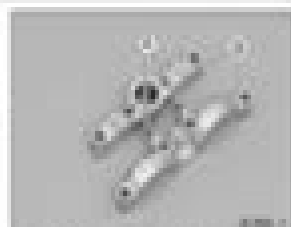


## Cams/Shafts

- Apply grease to the hollow portions of the oil pipes (A).
- Assemble:
  - Camshaft Caps (B)
  - Oil Pipes
- While keeping the camshaft caps in parallel, install them to the cylinder head.



- Apply molybdenum disulfide oil to the threads of the camshaft cap bolts.
- Tighten all camshaft cap bolts evenly and tightly, and then tighten them with specified torque.

(Follow the numbers ① - ⑤ of tightening sequence on the camshaft cap.)

**Torque - Camshaft Cap Bolts:** 8.8 Nm (6.6 lbf·ft, 57 in·lb)



- Install the camshaft chain tensioner (see Camshaft Chain Tensioner Installation).
- Check the camshaft chain timing.
  - Confirm the timing mark and punch mark align with the cylinder head upper surface.
- If the timing mark and punch mark do not align with the cylinder head upper surface, recheck the camshafts.
  - Turn the camshaft pin(s).
- If the camshaft does not turn smoothly, the timing is off. Repeat. Stop tuning immediately.

**NOTE**

The improper camshaft chain timing may damage the valves.

- Install:
  - Cylinder Head Cover (see Cylinder Head Cover Installation)
- Replace the timing inspection cap and flywheel nut cap O-rings with new ones.
- Apply grease to the O-rings.
- Tighten:

**Torque - Timing Inspection Cap:** 3.0 Nm (2.0 lbf·ft, 17 in·lb)

**Flywheel Nut Cap:** 3.0 Nm (2.0 lbf·ft, 17 in·lb)

**Special Tool - Flyer Cap Driver:** 570N·m (40 ft·lb)

## Camshafts

## Camshaft Chain Removal

- Remove:
  - Camshaft (see Camshaft Removal)
  - Flywheel (see Flywheel Removal in the Electrical System chapter)
  - Oil Pump (Overweight) Cover Bolt (A)
  - Lower Camshaft Chain Guide (B)
- Overweight the camshaft chain from the crankshaft.



## Camshaft Chain Installation

- Engage the camshaft chain to the crankshaft.
- Install the lower camshaft chain guide.
- Tighten:

**Torque - Oil Pump (Overweight) Cover Bolts:** 8.8 Nm (6.6 lbf·ft, 57 in·lb)

- Install:
  - Flywheel (see Flywheel Installation in the Electrical System chapter)
  - Camshaft (see Camshaft Installation)

## Camshaft and Camshaft Cap Wear Inspection

- Measure each clearance between the camshaft journal and camshaft cap using plastigage (crank gauge) (A).
- Tighten the camshaft cap bolts after applying molybdenum disulfide oil to the thread of them.

**Torque - Camshaft Cap Bolts:** 8.8 Nm (6.6 lbf·ft, 57 in·lb)

**NOTE**

(Do not turn the camshaft when the plastigage is between the journal and camshaft cap.)



## Camshaft Journal/Camshaft Cap Clearance

**Standard:** 0.025 - 0.052 mm (0.0010 - 0.0021 in.)

**Service Limit:** 0.10 mm (0.0039 in.)

- If any clearance exceeds the service limit, measure the diameter of each camshaft journal with a micrometer.

## Camshaft Journal Diameter

**Standard:** 22.930 - 22.935 mm (0.9028 - 0.9031 in.)

**Service Limit:** 22.91 mm (0.9019 in.)

- If the camshaft journal diameter is less than the service limit, replace the camshaft with a new one, and measure the clearance again.
- If the clearance still exceeds out of the service limit, replace the cylinder head and

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**Kawasaki Jūkōgyō Kabushiki Kaisha**

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