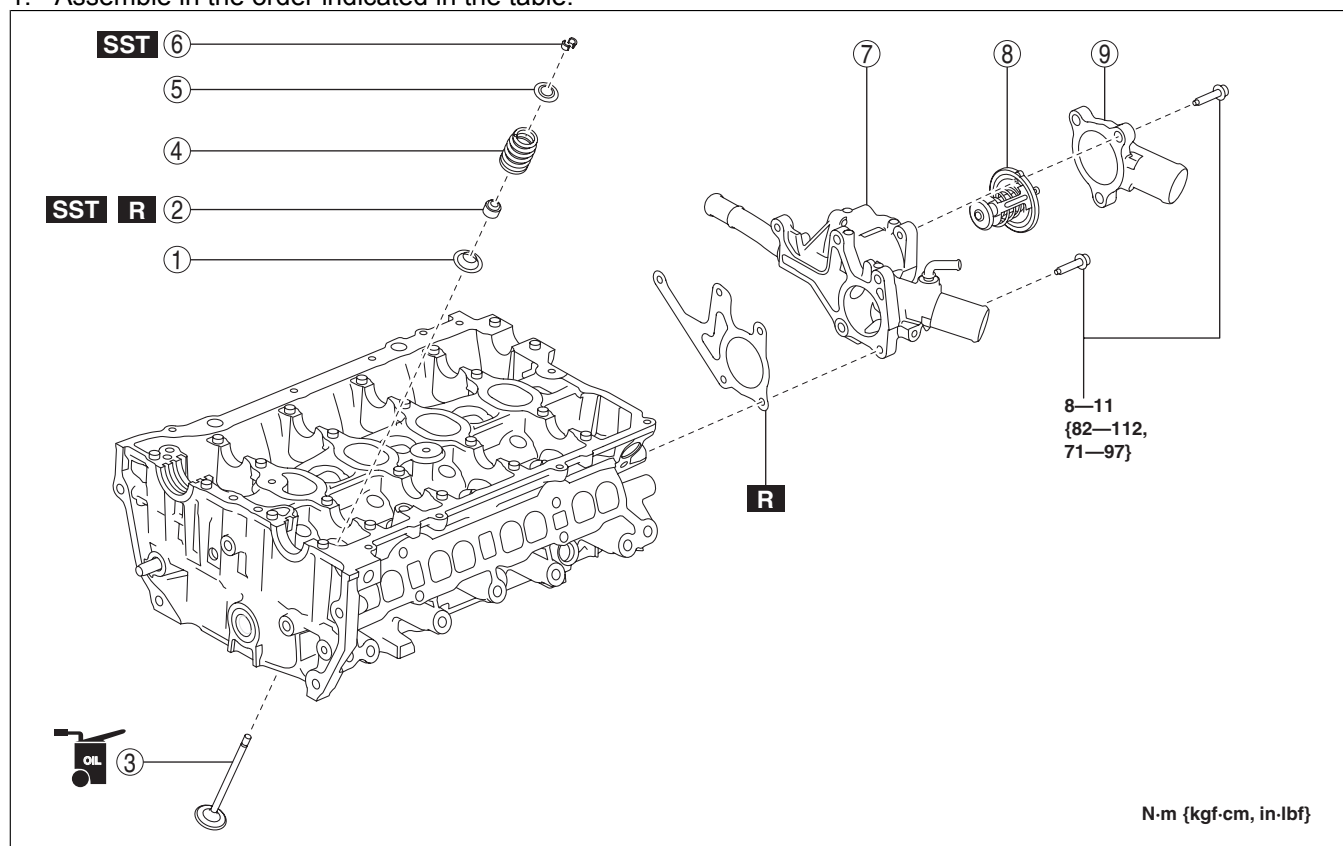


CYLINDER HEAD ASSEMBLY (I)

id011000504300

1. Assemble in the order indicated in the table.



1	Lower valve spring seat
2	Valve seal (See Valve Seal Assembly Note.)
3	Valve
4	Valve spring (See Valve Spring Assembly Note.)
5	Upper valve spring seat
6	Valve keeper (See Valve Keeper Assembly Note.)

