

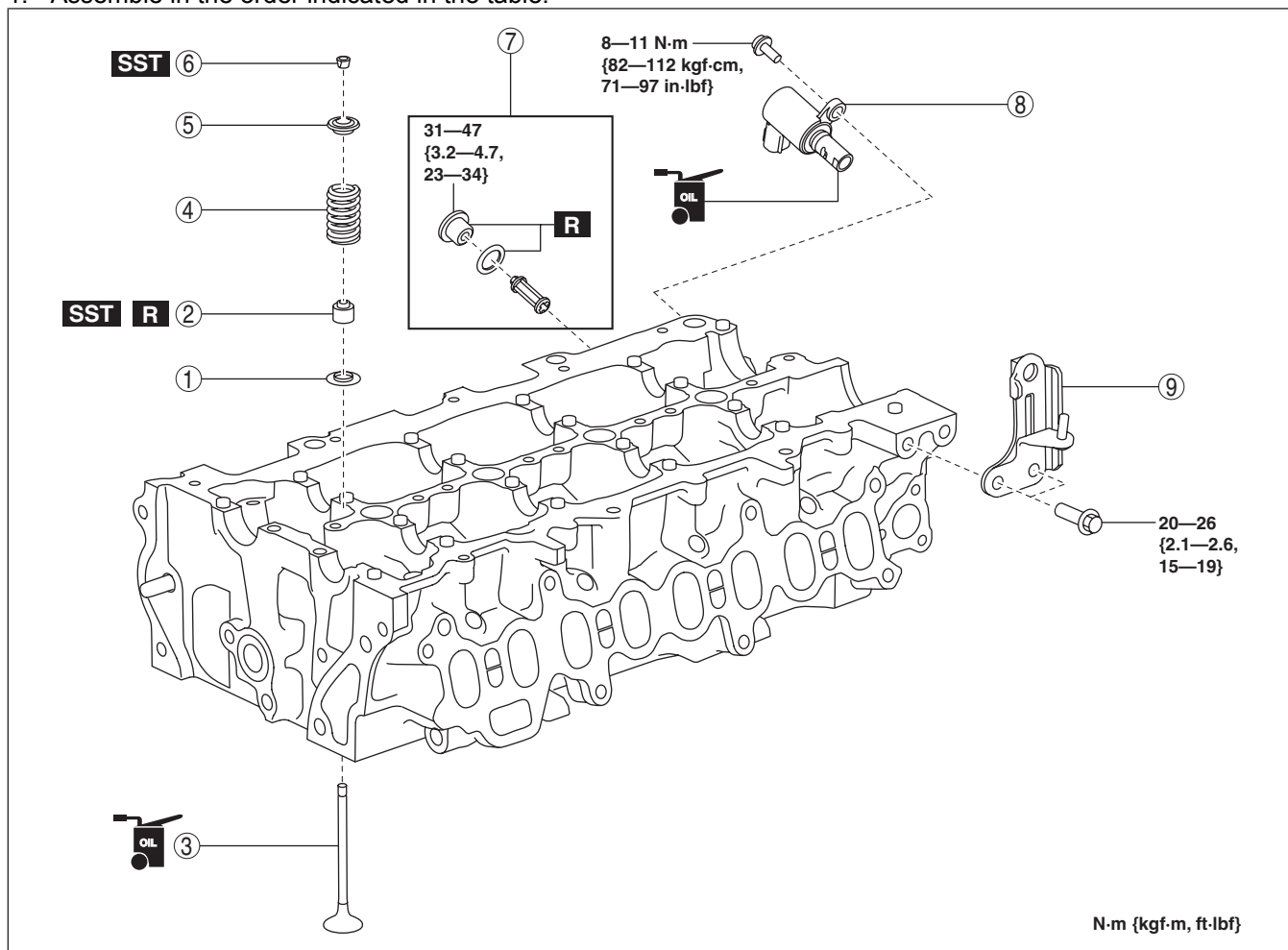
CYLINDER HEAD ASSEMBLY (I)

id011000504300

Caution

- The end of the glow plug protrudes from the cylinder head (tightened surface of cylinder block). When removing/installing the cylinder head and placing the cylinder head on a workbench, be careful not to allow the end of the glow plug to contact the cylinder block or workbench. Otherwise, the end of the glow plug could be damaged.

