
- 10) Install the intake manifold. <Ref. to FU(H4DO)-32, INSTALLATION, Intake Manifold.>
- 11) Install the engine to the vehicle. <Ref. to ME(H4DO)-59, INSTALLATION, Engine Assembly.>

# Cylinder Head

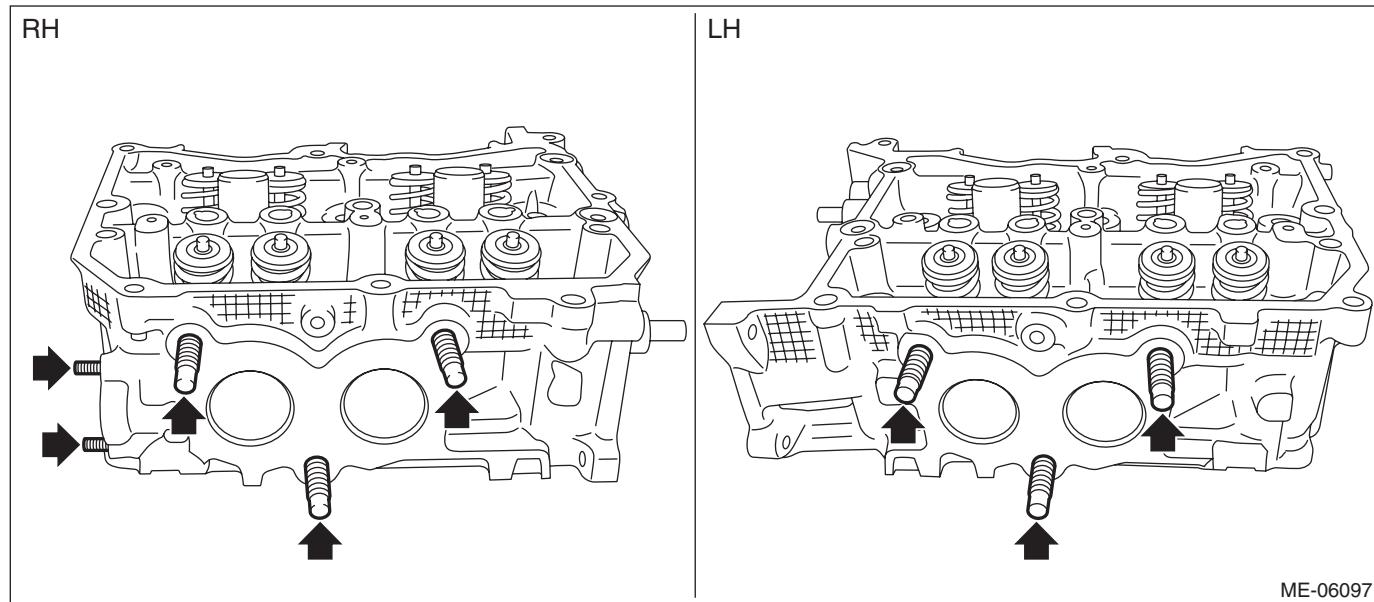
## MECHANICAL

### C: DISASSEMBLY

- 1) Remove the chain cover securing bolt from the cylinder head LH.



- 2) Remove the stud bolts from the cylinder head.



3) Remove the valve collet, valve, valve spring retainer, valve spring and valve spring seat from the cylinder head RH.

**CAUTION:**

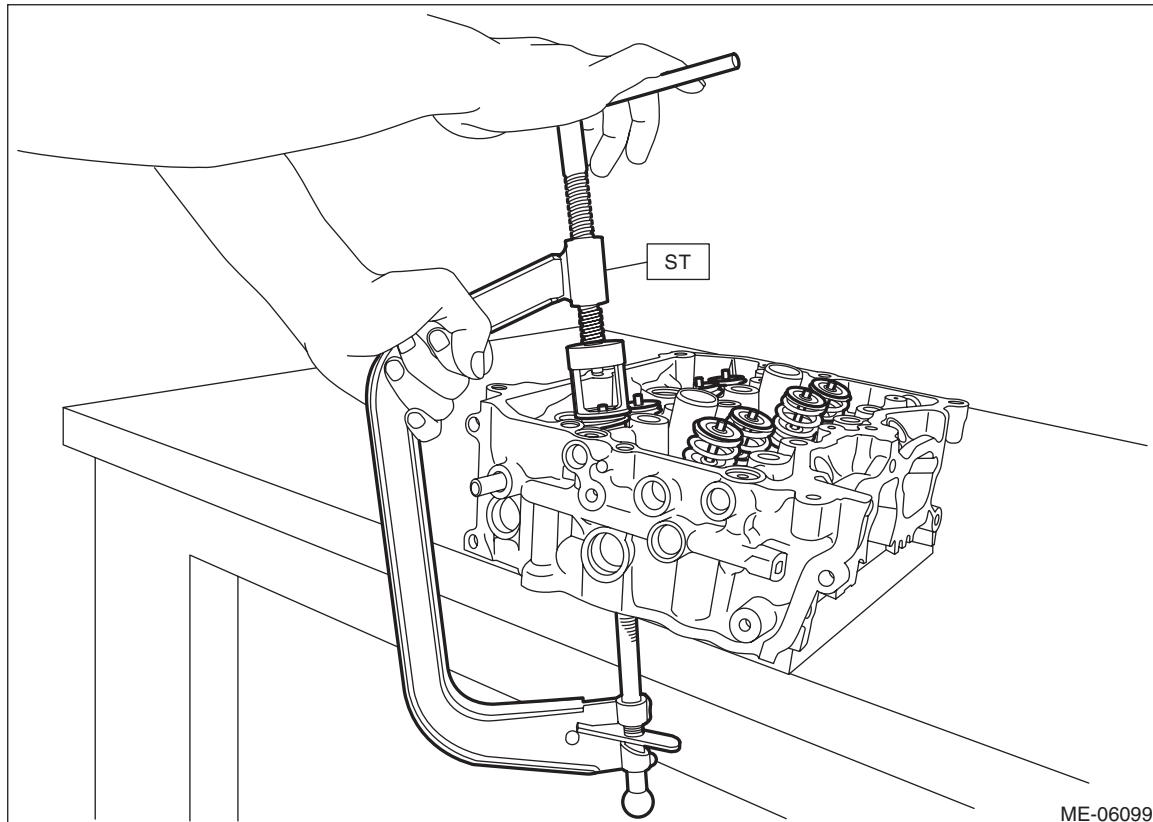
During work, place a waste cloth, etc. to avoid scratching the mating surface of the cylinder head RH.

**NOTE:**

- Mark each part to prevent confusion.
- Keep all the removed parts in order for re-installing in their original positions.

(1) Compress the valve spring and remove the valve collet using ST.

ST 0920287002000 REMOVER AND REPLACER



(2) Remove valve, valve spring retainer, valve spring and valve spring seat.

4) Remove the valve collet, valve, valve spring retainer, valve spring and valve spring seat from the cylinder head LH.

# Cylinder Head

## MECHANICAL

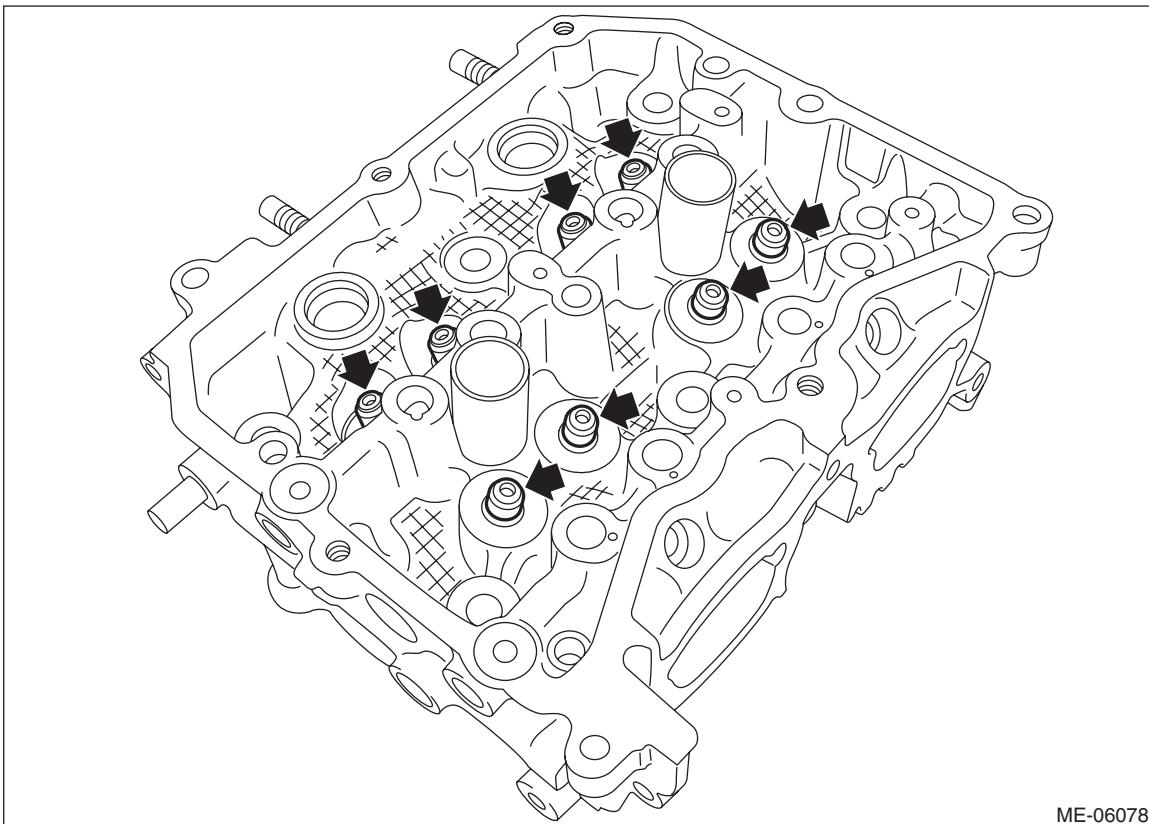
5) Remove the valve oil seals from valve guides of cylinder head RH.

### CAUTION:

- During work, place a waste cloth, etc. to avoid scratching the mating surface of the cylinder head RH.
- Use special care not to damage the cylinder head RH and guide during work.

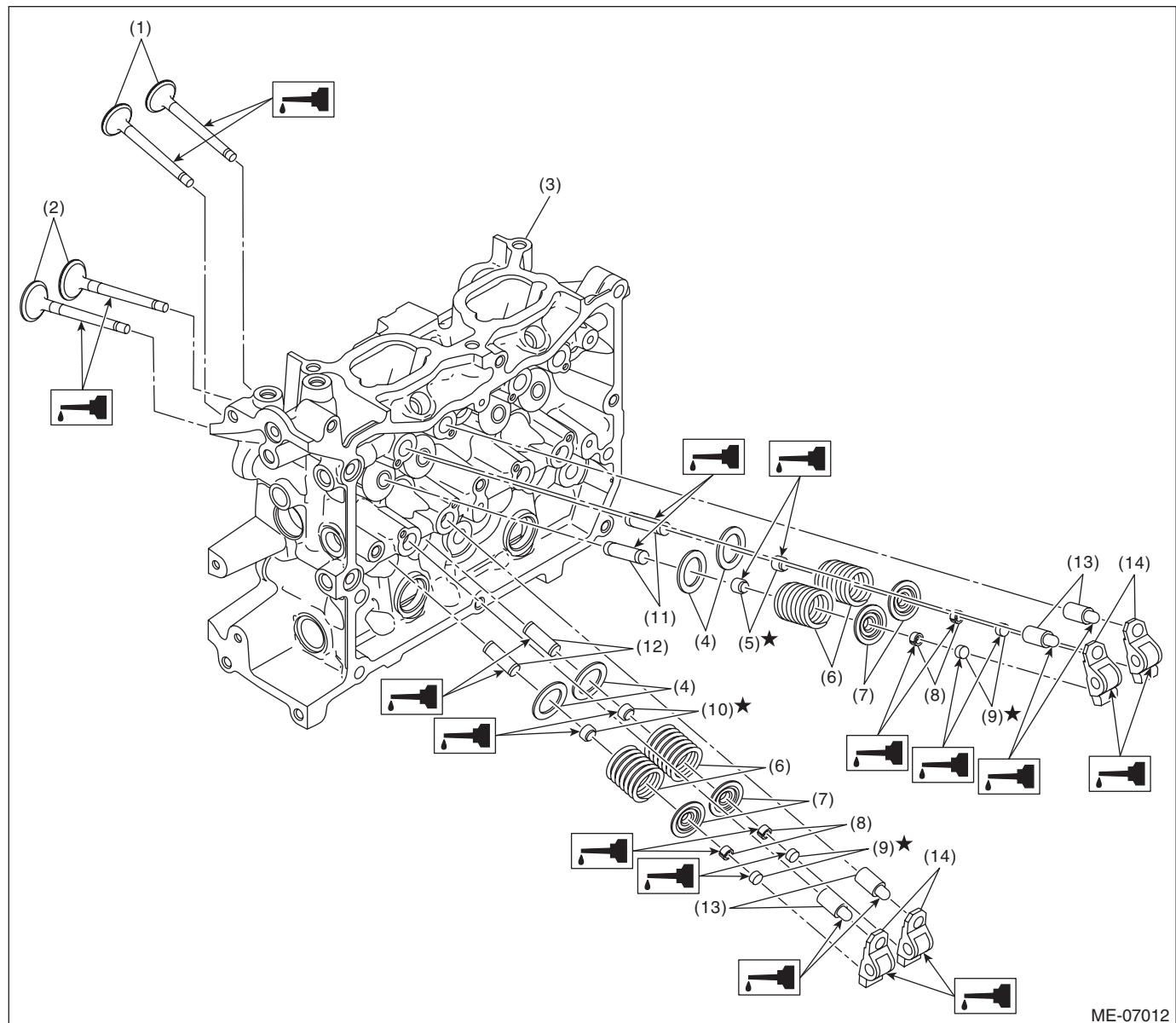
### NOTE:

For removal of valve guide, refer to INSPECTION. <Ref. to ME(H4DO)-220, VALVE & VALVE GUIDE, INSPECTION, Cylinder Head.>



6) For cylinder head LH, remove the valve oil seal in the same manner.