7	Water outlet (See Water Outlet Assembly Note.)
8	Thermostat (See Thermostat Assembly Note.)
9	Thermostat cover

bpe1ze00000017

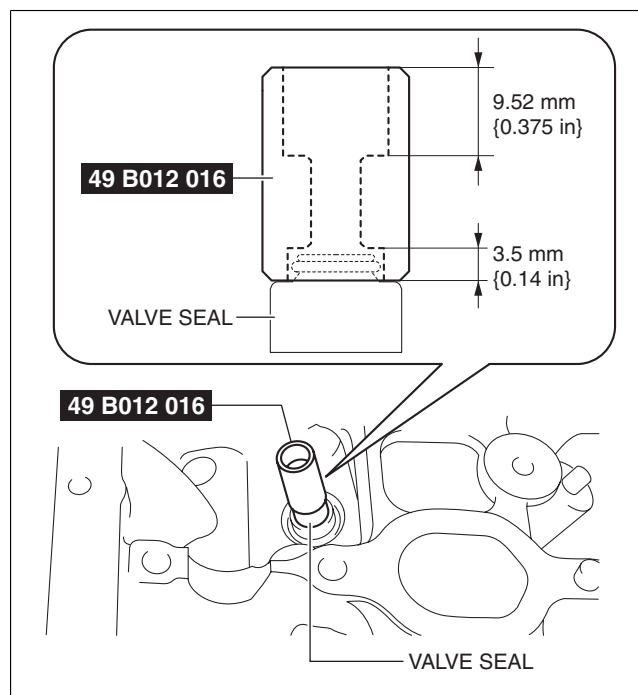
Valve Seal Assembly Note

1. Press in the valve seal to the valve guide using the **SST** by hand.

Valve seal identification color

IN: GREEN

EX: GRAY



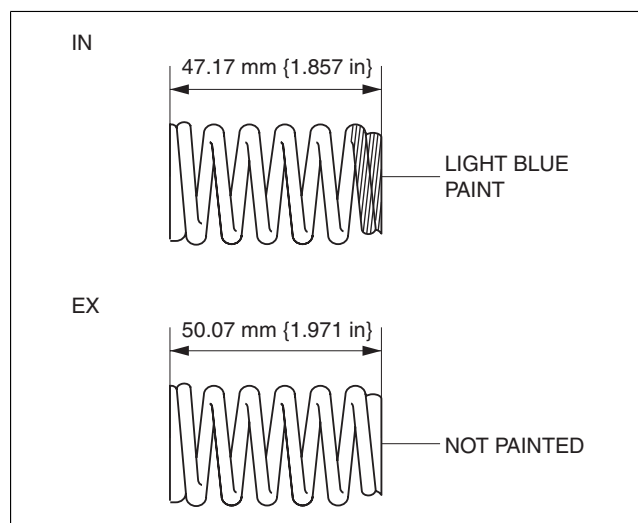
bpe1ze00000057

Valve Spring Assembly Note

Caution

- The valve springs differ depending on IN and EX sides. Therefore, verify the free length or identification paint beforehand and assemble the valve springs correctly.