1. Assemble in the order indicated in the table.



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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	OCV oil filter, plug
8	OCV (See OCV Assembly Note.)
9	Seal cover bracket

Valve Seal Assembly Note

1. Place the valve seal on the valve guide.

Valve seal identification color

IN: GREEN

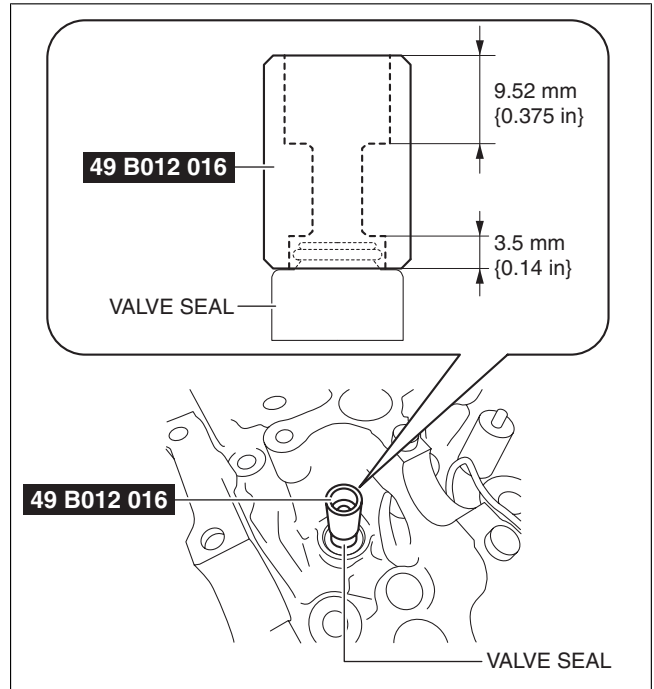
EX: GRAY

- Set the **SST** to the valve seal in the direction shown in the figure.

Caution

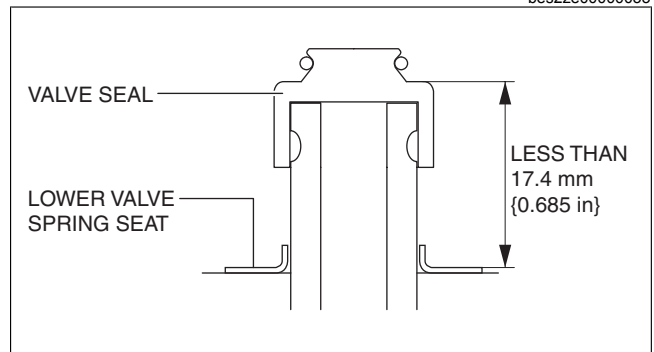
- Do not insert the **SST** with the force of 900 N {91.8 kgf, 202 lbf} or more.

- Press in the **SST** by hand and install the valve seal to the valve guide.



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- Insert the valve seal until the height of the valve seal is less than 17.4 mm {0.685 in}.



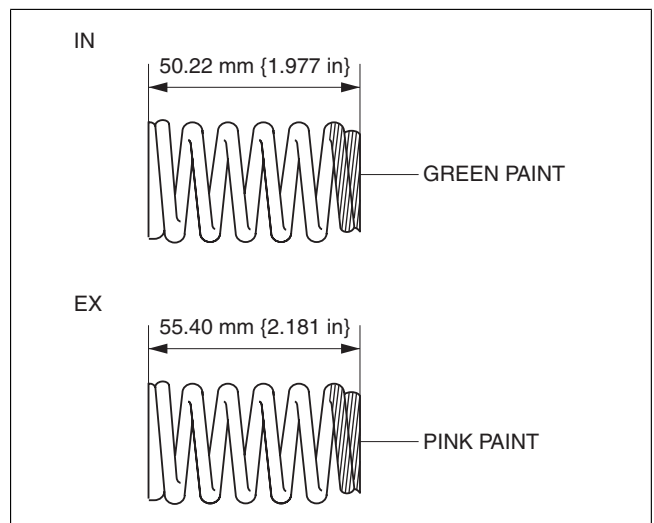
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Valve Spring Assembly Note

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.

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



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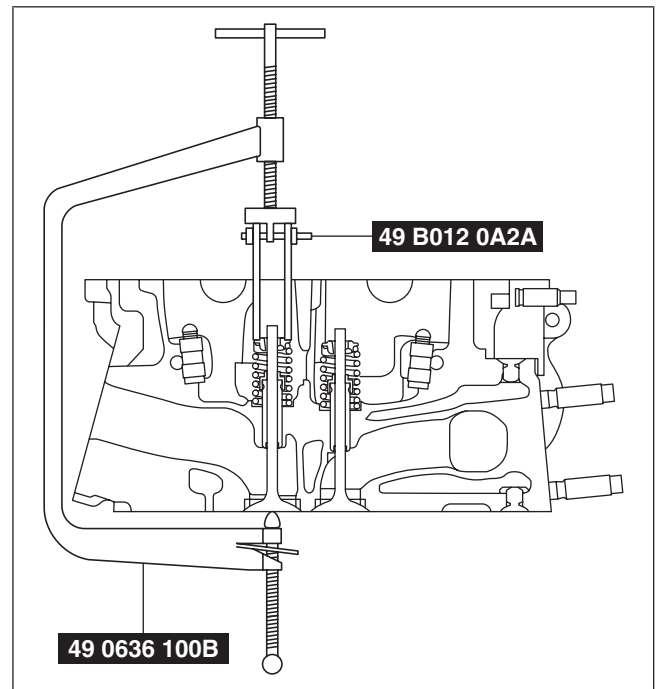
Valve Keeper Assembly Note