## D: ASSEMBLY



(1) Exhaust valve	(6) Valve spring	(11) Intake valve guide
(2) Intake valve	(7) Valve spring retainer	(12) Exhaust valve guide
(3) Cylinder head	(8) Valve collet	(13) Roller rocker arm pivot
(4) Valve spring seat	(9) Valve shim	(14) Roller rocker arm
(5) Intake valve oil seal	(10) Exhaust valve oil seal	

# Cylinder Head

## MECHANICAL

1) Using the ST, install the valve oil seals to valve guides of cylinder head RH.

### CAUTION:

- During work, place a waste cloth, etc. to avoid scratching the mating surface of the cylinder head RH.
- Use special care not to damage the cylinder head RH and guide during work.
- When installing the valve oil seal, press the ST with hands to install it and never drive the ST with a plastic hammer, otherwise the valve oil seal can be damaged.

### NOTE:

- Use a new valve oil seal.
- Apply engine oil to valve oil seal before installing.
- The intake valve oil seals and exhaust valve oil seals are distinguished by their colors.

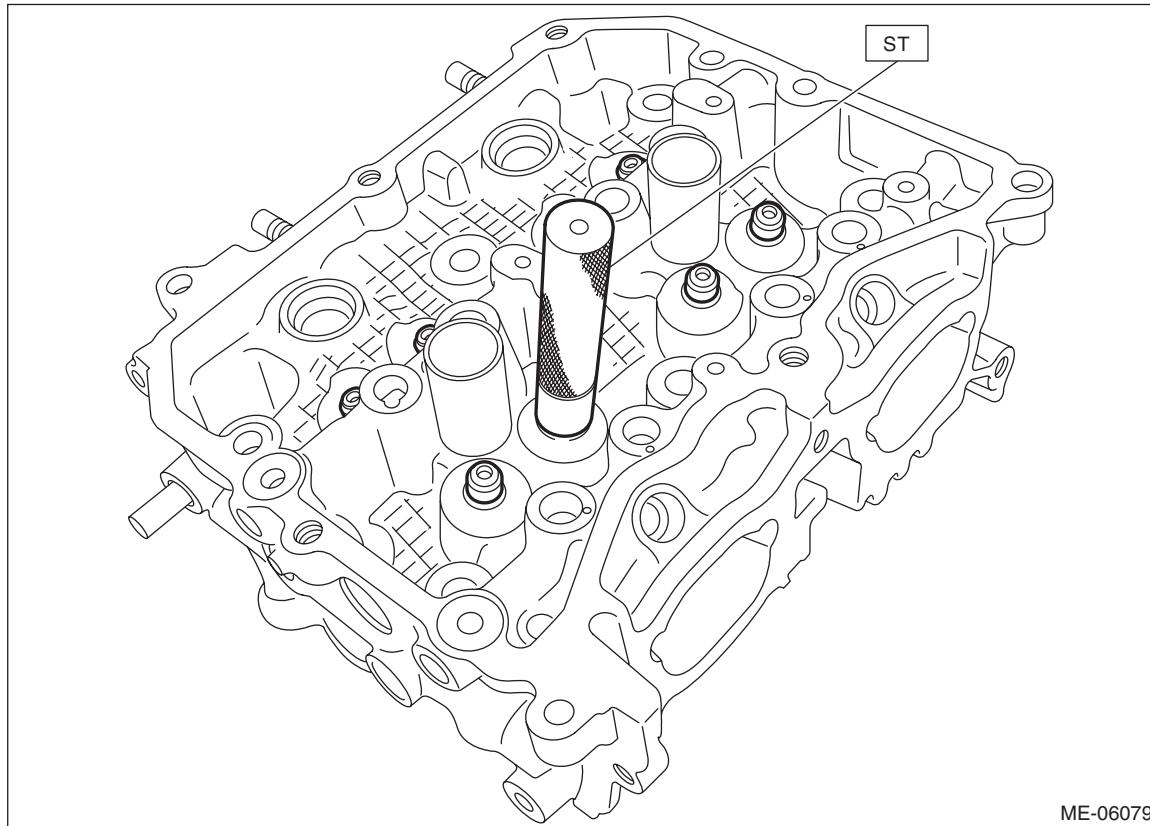
### *Identification colors:*

*Intake [Gray]*

*Exhaust [Green]*

- For installation of valve guide, refer to INSPECTION. <Ref. to ME(H4DO)-220, VALVE & VALVE GUIDE, INSPECTION, Cylinder Head.>

ST 18261AA010 VALVE OIL SEAL GUIDE



2) For cylinder head LH, install the valve oil seal in the same manner.

3) Install the valve spring seat, valve spring, valve spring retainer, valve and valve collet to the cylinder head RH.

### CAUTION:

**During work, place a waste cloth, etc. to avoid scratching the mating surface of the cylinder head RH.**

- (1) Set the valve spring seat, valve spring and valve spring retainer onto the cylinder head RH.

### NOTE:

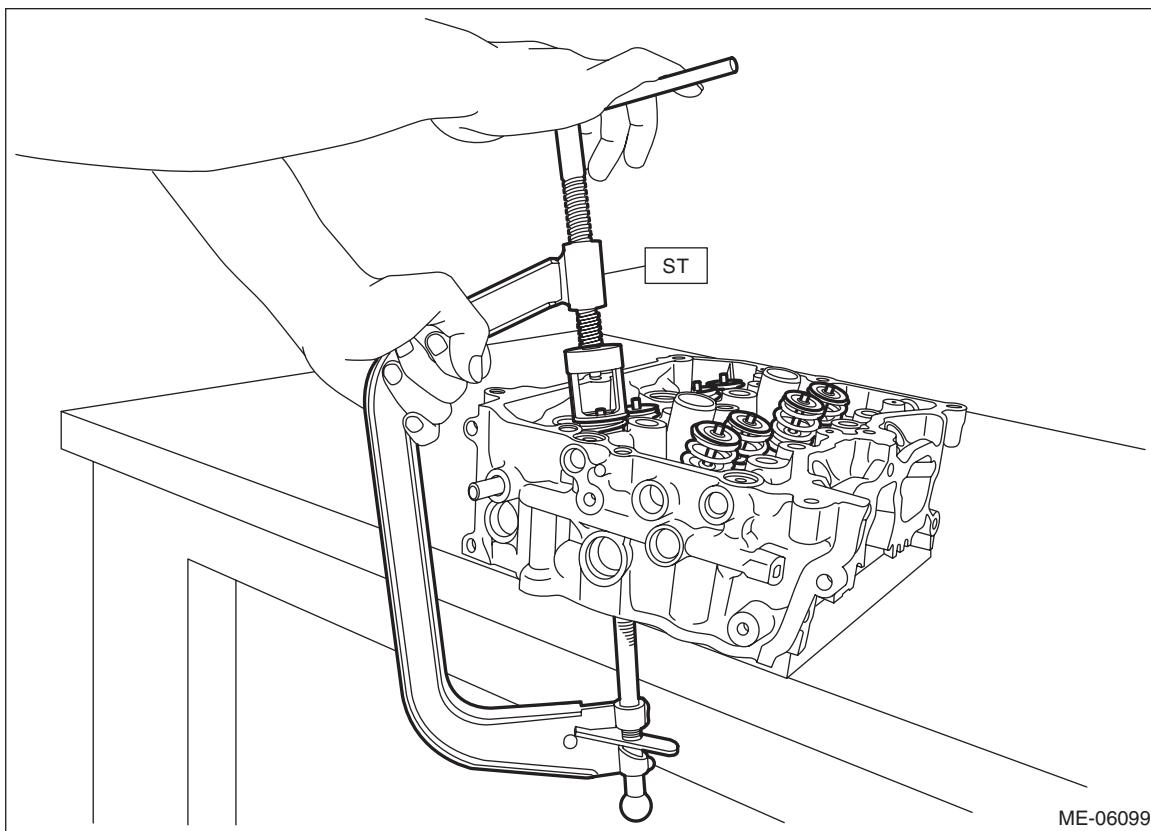
Be sure to install the valve spring with its close-coiled end facing the cylinder head side.

- (2) 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.

(3) Compress the valve spring and install the valve collet using ST.  
ST 0920287002000 REMOVER AND REPLACER

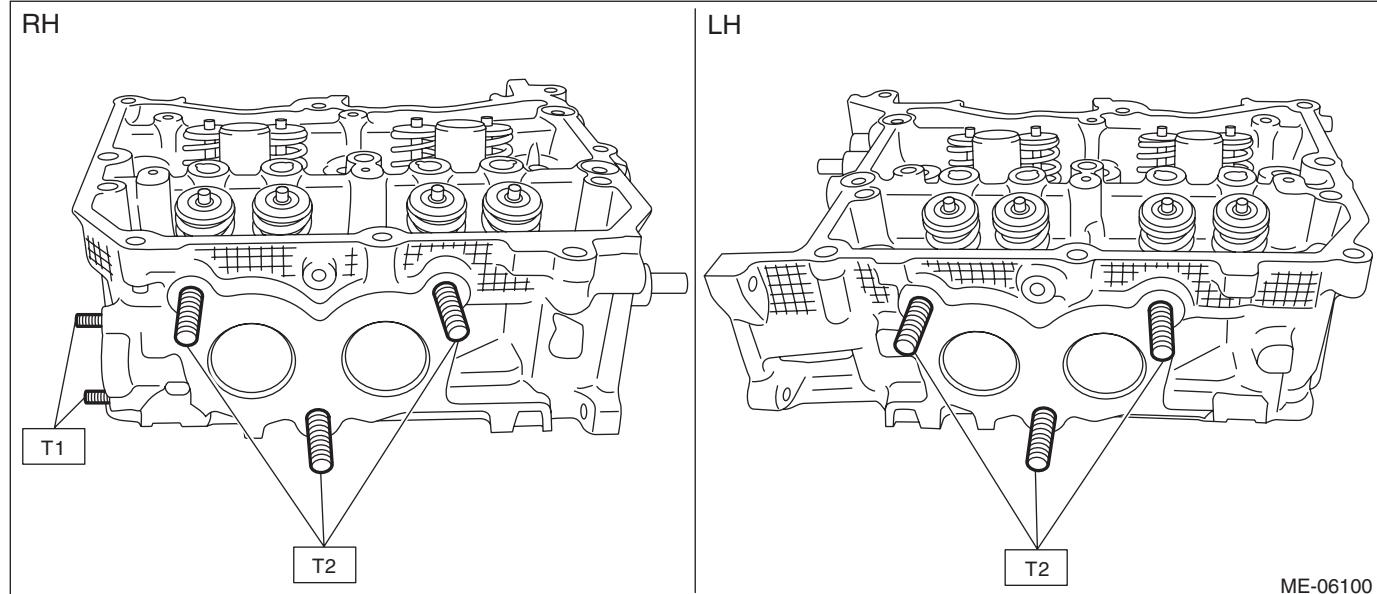


- 4) Install the valve spring seat, valve spring, valve spring retainer, valve and valve collet to the cylinder head LH.
- 5) Lightly tap the valve spring retainer with a plastic hammer, and make sure that the valve collet is securely attached.
- 6) Install the stud bolts onto cylinder heads.

