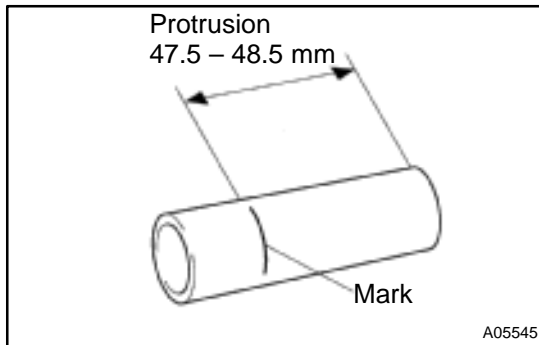


REASSEMBLY

HINT:

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



1. INSTALL SPARK PLUG TUBES

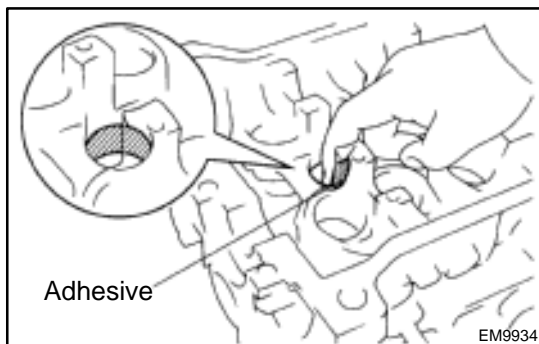
HINT:

When using a new cylinder head, spark plug tubes must be installed.

- (a) Mark the standard position away from the edge, onto the spark plug tube.

Standard protrusion:

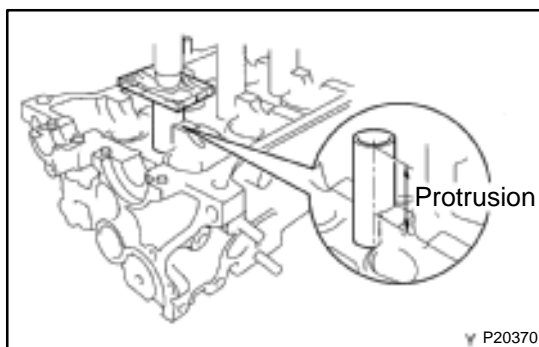
47.5 – 48.5 mm (1.870 – 1.909 in.)



- (b) Apply adhesive to the spark plug tube hole of the cylinder head.

Adhesive:

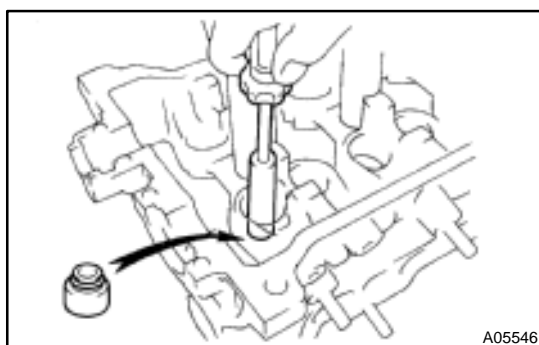
**Part No. 08833-00070, Adhesive 1324,
THREE BOND 1324 or equivalent**



- (c) Using a press, press in a new spark plug tube until there is standard protrusion protruding from the camshaft bearing cap installation surface of the cylinder head.

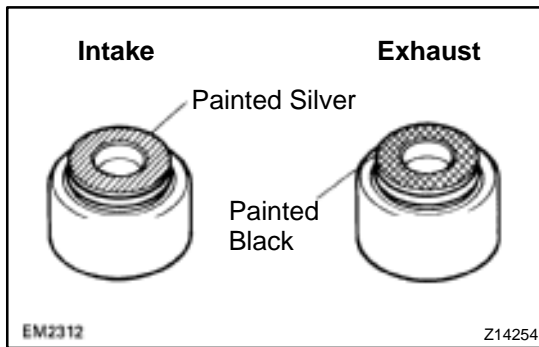
NOTICE:

Avoid pressing a new spark plug tube in too far by measuring the amount of protrusion while pressing.



2. INSTALL VALVES

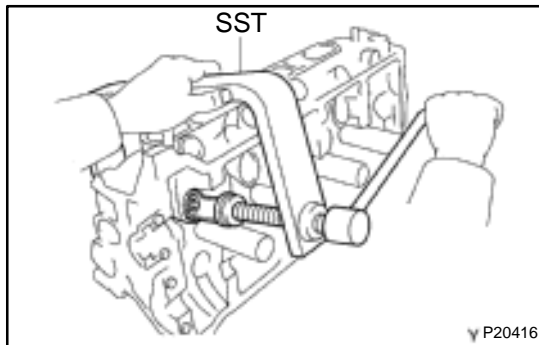
- (a) Using a 10 mm socket-driver, push in a new oil seal.

**HINT:**

The intake valve oil seal is silver and the exhaust valve oil seal is black.

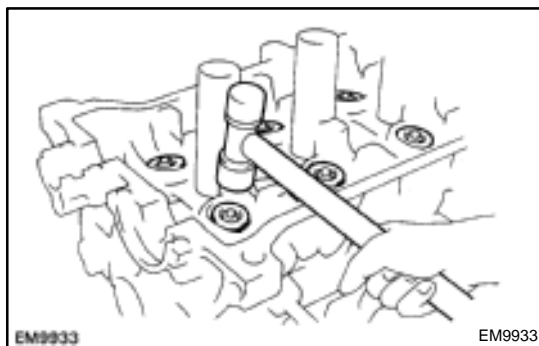
(b) Install these parts:

- (1) Valve
- (2) Spring seat
- (3) Valve spring
- (4) Spring retainer



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

SST 09202-70020



(d) Using a plastic-faced hammer, lightly tap the valve stem tip to assure proper fit.

3. INSTALL VALVE LIFTERS AND SHIMS

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

4. INSTALL STUD BOLT FOR CYLINDER HEAD COVER**5. INSTALL NO.2 ENGINE HANGER**

Torque: 53 N·m (530 kgf-cm, 38 ft-lbf)