

Cylinder Head

1. Loosen the pipe clamp, and remove the water return pipe.
2. Remove the cylinder head screws in the order of (2) to (1).
3. Lift up the cylinder head to dislodge.

(When reassembling)

- Tighten the cylinder head screws after applying sufficient oil.
- Tighten the cylinder head screws in diagonal sequence starting from the center. (Refer to figure left.)
- Tighten them uniformly, or the head may deform in the long run.

■ IMPORTANT

- When overhauling the engine, replace the gasket with a new one without confusing its front and back.
- Retighten the cylinder head screws after running the engine for 30 minutes.

Tightening torque	Cylinder head screw	Oil 1 to 30.0 (1.0L) Oil 2 to 15.0 (0.5L) Oil 3 to 10.0 (0.2L)
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(a) To Loosen: 20 to 1

(b) To Tighten: 1 to 20

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Cylinder Head Gasket and Tappet

1. Remove the cylinder head gasket (1).
2. Remove the C-ring (2).
3. Remove the tappets (3) from the combustion.

(When reassembling)

- Before installing the cylinder head gasket, check to see there is no foreign matter on the cylinder head and cylinder.
- Visually check the contact between tappets and cam for proper relation. If defect is found, replace tappets.
- Before installing the tappets, apply engine oil thinly around them.

■ IMPORTANT

- Do not change the combination of tappet and tappet guide.

- (1) Cylinder head gasket (2) Tappet
(3) C-ring

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Valves

1. Remove the valve cap (2).
2. Remove the valve spring retainer (3), pushing the valve spring retainer (4) to valve spring retainer (1).
3. Remove the valve spring retainer (4), valve spring (5) and valve stem seal (6).
4. Remove the valve (7).

(When reassembling)

- Wash the valve stem and valve guide hole, and apply engine oil sufficiently.
- After installing the valve spring retainers, lightly tap the stem to assure proper fit with a plastic hammer.

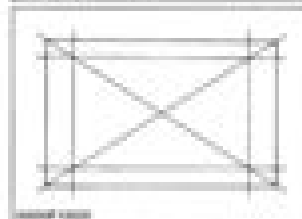
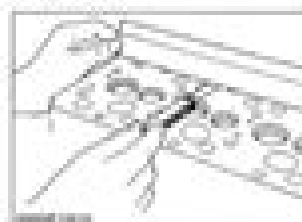
■ IMPORTANT

- Don't change the combination of valve and valve guide.

- (1) Valve Spring Retainer (2) Valve Spring
(3) Valve Cap (4) Valve Stem Seal
(5) Valve Spring Guide (6) Valve
(7) Valve Spring Retainer

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Cylinder Head Surface Flatness

1. Clean the cylinder head surface.
2. Place a straightedge on the cylinder head's four valves and two diagonal as shown in the figure.
3. Measure the clearance with a feeler gauge.
4. If the measurement exceeds the allowable limit, correct it with a surface grinder.

■ IMPORTANT

- Do not place the straightedge on the combustion chamber.
- Be sure to check the valve recessing after correcting.

Cylinder head surface	Allowable limit	0.10 mm (0.001 in.)
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Cylinder Head Flare

1. Prepare an air spray nozzle (Code No. 07900-21-071).
2. Clean the surface of the cylinder head with detergent (2).
3. Spray the cylinder head surface with the red permeant liquid (1). Leave it for ten minutes after spraying.
4. Wash away the red permeant liquid on the cylinder head surface with the detergent (2).
5. Spray the cylinder head surface with white developer (3).
6. If flawed, it can be identified as red marks.

- (1) Red Permeant Liquid (2) White Developer
(3) Detergent

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