**Tightening torque:**

**T1: 6.4 N·m (0.7 kgf-m, 4.7 ft-lb)**

**T2: 18 N·m (1.8 kgf-m, 13.3 ft-lb)**



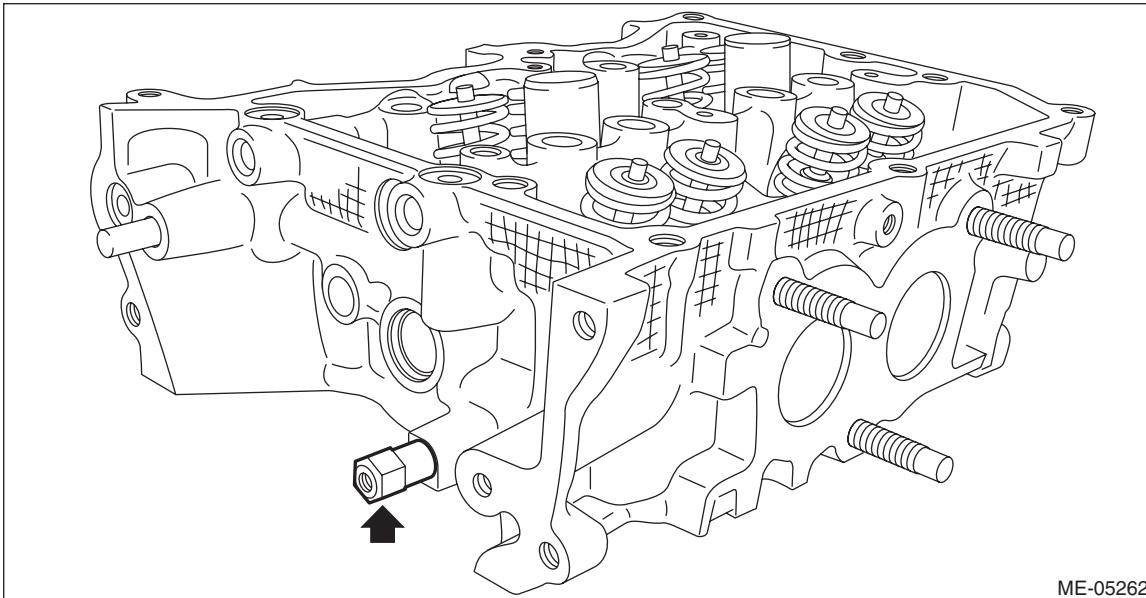
# Cylinder Head

## MECHANICAL

7) Install the chain cover securing bolt to the cylinder head LH.

**Tightening torque:**

**6.4 N·m (0.7 kgf·m, 4.7 ft-lb)**



## E: INSPECTION

### 1. CYLINDER HEAD

- 1) Visually inspect to make sure that there are no cracks, scratches or other damage.
- 2) Use liquid penetrant tester on the important sections to check for fissures.
- 3) Check that there are no marks of gas leaking or water leaking on gasket attachment surface.
- 4) Check the warping of the cylinder head mating surface that mates with cylinder block at the locations shown in the figure using a straight edge (A) and thickness gauge (B). If it exceeds the limit, correct the surface by grinding it with a surface grinder or replace the cylinder head.

**NOTE:**

- Measurement should be performed at a temperature of 20°C (68°F).
- If there is warpage on the cylinder head mating surface, the cylinder head bolt tightening torque and angle tightening may be improper. When installing the cylinder head, make sure that tightening torque and angle tightening work is performed precisely according to the operation procedures.
- When the cylinder head is replaced, lap each valve. Refer to “VALVE SEAT” for lapping. <Ref. to ME(H4DO)-229, VALVE SEAT, INSPECTION, Cylinder Head.>

**Cylinder head warpage:**

**Limit**

**0.035 mm (0.0014 in)**

**Cylinder head grinding limit:**

**To 98.4 mm (3.874 in)**

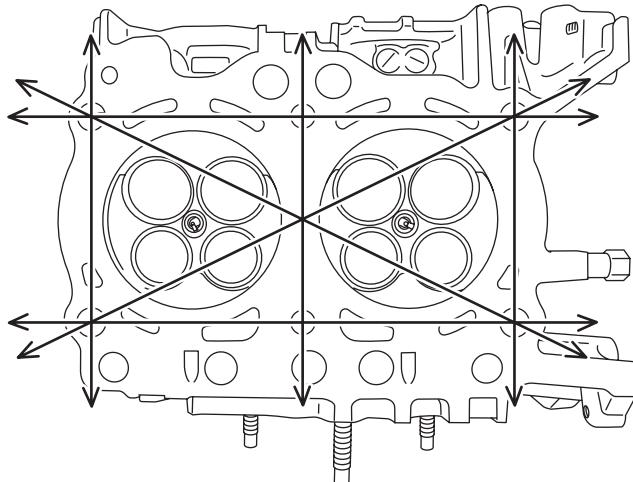
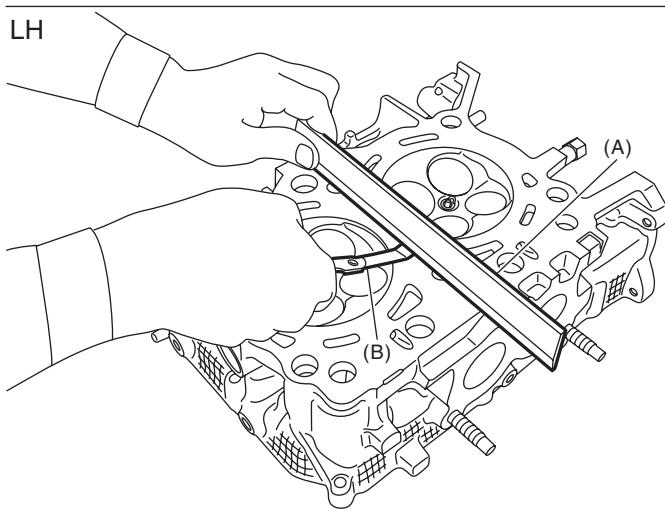
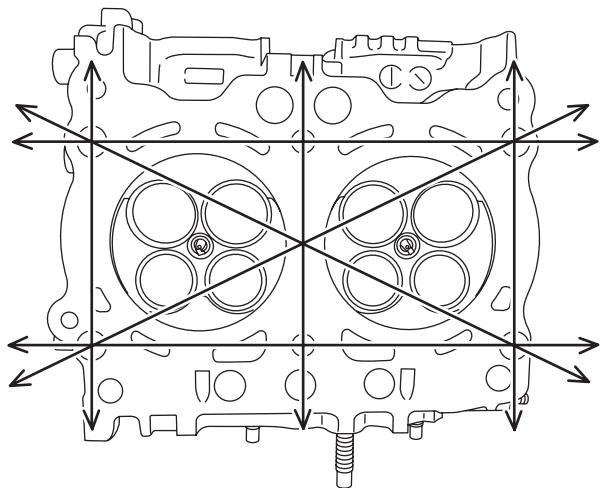
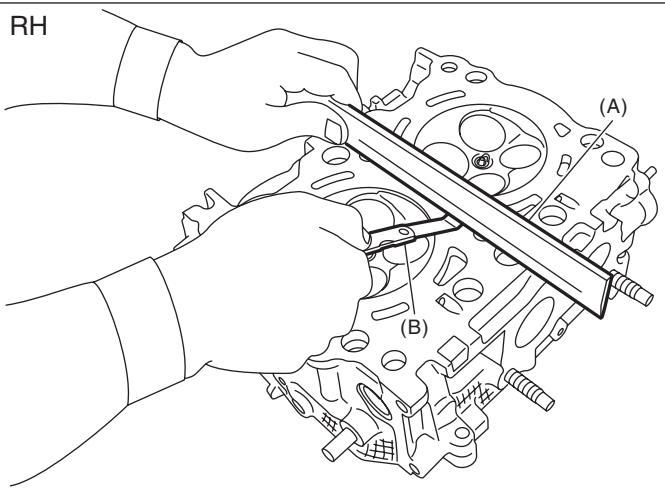
**Cylinder head height:**

**Standard**

**98.5 mm (3.878 in)**

# Cylinder Head

MECHANICAL



ME-06081

# Cylinder Head

## MECHANICAL

### 2. VALVE & VALVE GUIDE

- 1) Check the valve flange and stem for damage, wear or deformation.
- 2) Measure the thickness "H" of valve head edge as shown in the figure using a caliper gauge. If it is not within the standard, replace the valve.

NOTE:

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

#### Valve overall length:

##### Intake

**103.3 mm (4.067 in)**

##### Exhaust

**94.1 mm (3.705 in)**

- When the valve is replaced, lap the valve. Refer to "VALVE SEAT" for lapping. <Ref. to ME(H4DO)-229, VALVE SEAT, INSPECTION, Cylinder Head.>

#### Valve head edge thickness H:

##### Intake (A)

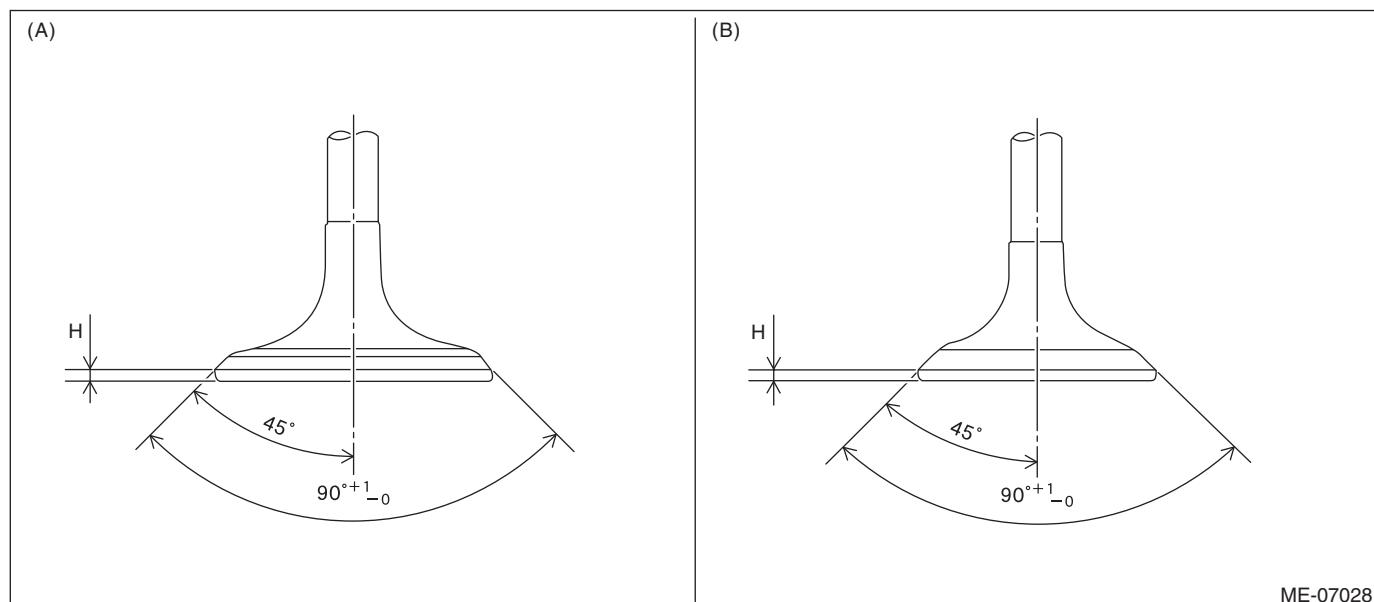
##### Standard

**0.8 — 1.2 mm (0.031 — 0.047 in)**

##### Exhaust (B)

##### Standard

**1.0 — 1.4 mm (0.039 — 0.055 in)**



ME-07028

3) Check the clearance between valve and valve guide. Check the clearance between valve and valve guide by measuring the outer diameter of valve stem and the inner diameter of valve guide respectively.

(1) Measure the outer diameter of valve stem with a micrometer. If it is not within the standard, replace the valve.

