

## Group 4

# Assembly

## Assembling Cylinder Head

### 1. Tappets, O-ring, Gasket

- (1) Apply a thin coat of engine oil to the tappets before installing.
- (2) Install the O-ring.
- (3) Before installing the cylinder head gasket, make sure there is no foreign matter on the cylinder head or in the cylinder.

### 2. Cylinder Head

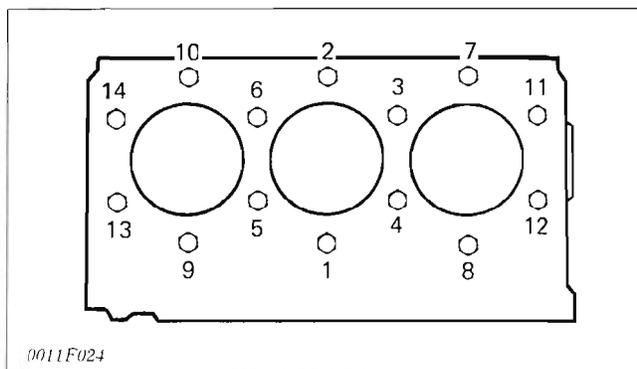


Fig. B-74 Cylinder Head Tightening Order

- (1) Tighten the set bolts to 42 to 47 Nm (4.3 to 4.8 kgf-m, 31 to 35ft-lbs).
- (2) Tighten the bolts and nuts in a diagonal sequence starting from the center. Tighten them uniformly, or the head may become deformed in the long run.
- (3) Tighten the bolts and nuts after applying sufficient oil.

### 3. Push Rods

- (1) Before inserting the push rods into the tappets, check to see if their ends are properly engaged with the grooves.

### 4. Rocker Arm

- (1) Before installing the rocker arm bracket, make sure that there are no metallic particles on the surface on which the assembly is to be mounted.
- (2) Tighten the bolts to 17 to 21 Nm (1.7 to 2.1 kgf-m, 12 to 15ft-lbs).

### 5. Fan Belt

- (1) Check that the V-belt is placed correctly (so that letters on the belt can be read from your side), and that there is no oil or grease on the belt.
- (2) Adjust tension of the V-belt.

### 6. Nozzle Holders

- (1) Install the nozzle holders after confirming that there are no metallic particles or foreign matter on the surface on which they are to be installed.
- (2) Tighten the nozzle holders to 29 to 49 Nm (3.0 to 5.0 kgf-m, 22 to 36 ft-lbs).

**SPECIAL TOOLS:** Nozzle holder socket wrench (See page 2-1)

### 7. Injection Pipes

- (1) Blow compressed air into the pipes to eliminate dust.
- (2) Tighten the retaining nuts to 15 to 25 Nm (1.5 to 2.5 kgf-m, 11 to 18 ft-lbs).

### 8. Cylinder Head Cover

- (1) Make sure the gasket is not defective.
- (2) To prevent valve stems seizure, apply engine oil to the valve guides and valve stems.