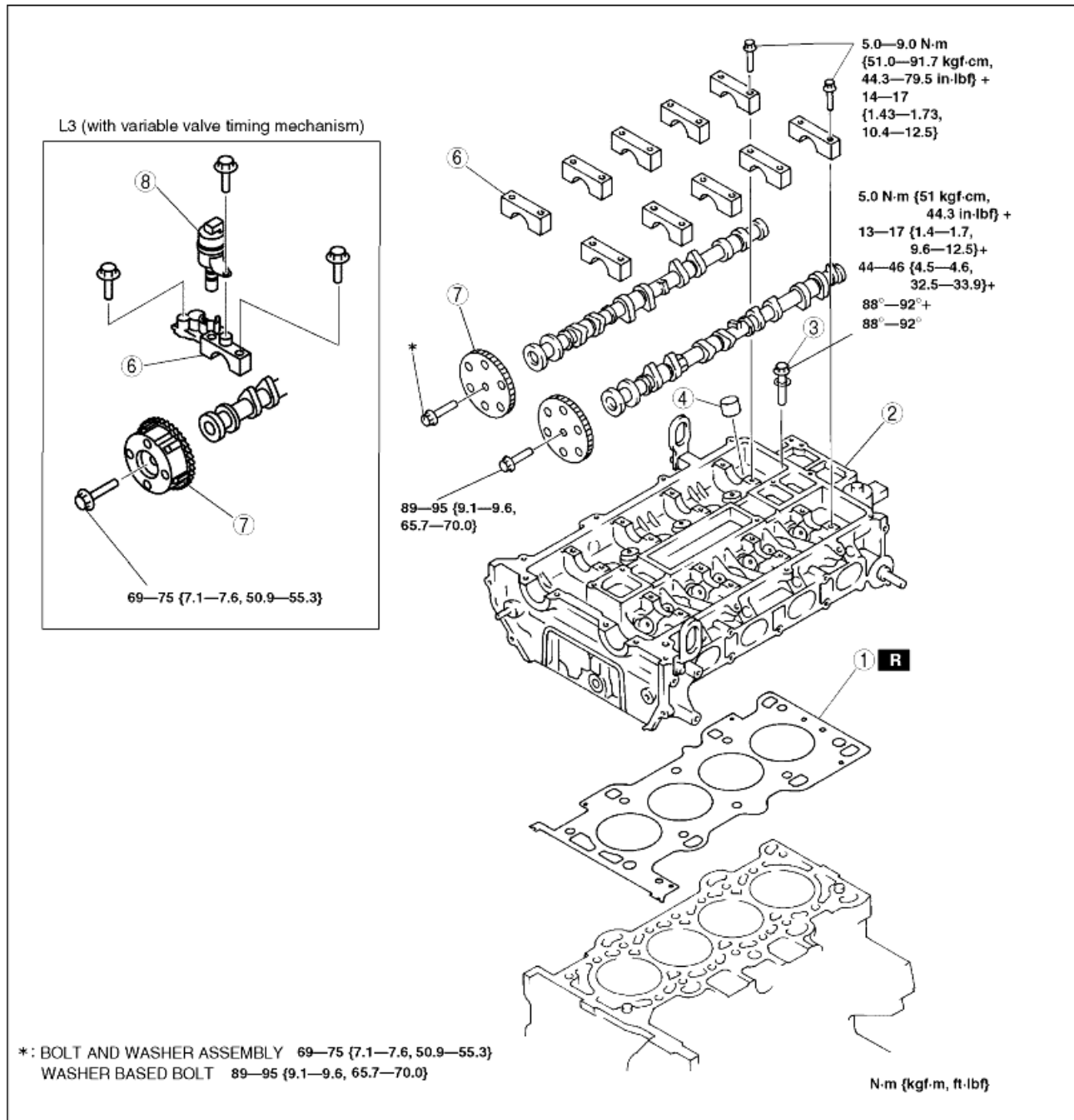


CYLINDER HEAD (II) ASSEMBLY

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1. Assemble in the order indicated in the table.