**NOTE:**

- Measurement should be performed at a temperature of 20°C (68°F).
- Measure the outer diameter of the valve stem at the six locations as shown in the figure, and read the value of most worn location.
- When the valve is replaced, lap the valve. Refer to "VALVE SEAT" for lapping. <Ref. to ME(H4DO)-229, VALVE SEAT, INSPECTION, Cylinder Head.>

**Valve stem outer diameter:**

**Intake**

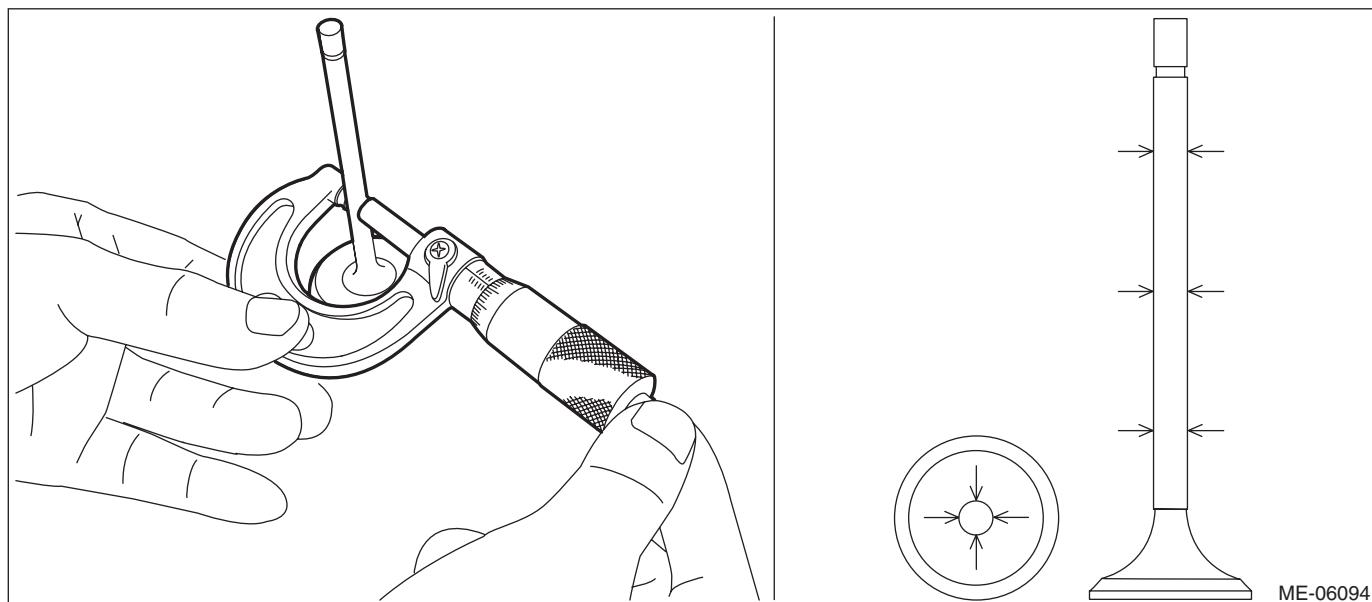
**Standard**

**5.455 — 5.470 mm (0.2148 — 0.2154 in)**

**Exhaust**

**Standard**

**5.445 — 5.460 mm (0.2144 — 0.2150 in)**



# Cylinder Head

## MECHANICAL

(2) Using a caliper gauge, measure the inner diameter of valve guide. If it is not within the standard, replace the valve guide. For replacement procedure, refer to step 4).

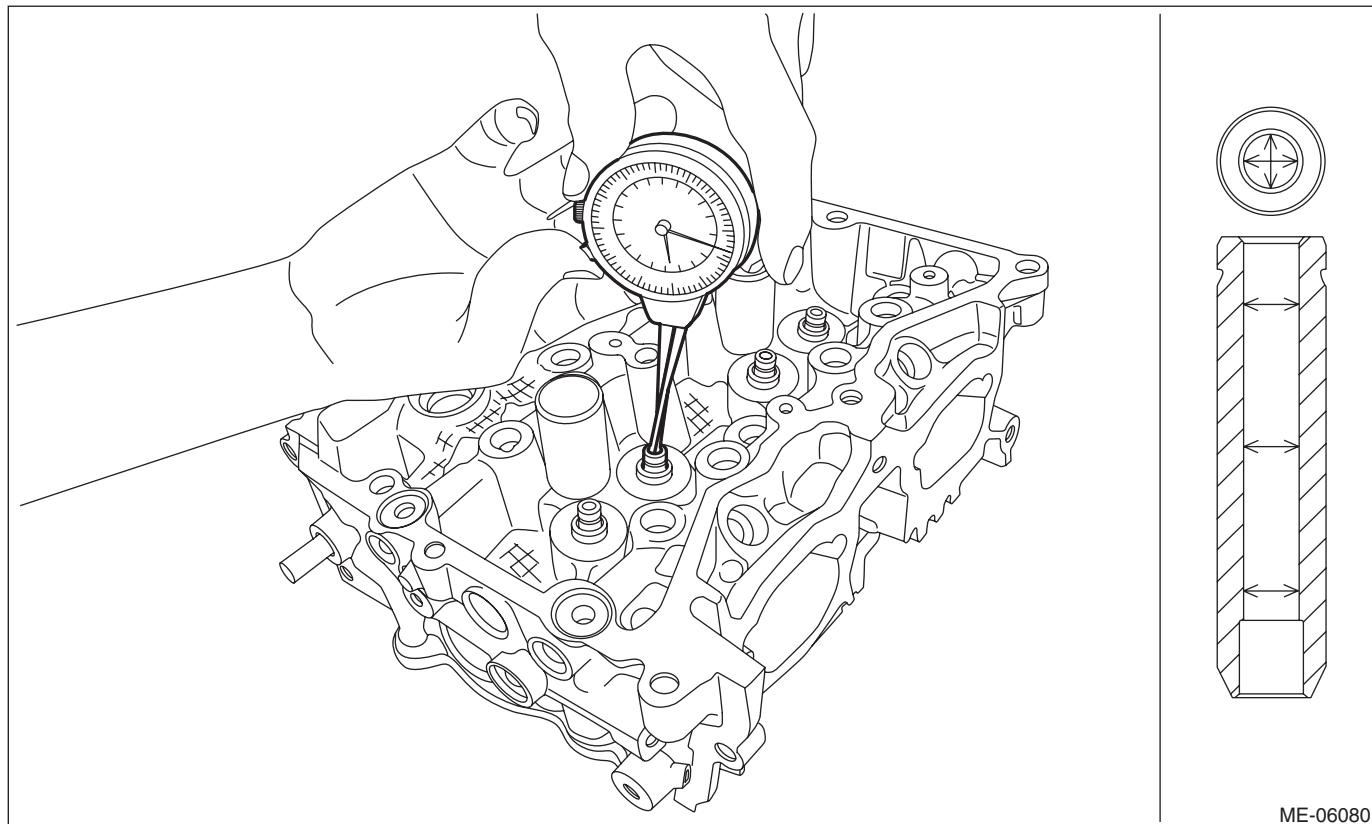
NOTE:

- Measurement should be performed at a temperature of 20°C (68°F).
- Measure the inner diameter of the valve guide at the six locations as shown in the figure, and read the value of most worn location.

**Valve guide inner diameter:**

**Standard**

**5.500 — 5.512 mm (0.2165 — 0.2170 in)**



(3) Calculate the clearance between valve and valve guide.

**Clearance between valve and valve guide:**

**Intake**

**Standard**

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

**Exhaust**

**Standard**

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

4) If the clearance between valve and valve guide exceeds the standard, replace the valve or valve guide, whichever shows the greater amount of wear or damage. For replacement procedure of valve guide, refer to the following.

NOTE:

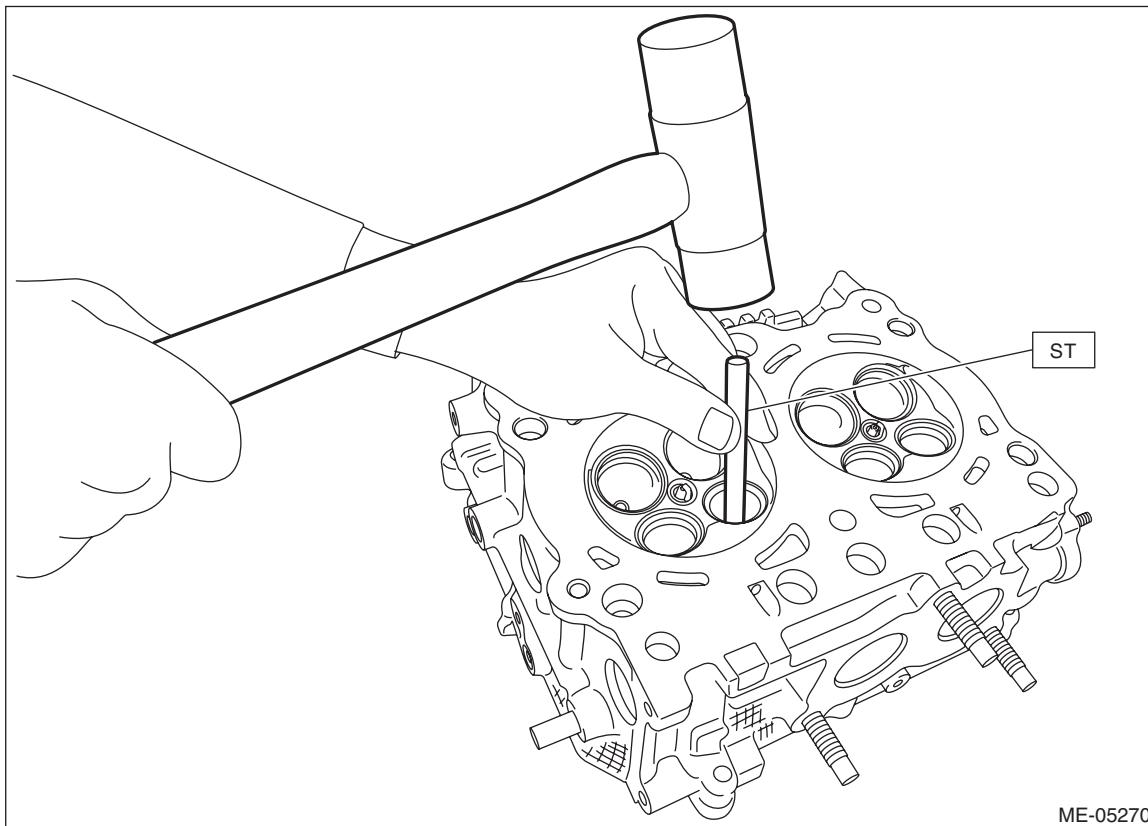
When the valve is replaced, lap the valve. Refer to "VALVE SEAT" for lapping. <Ref. to ME(H4DO)-229, VALVE SEAT, INSPECTION, Cylinder Head.>

(1) Insert ST into the valve guide with the combustion chamber upward and remove the valve guide using plastic hammer.

**CAUTION:**

- Place a wood board wrapped with a waste cloth to stabilize the cylinder head before work.
- Use special care not to damage the cylinder head during work.

ST 499765700 VALVE GUIDE REMOVER AND INSTALLER



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

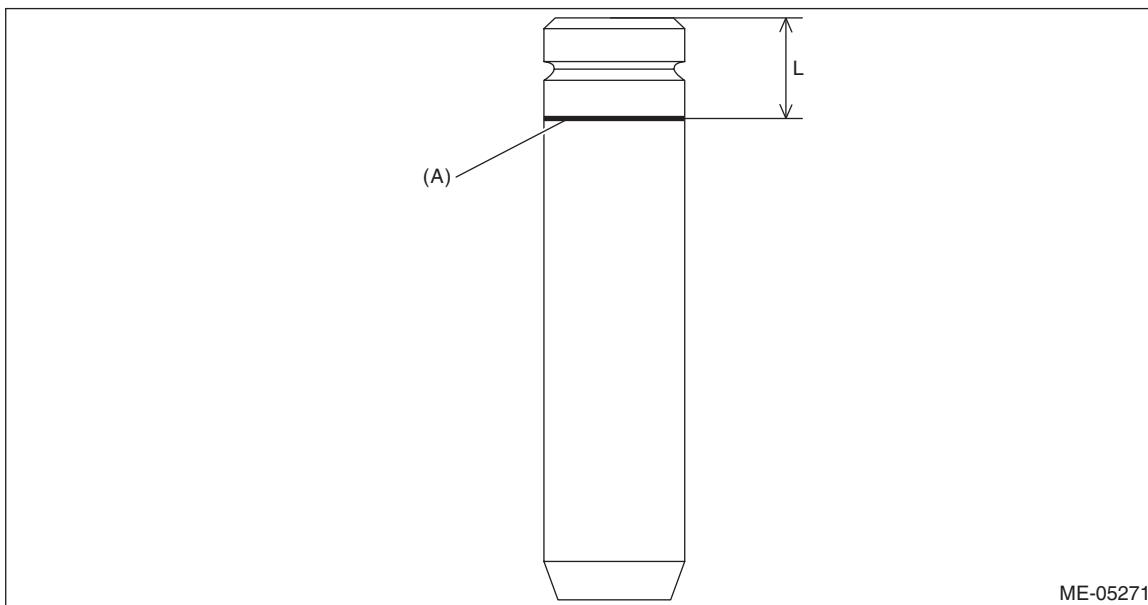
(3) Draw a reference line (A) for insert on the valve guide using a marker as shown in the figure.

NOTE:

- Use a new valve guide.
- A reference line for insert is used as a guide when tapping-in the valve guide.