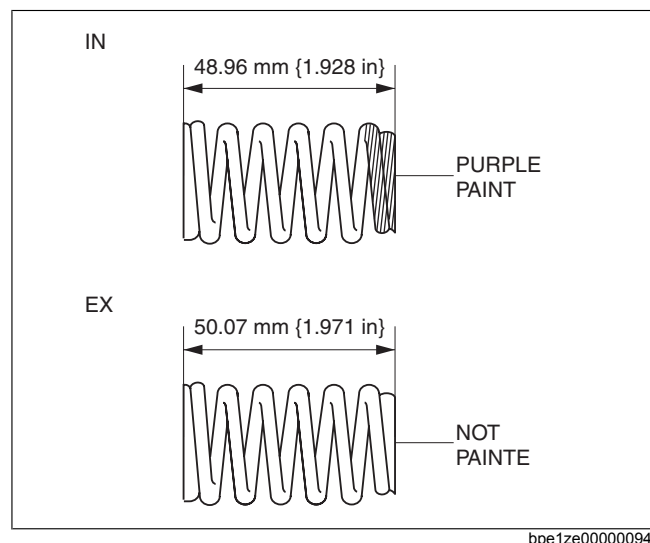
SKYACTIV-G 2.0



bpe1ze00000019

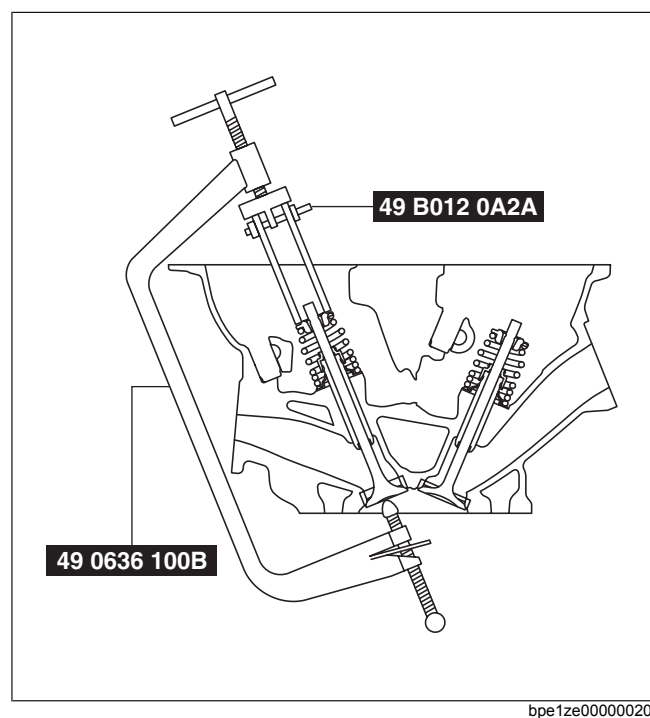
SKYACTIV-G 2.5

1. Assemble the valve spring with the small diameter side of the valve spring facing upward.

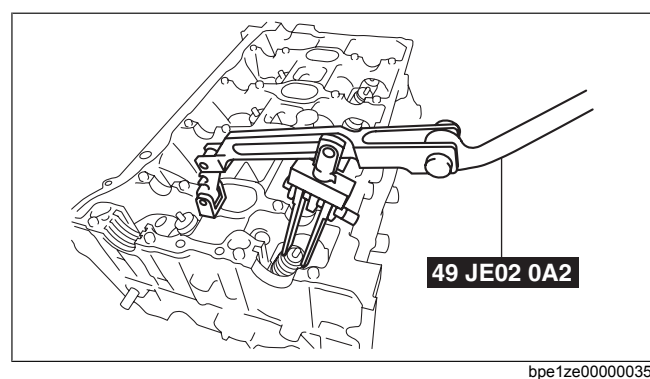


Valve Keeper Assembly Note

1. Install the valve keeper using the SST.
- When using the SSTs (49 0636 100B, 49 B012 0A2)

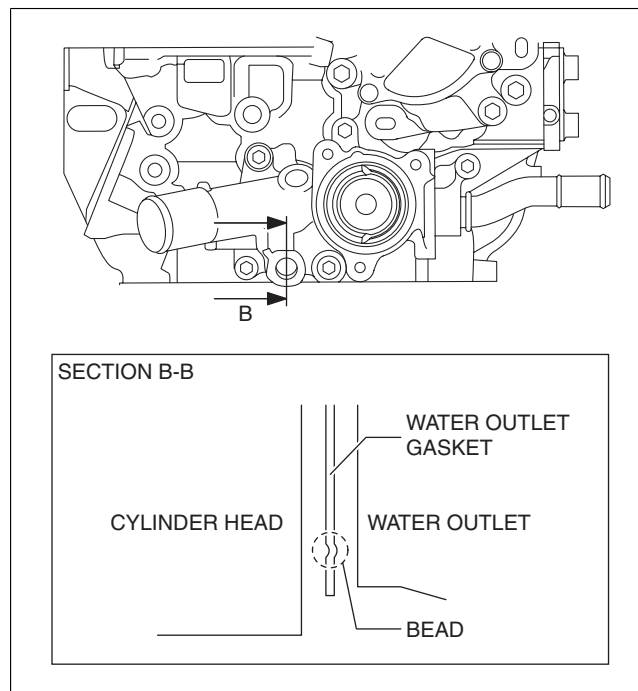


When using the SST (49 JE02 0A2) (Europe only)



Water Outlet Assembly Note

1. Install the water outlet gasket with the bead of gasket facing the direction shown in the figure.
2. Temporarily tighten the water outlet installation bolts.



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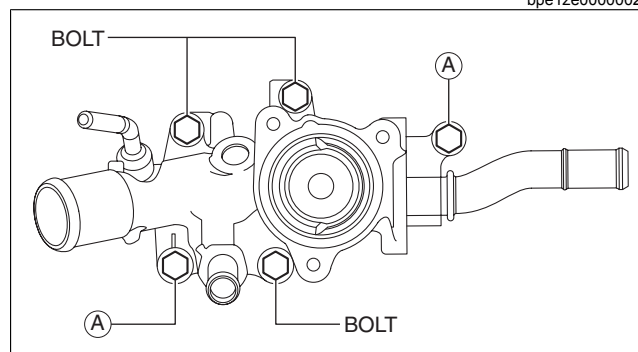
3. Tighten bolt A of the 5 bolts shown in the figure to the specified torque first.

Tightening torque

8—11 N·m {82—112 kgf·cm, 71—97 in·lbf}

Note

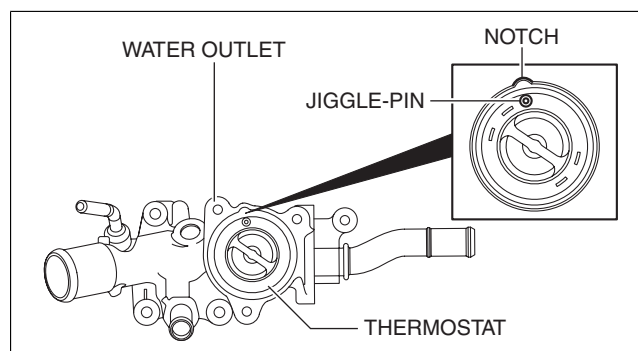
- The tightening order for the remaining 3 bolts is optional.



bpe1ze00000022

Thermostat Assembly Note

1. Install the thermostat with the jiggle pin aligned with the notch of the water outlet.



bpe1ze00000023