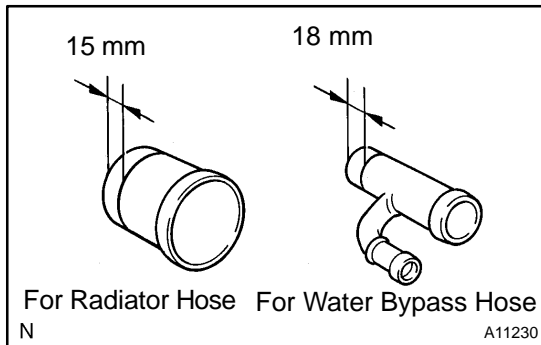


REASSEMBLY

HINT:

- Thoroughly clean all parts to be assembled.
- Before installing the parts, apply fresh engine oil to all sliding and rotating surfaces.
- Replace oil seals with new ones.

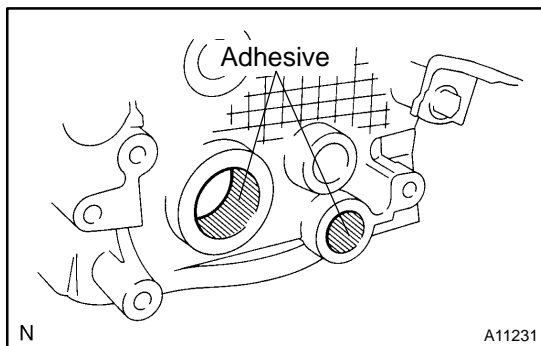


1. INSTALL WATER HOSE UNIONS

HINT:

When using a new cylinder head, water hose unions must be installed.

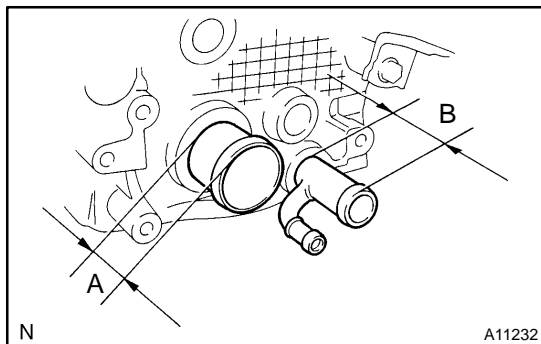
- (a) Mark the standard position away from the edge, onto the water hose union.



- (b) Apply adhesive to the water hose union hole of the cylinder head.

Adhesive:

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



- (c) Using a press, press in a new water hose union until there is protruding from the cylinder head.

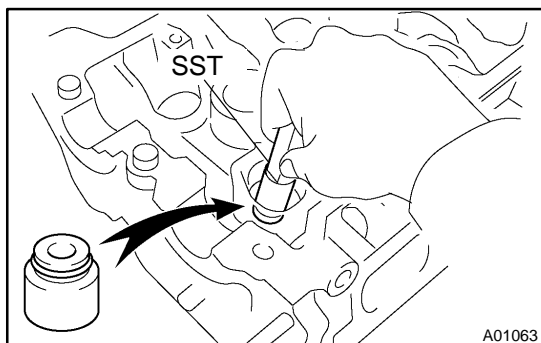
Standard protrusion:

A 29 mm (1.14 in.)

B 44 mm (1.73 in.)

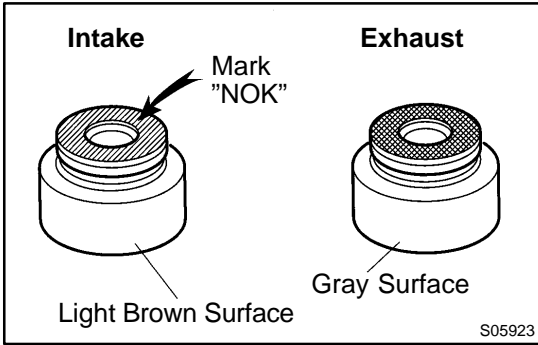
NOTICE:

Avoid pressing a new water hose union in too far by measuring the amount of protrusion while pressing.



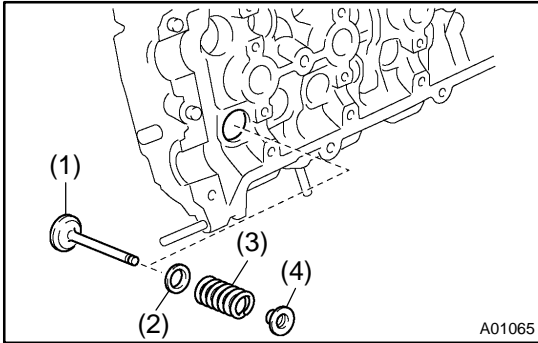
2. INSTALL VALVES

- (a) Using SST, push in a new oil seal.
SST 09201-41020

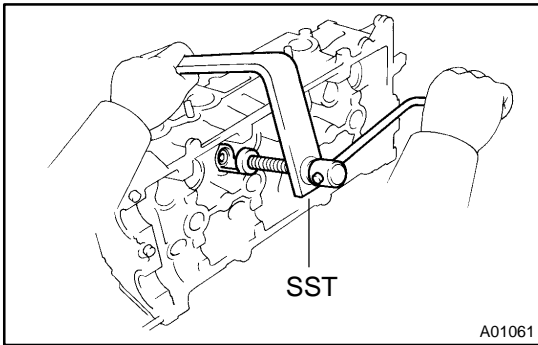


HINT:
The intake valve oil seal is light brown and the exhaust valve oil seal is gray.

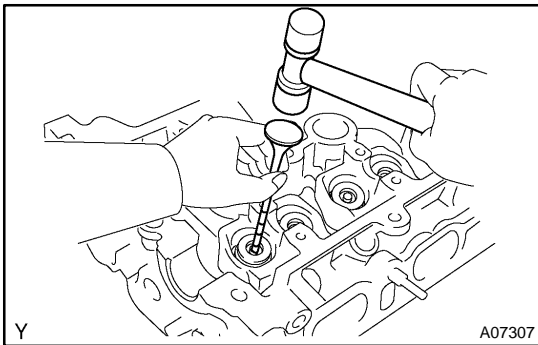
NOTICE:
Pay much attention assembling the oil seal for intake and exhaust. Assembling the wrong one may cause a failure.



(b) Install the valve (1), spring (2), valve spring (3), and spring retainer (4).



(c) Using SST, compress the valve spring and place the 2 keepers around the valve stem.
SST 09202-70020 (09202-00010)



(d) Using a plastic-faced hammer and the valve stem (not in use) tip wound with vinyl tape, lightly tap the valve stem tip to ensure a proper fit.

NOTICE:
Be careful not to damage the valve stem tip.

3. INSTALL VALVE LIFTERS

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