REASSEMBLY

EM0Z4-02
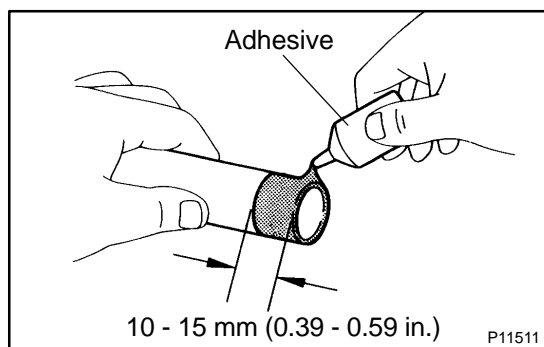
HINT:

- 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.

Adhesive

10 - 15 mm (0.39 - 0.59 in.)

P11511

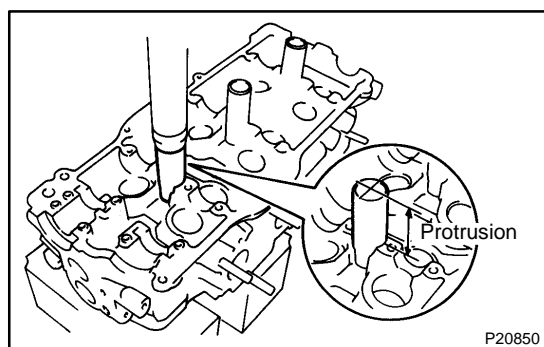## 1.   INSTALL SPARK PLUG TUBES

HINT:

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

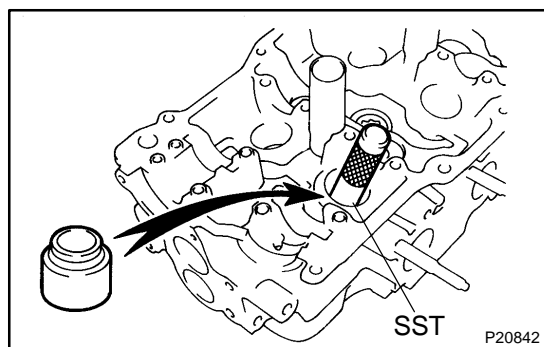(a)   Apply adhesive to the end of a spark plug tube.
Adhesive:
Part No. 08833-00070, THREE BOND 1324 or equivalent

Protrusion

P20850

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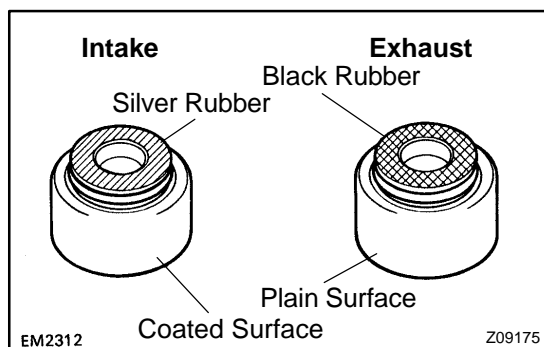
NOTICE:
Avoid pressing the spark plug tube in too far by measuring the amount of the protrusion while pressing.
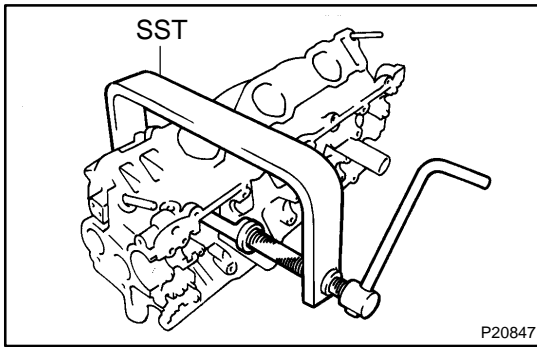

SST

P20842

2.   INSTALL VALVES

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

Intake   Exhaust
Silver Rubber   Black Rubber

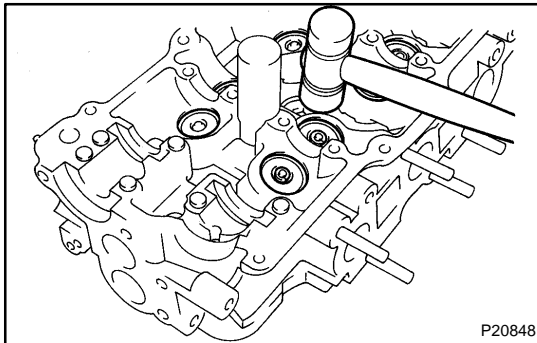Coated Surface   Plain Surface

EM2312   Z09175

HINT:

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

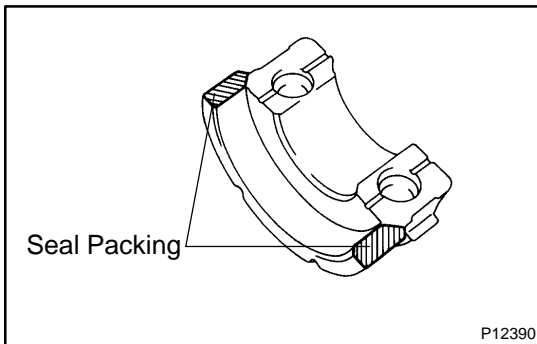(b)   Install the valve, spring seat, valve spring and spring retainer.

(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.

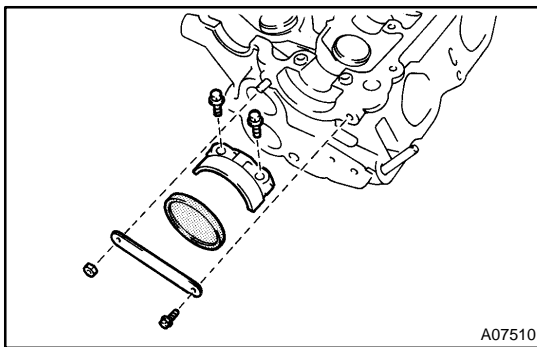**3. INSTALL VALVE LIFTERS AND SHIMS**

(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 and ground strap with the bolt and nut.
Torque: 8 N·m (80 kgf·cm, 71 in.·lbf)