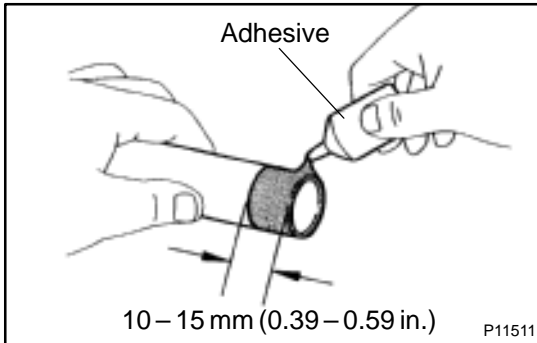


## REASSEMBLY

### 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

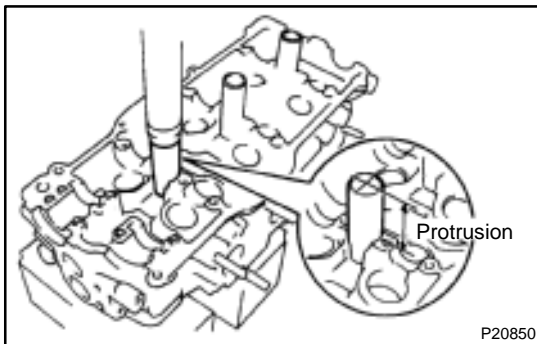
#### HINT:

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

- (a) Apply adhesive to the end of a spark plug tube.

#### Adhesive:

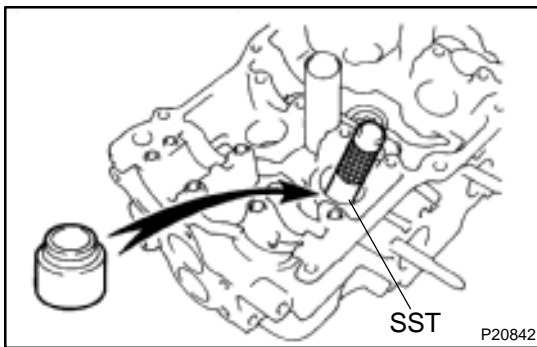
**Part No. 08833-00070, THREE BOND 1324 or equivalent**



- (b) Using a press, press in the spark plug tube until there is 49.0 – 49.4 mm (1.929 – 1.945 in.) protruding from the camshaft bearing cap installation surface of the cylinder head.

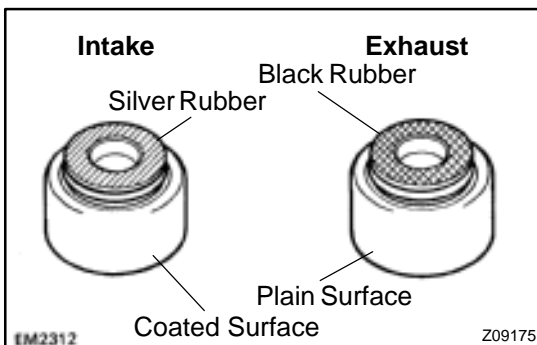
#### NOTICE:

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



### 2. INSTALL VALVES

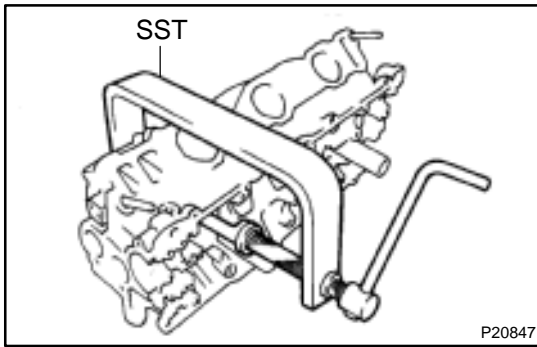
- (a) Using SST, push in a new oil seal.  
SST 09201-41020



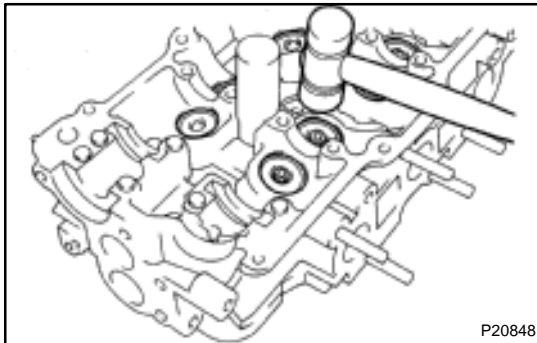
#### HINT:

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

- (b) Install the valve, spring seat, valve spring and spring retainer.



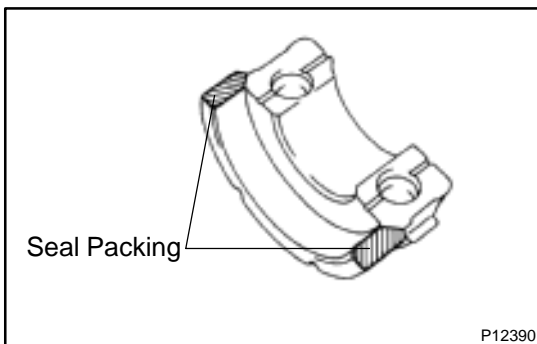
- (c) Using SST, compress the valve spring and place the 2 keepers around the valve stem.  
SST 09202-70020



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

### 3. INSTALL VALVE LIFTERS AND SHIMS

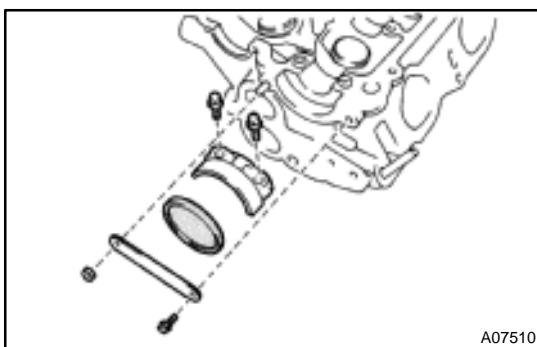
- (a) Install the valve lifter and shim.  
(b) Check that the valve lifter rotates smoothly by hand.



### 4. INSTALL CAMSHAFT HOUSING PLUGS

- (a) Remove any old packing (FIPG) material.  
(b) Apply seal packing to the bearing cap as shown in the illustration.

**Seal packing: Part No. 08826-00080 or equivalent**



- (c) Place a new housing plug in position on the cylinder head, facing the cup side inward.  
(d) Install the camshaft bearing cap with the 2 bolts.  
**Torque: 16 N·m (160 kgf-cm, 12 ft-lbf)**  
(e) Install the rear plate with the bolt and nut.  
**Torque: 8 N·m (80 kgf-cm, 71 in.-lbf)**