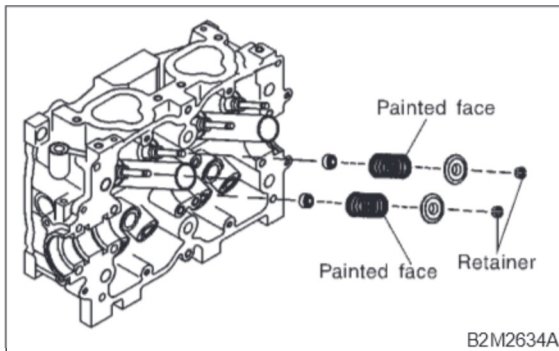


(5) Compress valve spring and fit valve spring retainer key.

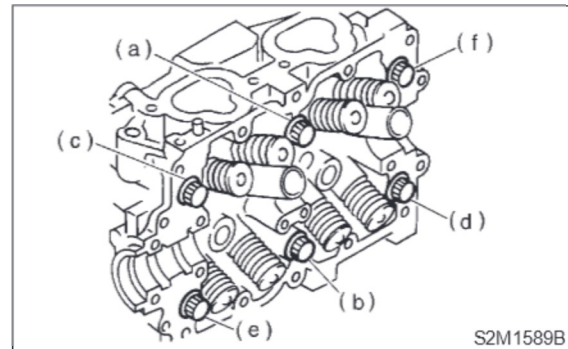


(6) After installing, tap valve spring retainers lightly with wooden hammer for better seating.

(7) Further tighten all bolts by 80 to 90° in alphabetical sequence shown in figure below.

CAUTION:

Ensure that the total “re-tightening angle” [in the former two steps], do not exceed 180°.



E: INSTALLATION

1. CYLINDER HEAD

1) Install cylinder head and gaskets on cylinder block.

CAUTION:

Use new cylinder head gaskets.

2) Tighten cylinder head bolts.

(1) Apply a coat of engine oil to washers and bolt threads.

(2) Tighten all bolts to 29 N·m (3.0 kg-m, 22 ft-lb) in alphabetical sequence.

Then tighten all bolts to 69 N·m (7.0 kg-m, 51 ft-lb) in alphabetical sequence.

(3) Back off all bolts by 180° first; back them off by 180° again.

(4) Tighten bolts (a) and (b) to 34 N·m (3.5 kg-m, 25 ft-lb).

(5) Tighten bolts (c), (d), (e) and (f) to 15 N·m (1.5 kg-m, 11 ft-lb).

(6) Tighten all bolts by 80 to 90° in alphabetical sequence.

CAUTION:

Do not tighten bolts more than 90°.

3) Install oil level gauge guide and tighten attaching bolt (left side only).

2. RELATED PARTS

CAUTION:

Be careful not to scratch the mating surface of cylinder block and oil pump.

1) Install camshafts. <Ref. to 2-3 [W5C0].>

2) Install intake manifold. <Ref. to 2-7 [W3D0].>

3) Tighten bolt which installs A/C compressor bracket on cylinder head. (With A/C model)