**Valve guide inserting reference line position L:**

**15 mm (0.5906 in)**



# Cylinder Head

## MECHANICAL

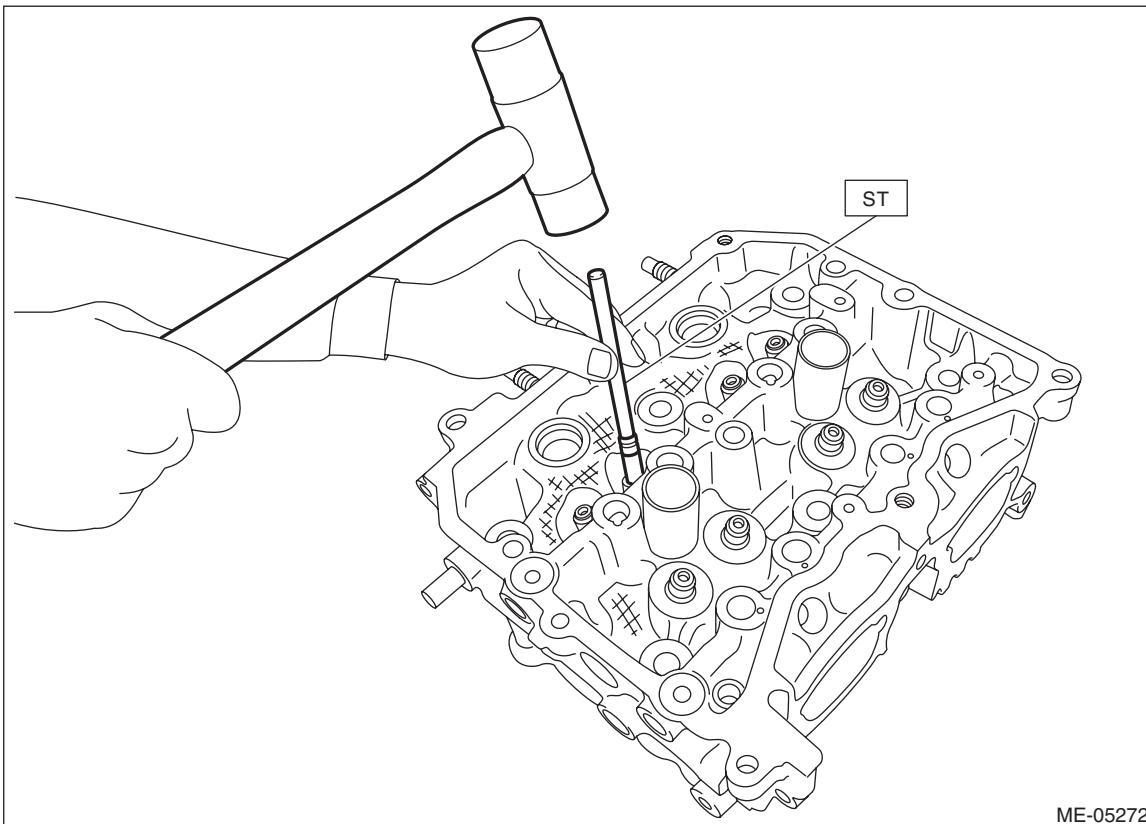
(4) Apply a enough coat of engine oil to the valve guide, and set the valve guide on the cylinder head with the combustion chamber downward.

(5) Insert the ST into the valve guide, and tap-in the valve guide to the reference line (A) for insert using plastic hammer.

### CAUTION:

- During work, place a waste cloth, etc. to avoid scratching the mating surface of the cylinder head.
- Use special care not to damage the cylinder head during work.

ST 499765700 VALVE GUIDE REMOVER AND INSTALLER



(6) Measure the valve guide protrusion amount "L" as shown in the figure using a caliper gauge. Insert the ST into the valve guide again, and tap-in the valve guide so that it is positioned within standard by referring to the measured value using plastic hammer.

### CAUTION:

- During work, place a waste cloth, etc. to avoid scratching the mating surface of the cylinder head.
- Use special care not to damage the cylinder head during work.

### NOTE:

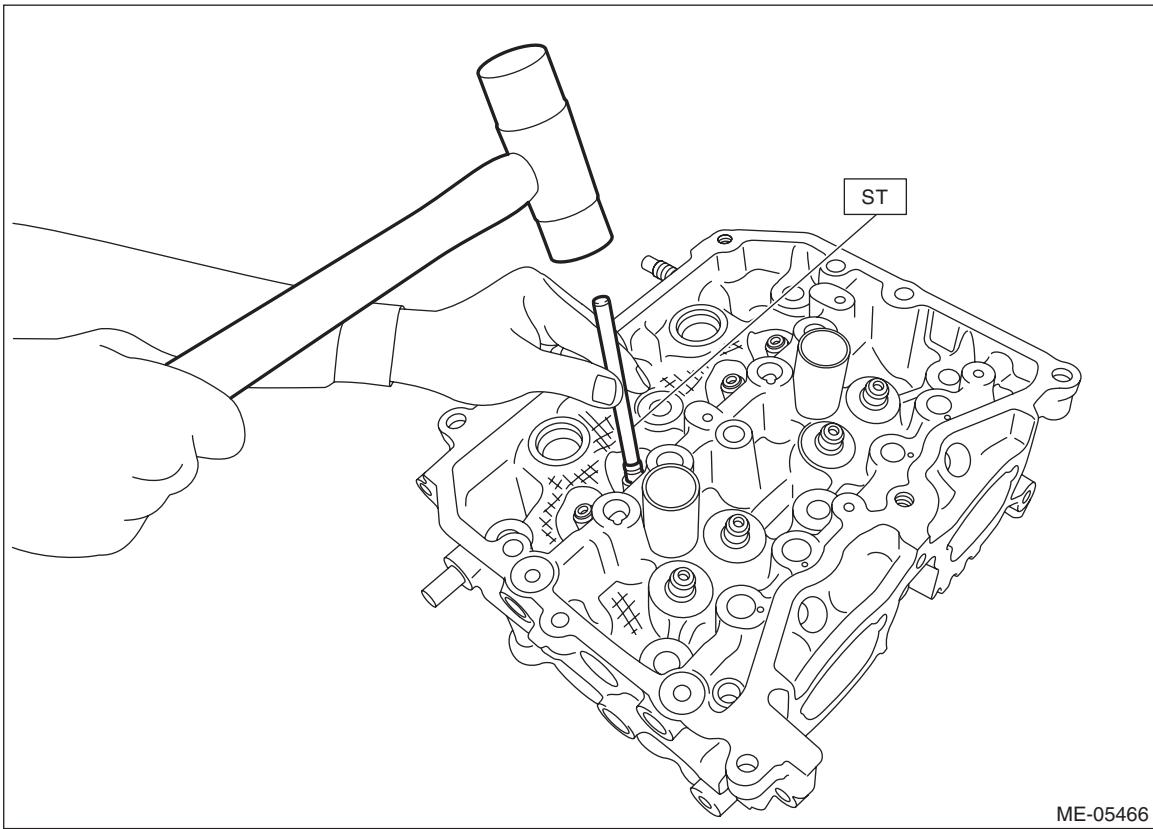
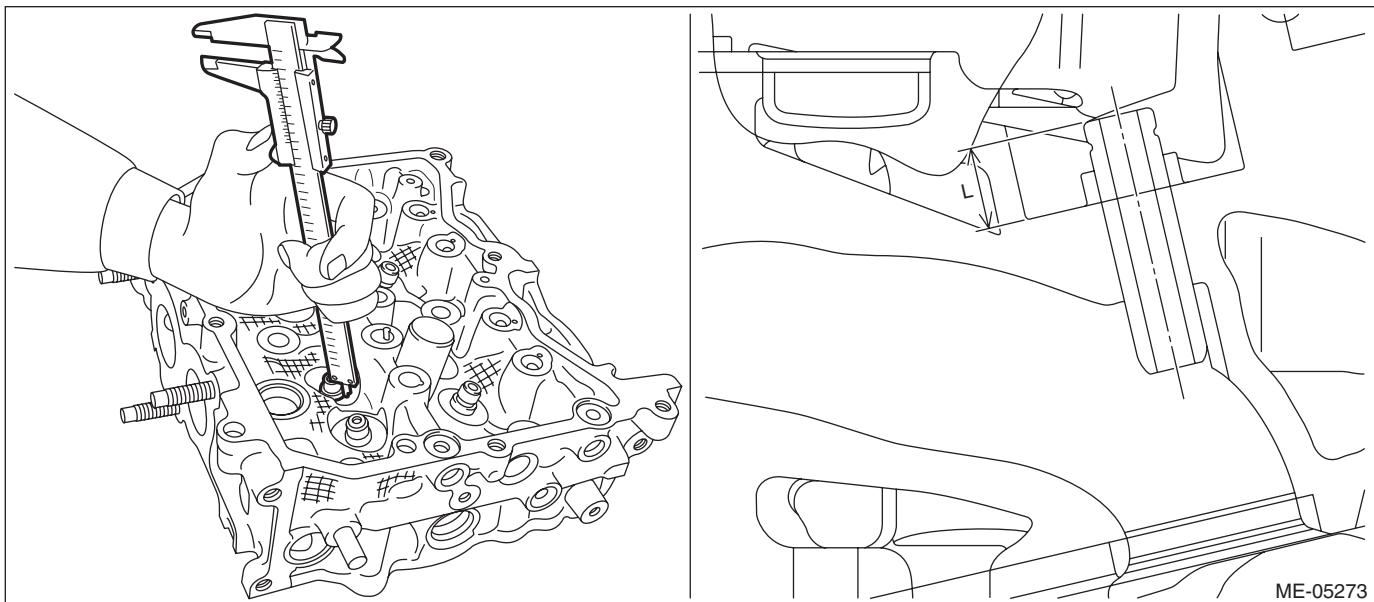
Be careful not to tap-in excessively by repeating the steps of Tapping-in → Measurement → Tapping-in → Measurement ... when installing the valve guide.

ST 499765700 VALVE GUIDE REMOVER AND INSTALLER

**Valve guide protrusion amount L:**

**Standard**

**11.4 — 11.8 mm (0.449 — 0.465 in)**



# Cylinder Head

## MECHANICAL

(7) Ream the inside of valve guide with the combustion chamber upward using the 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.

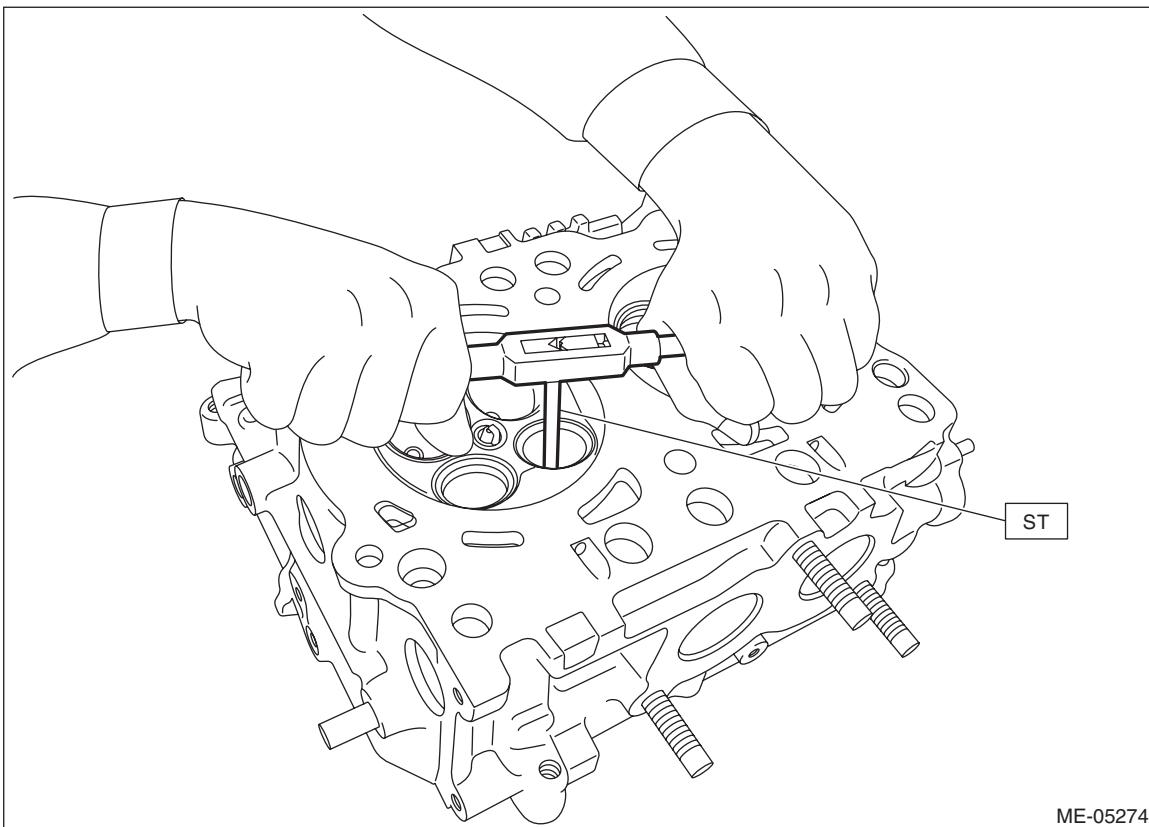
### CAUTION:

- Place a wood board wrapped with a waste cloth to stabilize the cylinder head before work.
- Use special care not to damage the cylinder head during work.