When using the SSTs (49 0636 100B, 49 B012 0A2A)

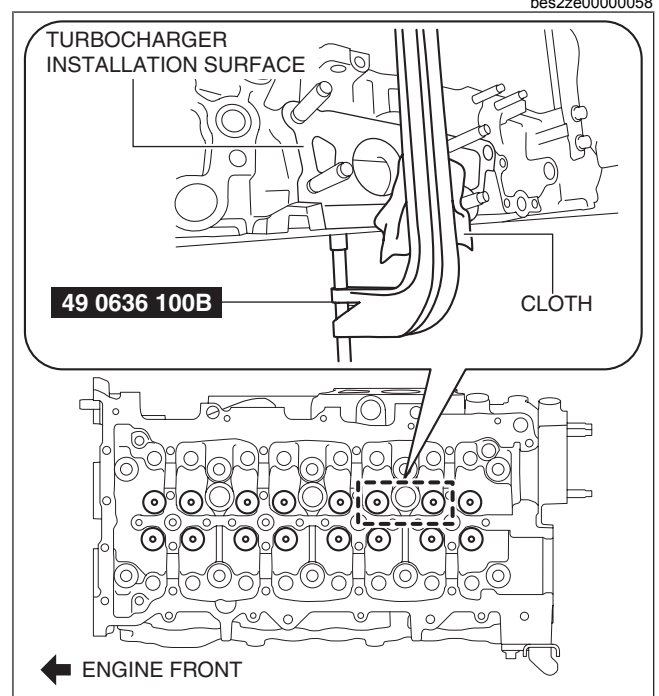
1. Install the valve keeper using the SSTs.

Caution

- When removing/installing the valve keepers in the two locations shown in the figure out of the total 16 locations, the SST could contact the turbocharger installation surface of the cylinder head and damage the cylinder head. Insert a rag between the cylinder head and SST before performing the work.



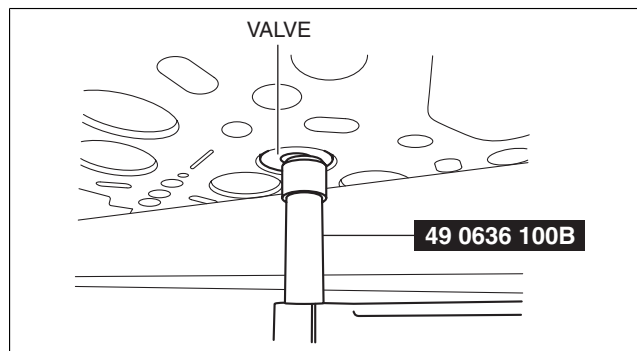
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Note

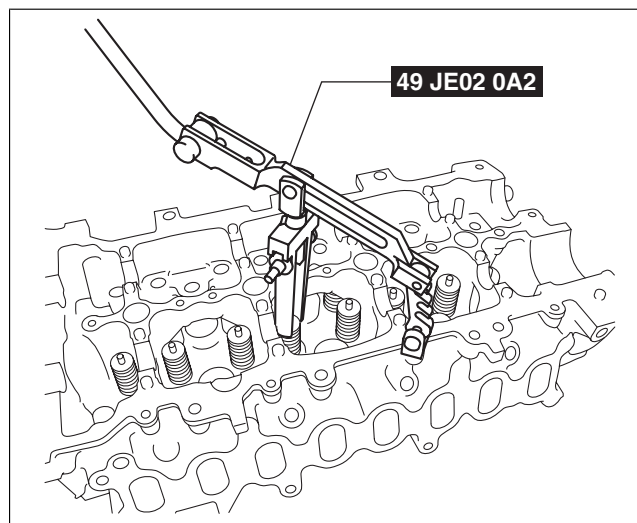
- When performing the work for the above two locations, the **SST** is slightly deviated from the center of the valve as shown in the figure. However, this does not indicate a malfunction.



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

1. Install the valve keeper using the **SST**.



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OCV Assembly Note

Caution

- If the OCV is dropped accidentally, replace with a new one. Otherwise, the OCV may not operate normally.
- Do not allow foreign matter to get caught when installing. Otherwise, it could leak oil.
- If the installation bolt is tightened with oil adhering, the bolt could be twisted and cut. Always degrease the bolt.