

Check mating surface between cylinder and cylinder head for contamination. If so, clean both surfaces.

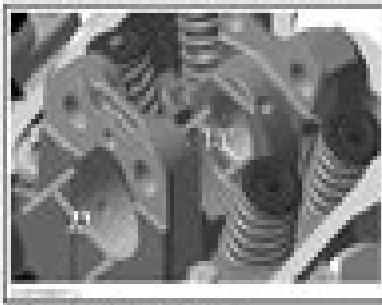
Clean oil support through the cylinder head from contamination.



- 1. Oil pump housing cover/cover base/motorplate
- 2. Valve cover/valve cover base/motorplate
- 3. Valve cover base/motorplate

Inspecting the Cylinder Head Camshaft Bearing

Measure camshaft bearing in cylinder head.



- 1. Camshaft bearing outer race
- 2. Camshaft bearing inner race

CAMSHAFT BEARING (TIMING CHAIN SIDE)

Max	38.000 mm to 38.020 mm (1.500 in to 1.508 in)
Service min	36.980 mm (1.496 in)

CAMSHAFT BEARING (TIMING CHAIN SIDE)

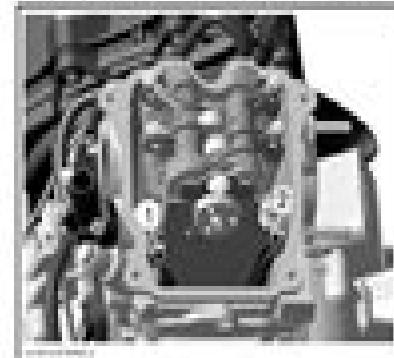
Max	37.900 mm to 37.921 mm (1.496 in to 1.497 in)
Service min	37.890 mm (1.495 in)

Installing the Cylinder Head

For installation, reverse the removal procedure. Pay attention to the following details.

Ensure dowel pins are in place.

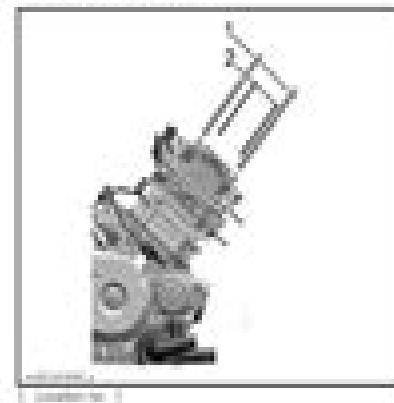
ADVICE Timing chain guide (base) has to be fixed between cylinder and cylinder head.



NOTE:
Timing chain guide (base) has to be fixed between cylinder and cylinder head.

Install a NEW cylinder head gasket.
Install cylinder head screws.

ADVICE Check for proper lengths of the cylinder head screws.



CYLINDER HEAD SCREW IDENTIFICATION

Location no. 1	M10 x 150
Location no. 2	M8 x 70

Tighten M10 cylinder head screws P10ST as per following specifications.

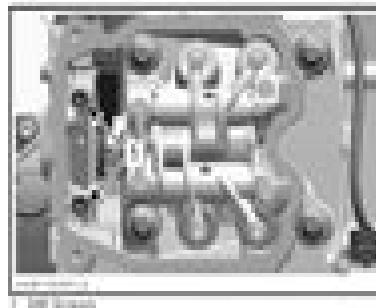


NOTE: Tighten cylinder head screws in clockwise direction.

TIGHTENING TORQUE

M10 Cylinder head screws	Step A 10 Nm to 15 Nm (0.98 ft-lb to 1.39 ft-lb)
	Step B 100 Nm to 117 Nm

Tighten M8 cylinder head screws as per following specification.



NOTE: Tighten cylinder head screws in clockwise direction.

TIGHTENING TORQUE

M8 Cylinder head screws	10 Nm to 15 Nm (0.98 ft-lb to 1.39 ft-lb)
-------------------------	--

Check timing chain guide (base) after for movement.

VALVE SPRINGS

Removing the Valve Spring

Refer to following procedure in the subsection to remove:

- CAMSHAFT
- CYLINDER HEAD

Compress valve spring

REQUIRED TOOL	
VALVE SPRING COMPRESSOR SPN 429-030-230	
VALVE SPRING COMPRESSOR CUP SPN 520-000-270	



NOTE: Use valve spring compressor cup tool or the like.

Remove valve collets.



NOTE: Use valve spring compressor cup tool or the like.

Remove tools and withdraw valve spring retainer and valve spring.

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**Great Britain. Royal Commission on
the South African War, 1899-1900**

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Organizational Maintenance Manual ,1978 *Federal Register* ,2008-02 **Documents of the Assembly of the State of New York** New York (State). Legislature. Assembly,1911 All Hands ,1952 *The United States Army and Navy Journal and Gazette of the Regular and Volunteer Forces* ,1921 Proceedings of the United States Naval Institute United States Naval Institute,1923 *Canal Record* ,1910 **Panama Canal Record** Canal Zone,1910 **Canal Record, Published Weekly Under Authority and Supervision of Isthmian Canal Commission** ,1910 *Army and Navy Register* ,1930 Popular Electronics ,1981 *Parliamentary Debates (Hansard)*. Great Britain. Parliament. House of Commons,1926 Contains the 4th session of the 28th Parliament through the session of the Parliament Minutes of Evidence Taken Before the Royal Commission on the War in South Africa Great Britain. Royal Commission on the South African War, 1899-1900,1903 *Popular Science Monthly* ,1929 **The United States Navy** United States. Congress. Senate. Committee on Naval Affairs,1908 **Electricity** ,1904 *Outlook* ,1918 *Deadline Disaster* Michael Wynn Jones,1976 *The Historical Magazine* John Ward Dean,George Folsom,John Gilmary Shea,Henry Reed Stiles,Henry Barton Dawson,1872 **New Outlook** ,1918

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