### NOTE:

- Apply engine oil to the ST.
- If the inner surface of valve guide is damaged, the edge of ST should be slightly ground with oil stone.
- If the inner surface of valve guide becomes lustrous and the ST does not chip, use a new ST or remedy the ST.

ST 499765900 VALVE GUIDE REAMER



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

(9) Check the seating width between valve and valve seat. <Ref. to ME(H4DO)-229, VALVE SEAT, INSPECTION, Cylinder Head.>

## 3. VALVE & VALVE SHIM

- 1) Visually check the valve shim for damage.
- 2) Check the clearance between valve and valve shim. Check the clearance between valve and valve shim by measuring the outer diameter of valve stem end and the inner diameter of valve shim respectively.
  - (1) Measure the outer diameter of valve stem end with a micrometer. If it is not within the standard, replace the valve.

NOTE:

- Measurement should be performed at a temperature of 20°C (68°F).
- Measure the outer diameter of the valve stem end at the two locations as shown in the figure, and read the value of most worn location.
- When the valve is replaced, lap the valve. Refer to "VALVE SEAT" for lapping. <Ref. to ME(H4DO)-229, VALVE SEAT, INSPECTION, Cylinder Head.>

### Valve stem end outer diameter:

*Intake*

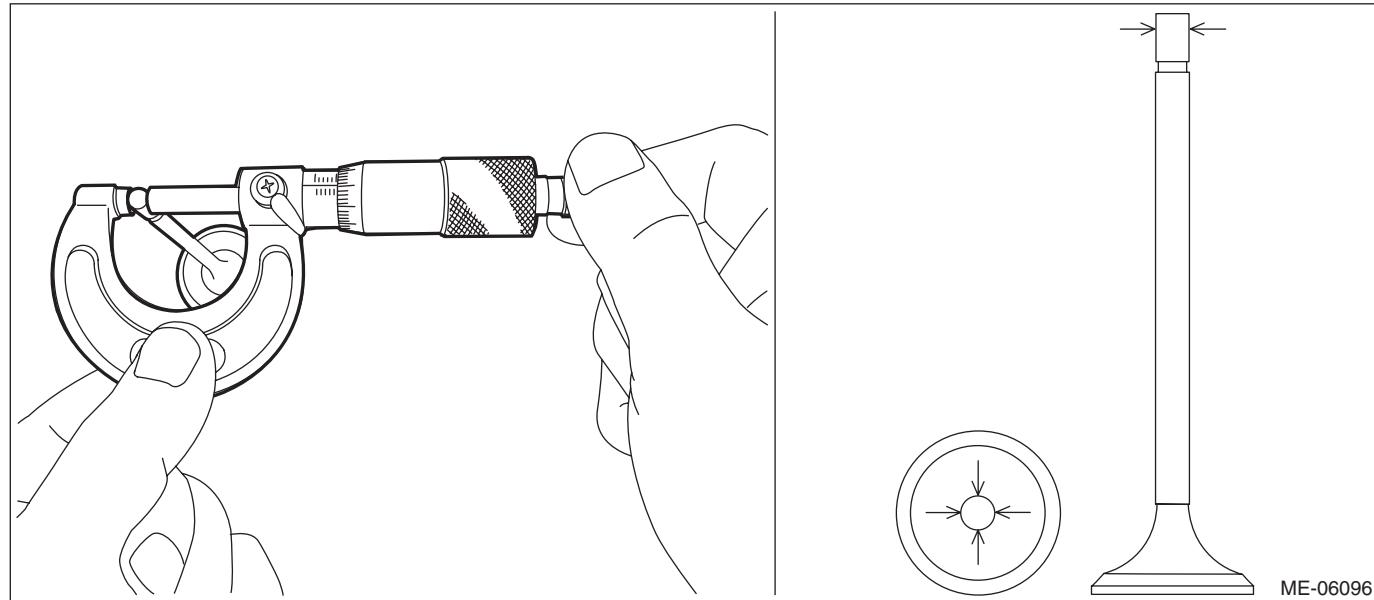
*Standard*

**5.455 — 5.470 mm (0.2148 — 0.2154 in)**

*Exhaust*

*Standard*

**5.445 — 5.460 mm (0.2144 — 0.2150 in)**



# Cylinder Head

## MECHANICAL

(2) Using a caliper gauge, measure the inner diameter of valve shim. If it is not within the standard, replace the valve shim.

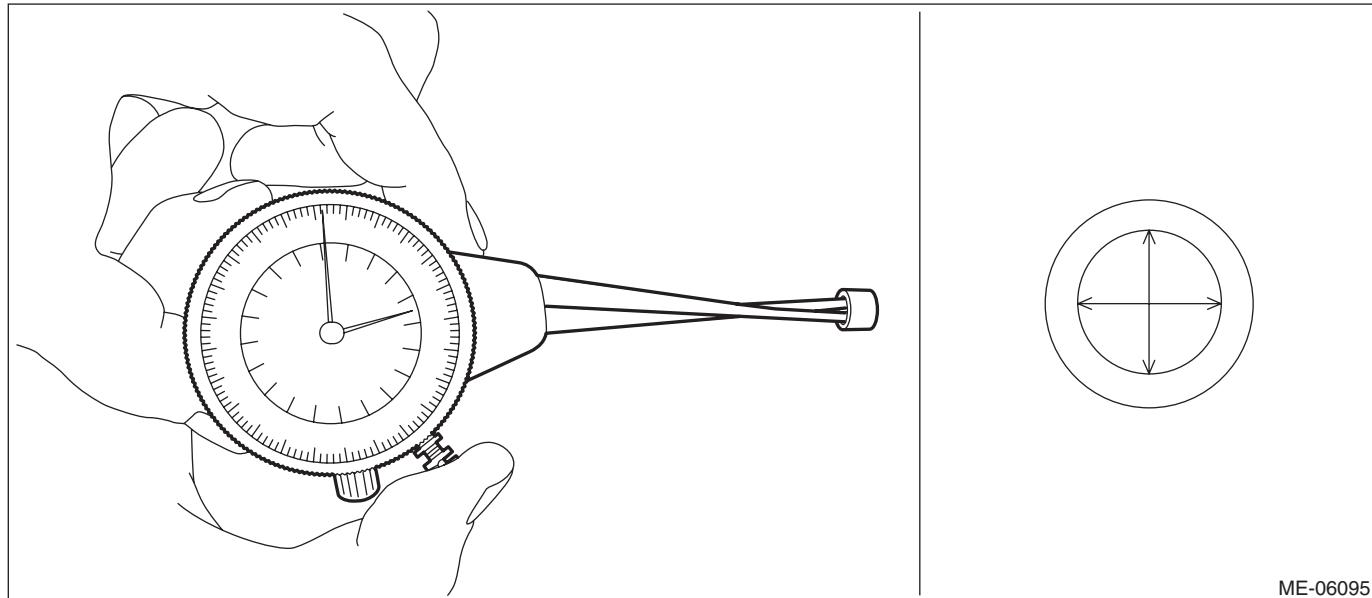
### NOTE:

- Measurement should be performed at a temperature of 20°C (68°F).
- Measure the inner diameter of the valve shim at the two locations as shown in the figure, and read the value of most worn location.
- If the valve shim has to be replaced, check the cam clearance and replace with the suitable valve shim.  
<Ref. to ME(H4DO)-41, WHEN TIMING CHAIN ASSEMBLY IS REMOVED, INSPECTION, Cam Clearance.>

### Valve shim inner diameter:

#### Standard

5.500 — 5.560 mm (0.2165 — 0.2189 in)



(3) Calculate the clearance between valve and valve shim. If the clearance exceeds the standard, replace the valve or valve shim, whichever shows the greater amount of wear or damage.

### NOTE:

- When the valve is replaced, lap the valve. Refer to "VALVE SEAT" for lapping. <Ref. to ME(H4DO)-229, VALVE SEAT, INSPECTION, Cylinder Head.>
- If the valve shim has to be replaced, check the cam clearance and replace with the suitable valve shim.  
<Ref. to ME(H4DO)-41, WHEN TIMING CHAIN ASSEMBLY IS REMOVED, INSPECTION, Cam Clearance.>

### Clearance between valve and valve shim:

#### Intake

#### Standard

0.030 — 0.105 mm (0.0012 — 0.0041 in)

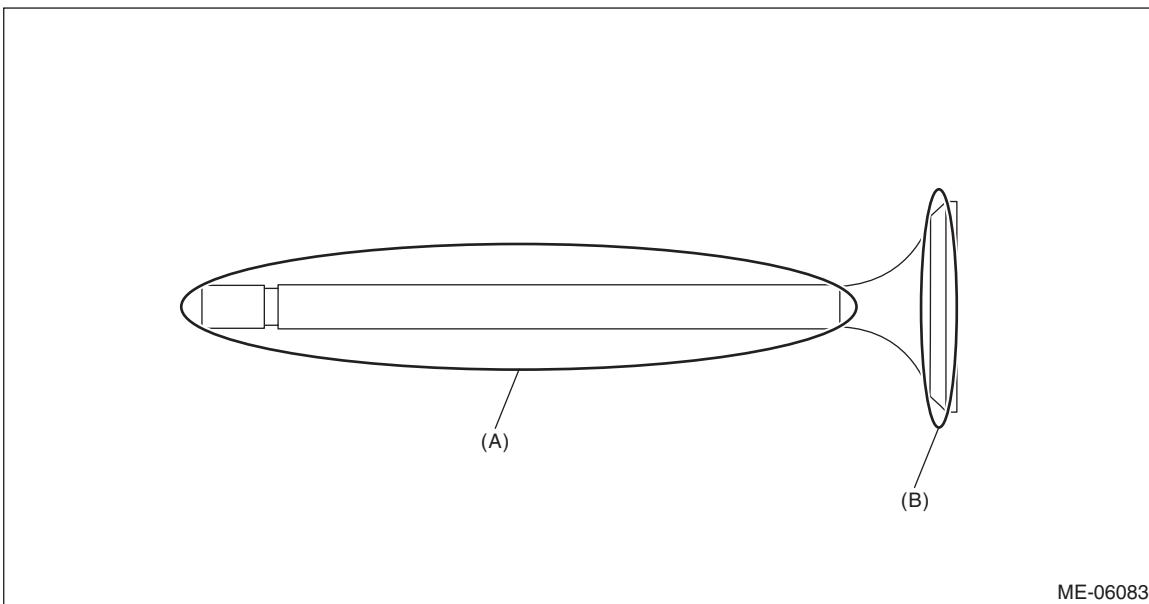
#### Exhaust

#### Standard

0.040 — 0.115 mm (0.0016 — 0.0045 in)

## 4. VALVE SEAT

- 1) Check the valve seat for damage and deformation.
- 2) Check the seating width and seating position between valve and valve seat for the intake valve seat and exhaust valve seat.
  - (1) Clean the valve and valve seat.
  - (2) Coat the stem (A) of the valve lightly with engine oil and apply red dye evenly on the valve face (B).



- (3) Using the valve lapper, slowly insert the valve with red dye applied into the valve guide. Lightly press the valve against the valve seat without turning the valve, and then slowly pull out the valve.

# Cylinder Head

## MECHANICAL

(4) Check the seating width "W" of valve seat as shown in the figure, using a caliper gauge. Check the seating width "W" between valve and valve seat by measuring the width of red dye on the seating surface of valve seat. If the seating width "W" between valve and valve seat is out of the standard, correct the seating surface of valve seat using the valve seat cutter. For correcting procedures of the valve seat seating surface, refer to step 3).

### NOTE:

- When the red dye does not appear seamlessly on the valve seat seating surface, lap the valve. For lapping procedure, refer to step 4).
- When the red dye does not appear seamlessly on the valve seat seating surface even after lapping the valve, correct the valve seat seating surface using the valve seat cutter. For correcting procedures of the valve seat seating surface, refer to step 3).

### **Seating width W between valve and valve seat:**

#### **Intake**

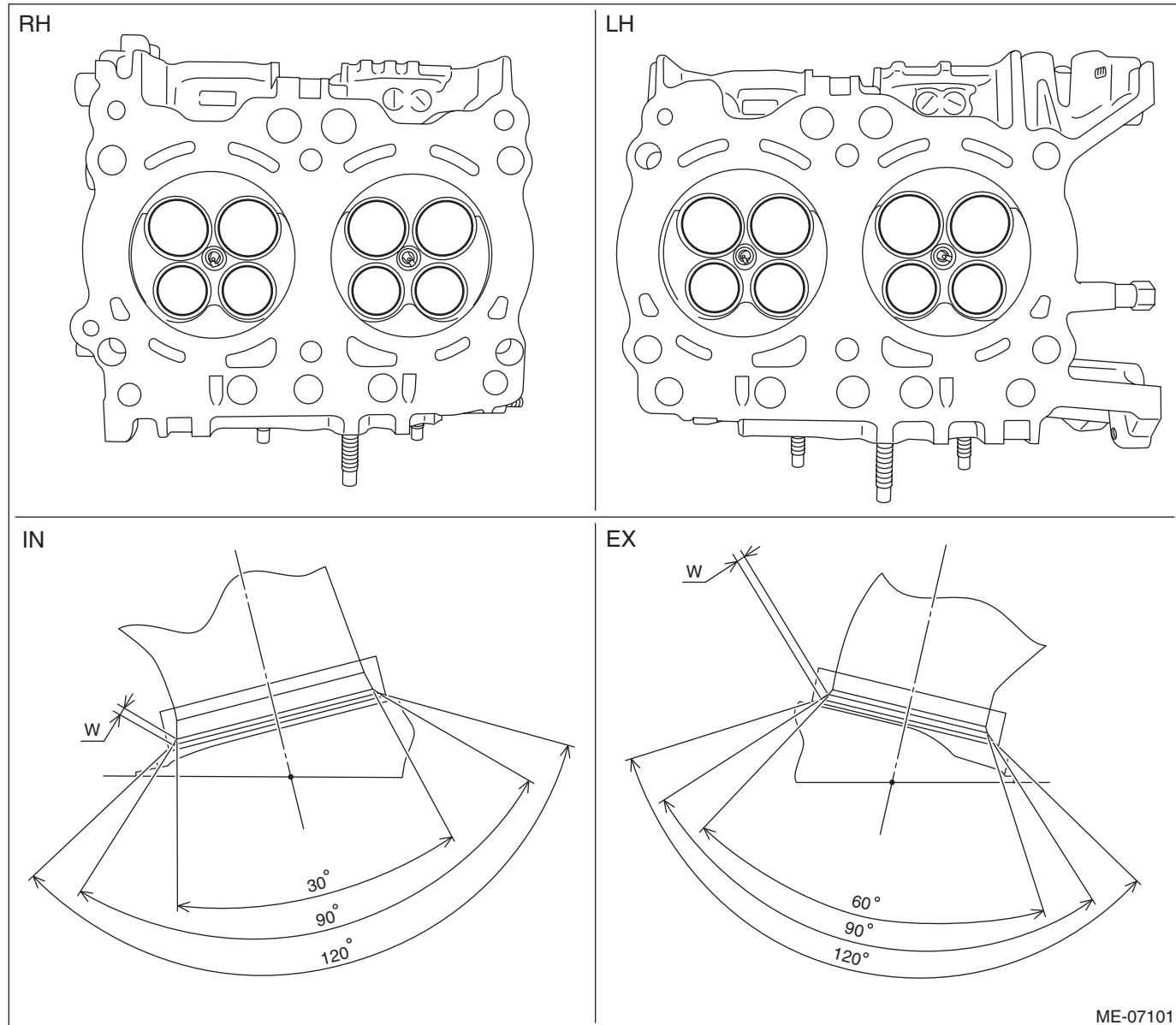
#### **Standard**

**0.8 — 1.6 mm (0.031 — 0.063 in)**

#### **Exhaust**

#### **Standard**

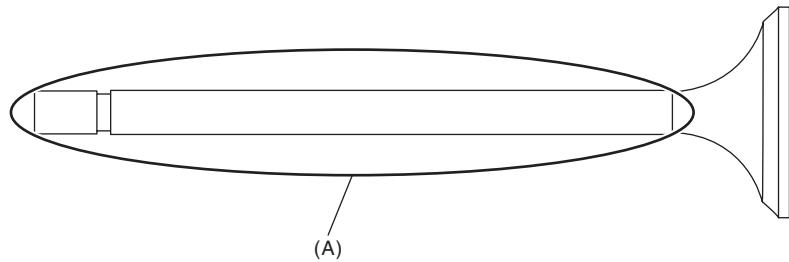
**1.1 — 1.7 mm (0.043 — 0.067 in)**



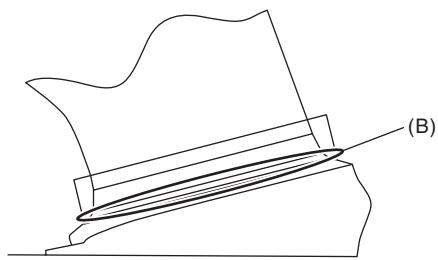
# Cylinder Head

## MECHANICAL

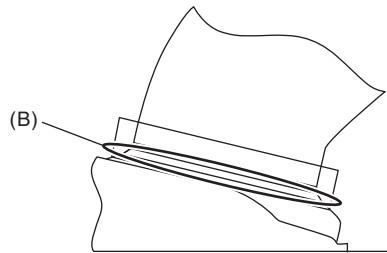
- (5) Wipe off the red dye on the valve and valve seat completely.
- (6) Coat the stem (A) of the valve lightly with engine oil and apply red dye evenly on the seating surface (B) between valve and valve seat.



IN



EX



ME-06084

- (7) Using the valve lapper, slowly insert the valve into the valve guide. Lightly press the valve against the valve seat without turning the valve, and then slowly pull out the valve.

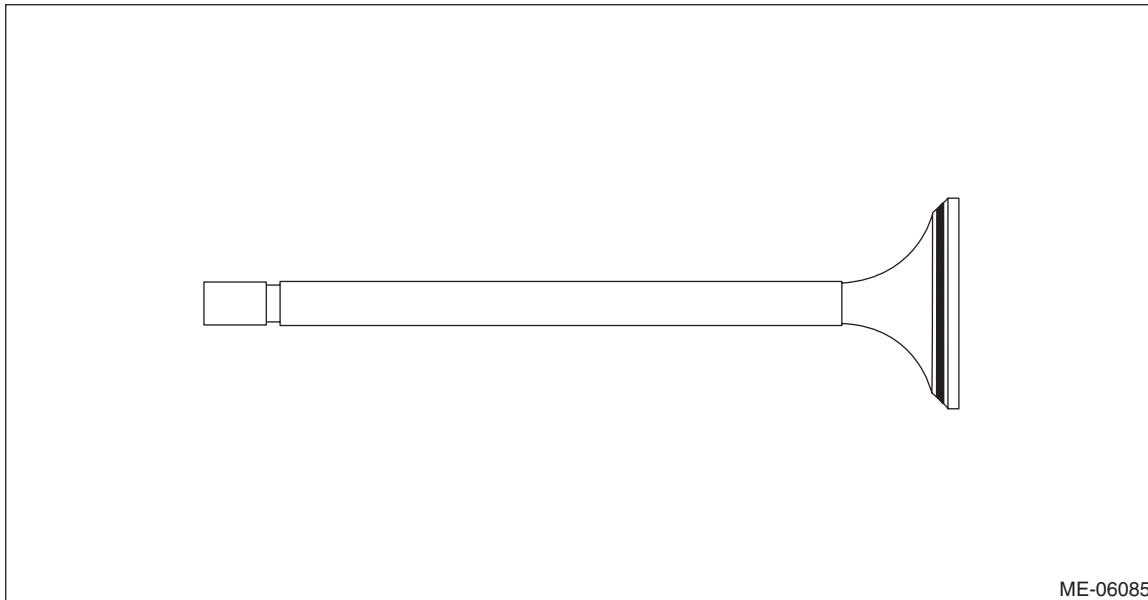
# Cylinder Head

## MECHANICAL

(8) Check the seating position between valve and valve seat. Check the seating position between valve and valve seat by checking the position of red dye on the valve face. If the seating position between valve and valve seat is not at the center of valve face, correct the seating surface of valve seat using the valve seat cutter. For correcting procedures of the valve seat seating surface, refer to step 3).

### **Seating position between valve and valve seat:**

#### **Valve face center**



(9) After inspection, wipe off the red dye completely.  
3) When correcting the seating surfaces of valve seat  
(1) Correct the seating angle between valve and valve seat using the 45° valve seat cutter.

#### NOTE:

- Select the size of the valve seat cutter by referring to the outer diameters of the intake valve and exhaust valve.

#### **Valve outer diameter:**

##### **Intake**

##### **Standard**

**33.9 — 34.1 mm (1.335 — 1.343 in)**

##### **Exhaust**

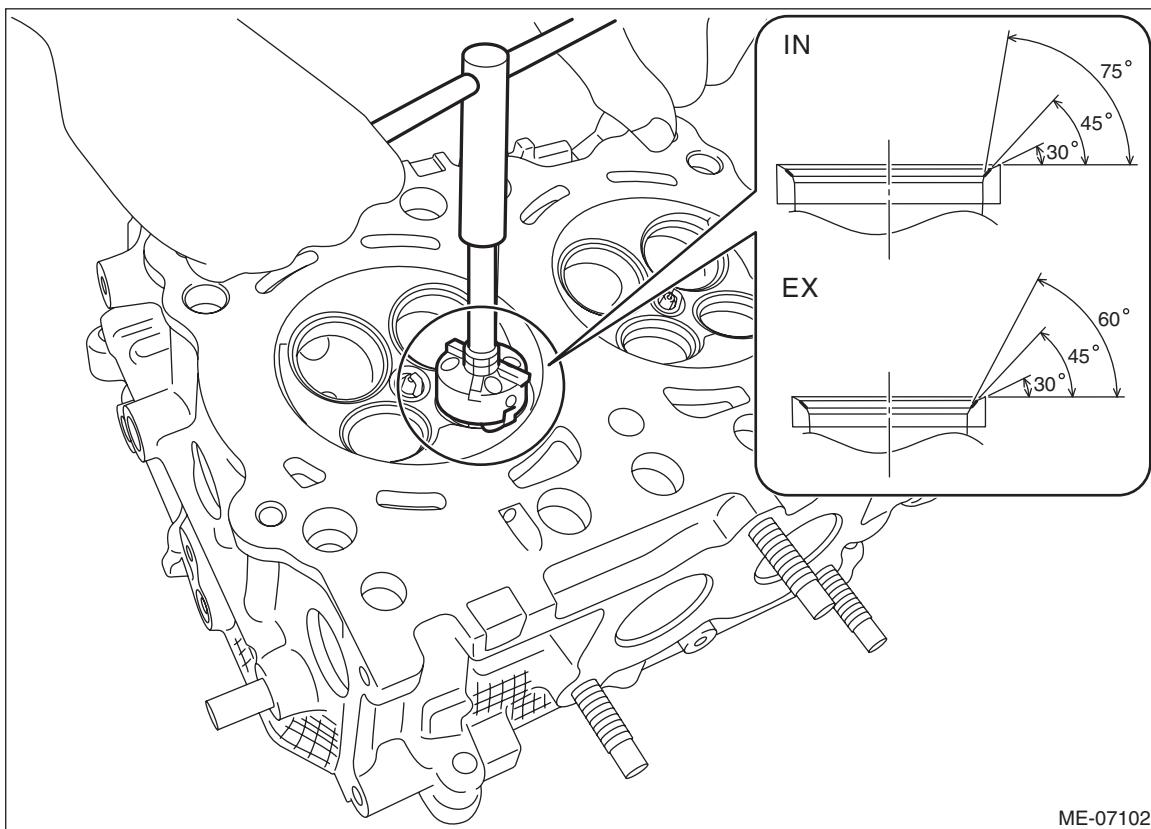
##### **Standard**

**27.9 — 28.1 mm (1.098 — 1.106 in)**

- Grind the seating surface so that the seating width between valve and valve seat becomes slightly larger than the standard value.
- Gradually reduce pressure at the end of grinding process in order to avoid creating a gap on the valve seat correcting surface.

### Seating angle between valve and valve seat:

45°



(2) Lap the valve. For lapping procedure of the valve, refer to step 4).

(3) Check the seating position between valve and valve seat. For inspection of the seating position between valve and valve seat, refer to step 2).

#### NOTE:

This procedure is necessary to select a seat cutter to be used in step (4).

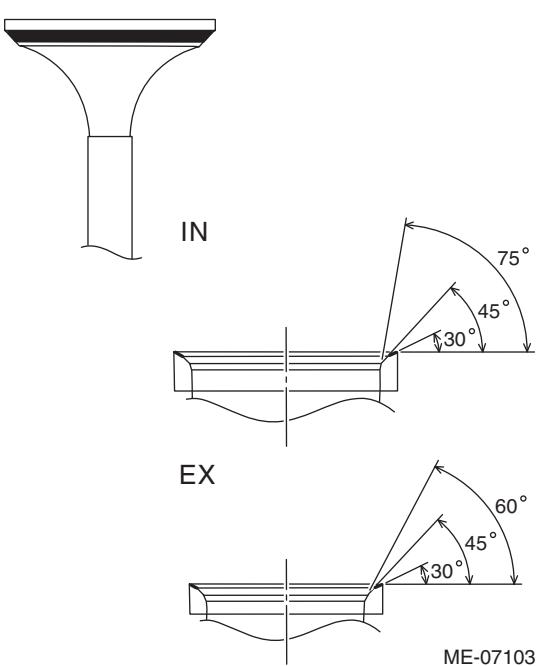
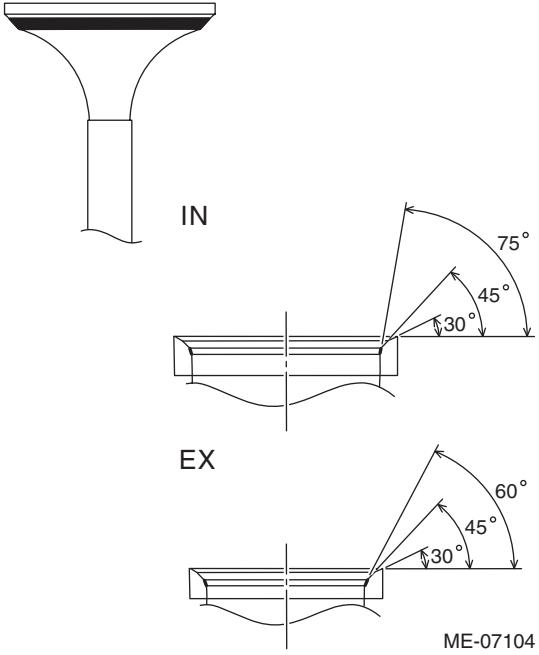
# Cylinder Head

## MECHANICAL

(4) Using the 30°, 75° (IN) or 60° (EX) seat cutter, correct the valve seat so that the seating width between valve and valve seat becomes the standard value.

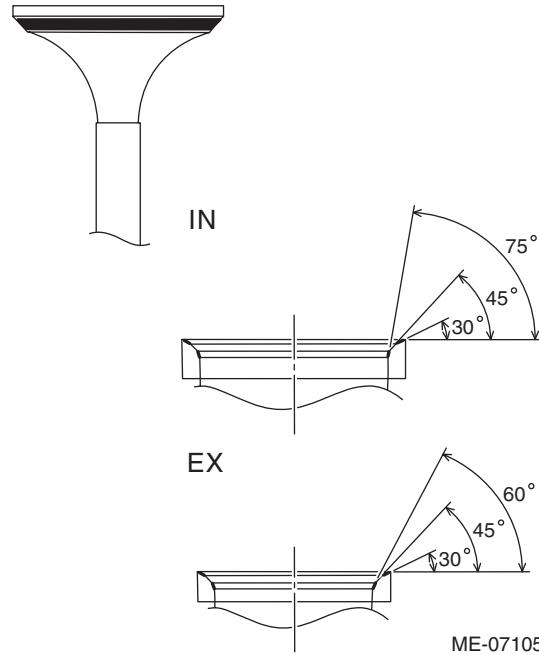
### NOTE:

- Select a proper valve seat cutter according to the following table.

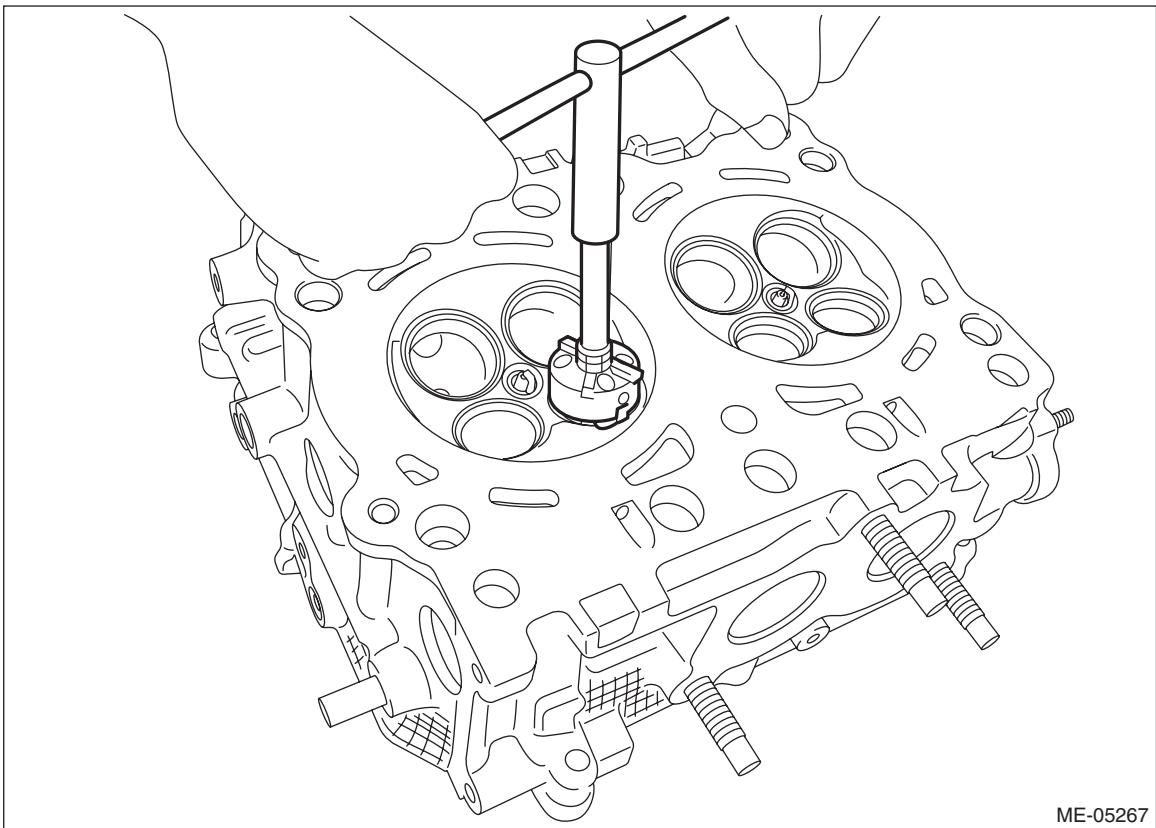
Seating position between valve and valve seat	Seat cutter selection
 <p>IN</p> <p>EX</p> <p>ME-07103</p>	When the seating position of valve face is high, grind the surface using the 30° seat cutter until seating width between valve and valve seat becomes the standard value.
 <p>IN</p> <p>EX</p> <p>ME-07104</p>	When the seating position of valve face is low, grind the surface using the 75° (IN) or 60° (EX) seat cutter until seating width between valve and valve seat becomes the standard value.

# Cylinder Head

## MECHANICAL

Seating position between valve and valve seat	Seat cutter selection
 <p>IN</p> <p>EX</p> <p>ME-07105</p>	<p>When the seating position of valve face is at center, grind the surface evenly using the 30°, 75° (IN) or 60° (EX) seat cutters until seating width between valve and valve seat becomes the standard value.</p>

- Gradually reduce pressure at the end of grinding process in order to avoid creating a gap on the valve seat correcting surface.



(5) Lap the valve. For lapping procedure of the valve, refer to step 4).

# Cylinder Head

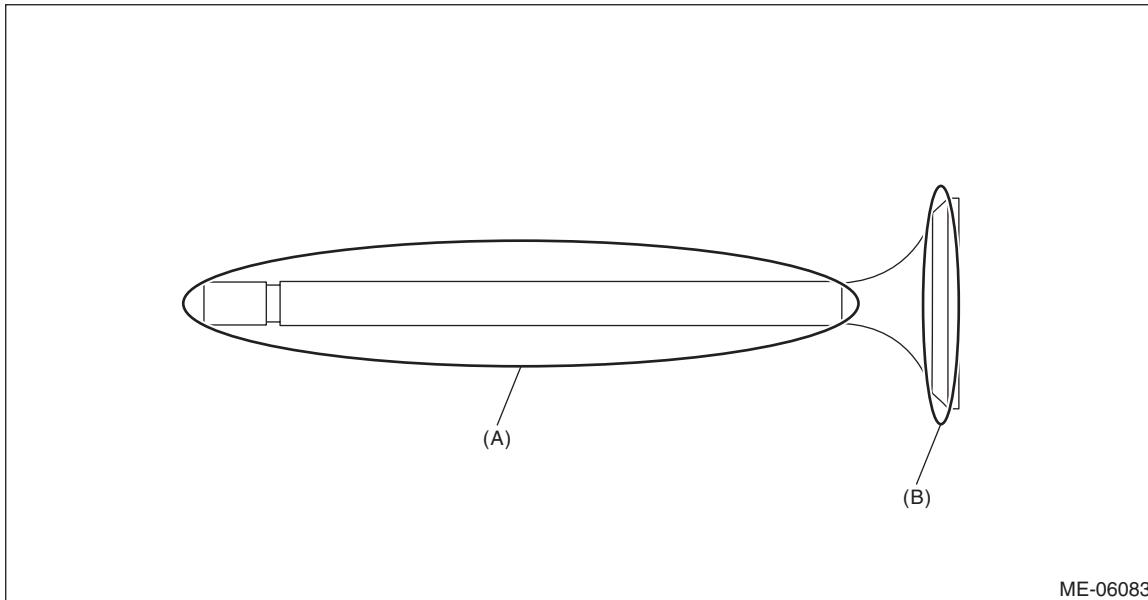
## MECHANICAL

### 4) When lapping the valve

- (1) Coat the stem (A) of the valve lightly with engine oil and put a small amount of valve compound evenly on the valve face (B).

#### NOTE:

- Be careful not to put the valve compound more than necessary.
- To avoid damaging the valve guide and valve stem, be careful not to let the valve compound contact the valve stem.



- (2) Using the valve lapper, slowly insert the valve with the valve compound applied into the valve guide, and lap the seating surface between valve and valve seat. First, lift the valve and strike it against the valve seat twice, and then slightly turn the valve once. Repeat these steps as one set.

#### NOTE:

- To prevent the seating width between valve and valve seat from exceeding the standard value, be careful not to keep turning the valve while pressing it against the valve seat during lapping.
- Be careful not to lift the valve too far during lapping in order to prevent the valve from coming off the valve guide.

- (3) Wipe off the valve compound on the valve and valve seat completely after lapping.

#### NOTE:

Be careful not to leave any valve compound in order to avoid malfunction.

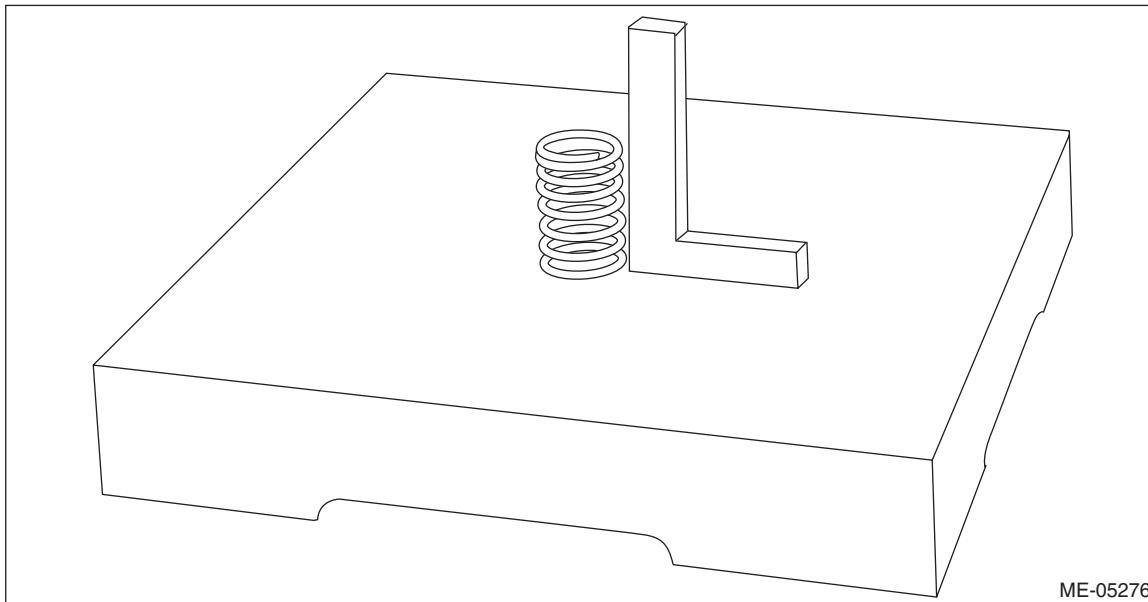
- (4) Check the seating width and seating position between valve and valve seat.

## 5. VALVE SPRING

- 1) Check the valve spring for damage and deformation.
- 2) Using a caliper gauge, valve spring tester, surface plate and try square, check the valve spring free length, tension/spring height and squareness. If it is not within the standard, replace the valve spring.

NOTE:

- Measurement should be performed at a temperature of 20°C (68°F).
- To check the squareness of the valve spring, stand the valve spring on a surface plate and check its deflection at the top of the valve spring using a try square.



**Valve spring free length:**

**Standard**

**41.06 mm (1.617 in)**

**Valve spring tension/spring height:**

**Set**

**Standard**

**182 — 210 N (18.56 — 21.41 kgf, 40.92 — 47.22 lbf)/33.0 mm (1.299 in)**

**Lift**

**Standard**

**552 — 610 N (56.29 — 62.20 kgf, 124.11 — 137.15 lbf)/22.0 mm (0.866 in)**

**Valve spring squareness:**

**Standard**

**2.5°, 1.8 mm (0.071 in) or less**