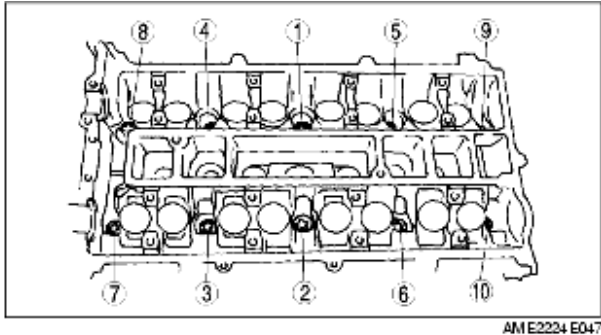
AME2224E046

1	Cylinder head gasket
2	Cylinder head
3	Cylinder head bolt (See Cylinder Head Bolt Assembly Note)
4	Tappet
5	Camshaft (See Camshaft Assembly Note)

6	Camshaft cap
7	Camshaft sprocket, Variable valve timing actuator (L3 (with variable valve timing mechanism)) (See Camshaft Sprocket, Variable Valve Timing Actuator (L3 (with variable valve timing mechanism)) Assembly Note)
8	Oil control valve (OCV) (L3 (with variable valve timing mechanism))

Cylinder Head Bolt Assembly Note

1. Tighten the cylinder head bolts in the order indicated in the figure in six steps.



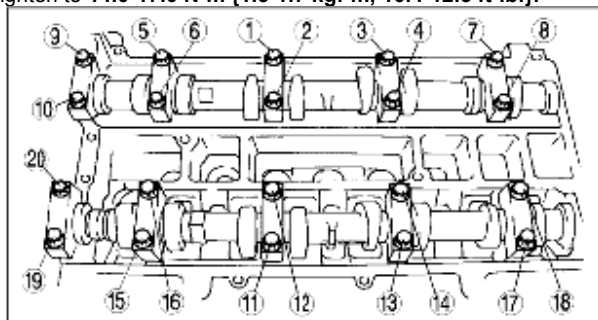
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- (1) Tighten to **5.0 N·m {51 kgf·cm, 44.3 in·lbf}**.
- (2) Tighten to **13- 17 N·m {1.4 -1.7 kgf·m, 9.6-12.5 ft·lbf}**.
- (3) Tighten to **44- 46 N·m {4.5 -4.6 kgf·m, 32.5-33.9 ft·lbf}**.
- (4) Tighten **88°-92°**.
- (5) Tighten **88°-92°**.

Camshaft Assembly Note

1. Install the camshaft with No.1 cylinder aligned with TDC position.
2. Tighten the camshaft cap bolt using the following two steps.

- (1) Tighten to **5.0-9.0 N·m {51.0-91.7 kgf·cm, 44.3-79.5 in·lbf}**.
- (2) Tighten to **14.0-17.0 N·m {1.5-1.7 kgf·m, 10.4-12.5 ft·lbf}**.



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Camshaft Sprocket, Variable Valve Timing Actuator (L3 (with variable valve timing mechanism)) Assembly Note

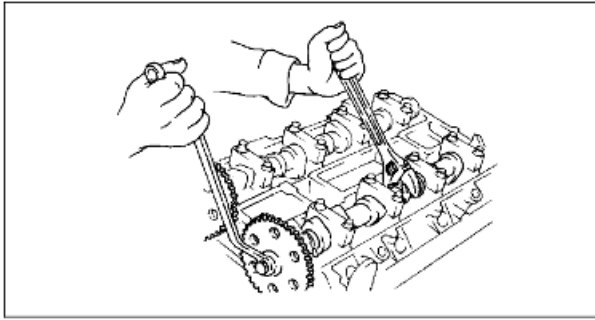
1. Camshaft sprocket or variable valve timing actuator (L3 (with variable valve timing mechanism)) attachment bolt is changed into the state of a temporary bundle by hand until it attaches timing chain.
2. The attachment bolt of camshaft sprocket or variable valve timing actuator (L3 (with variable valve timing mechanism)) is bound tight for timing chain after attachment.

L8, LF, L3

N·m {kgf·m, ft·lbf}

Camshaft sprocket	Bolt type	Tightening torque
IN side	Washer based bolt	89-95
		{9.1-9.6, 65.7-70.0}
		69-75

EX side	Bolt and washer assembly	{7.1-7.6, 50.9-55.3}
	Washer based bolt	89-95 {9.1-9.6, 65.7-70.0}

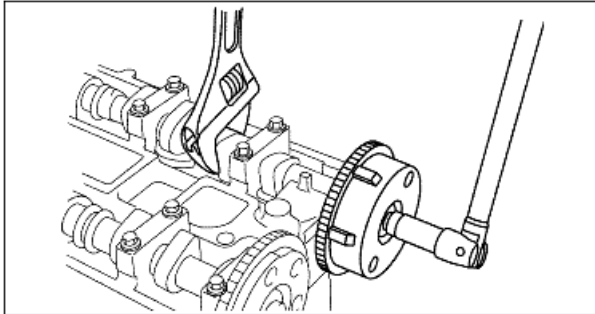


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L3 (with variable valve timing mechanism)

N·m {kgf·m, ft·lbf}

Camshaft sprocket	Bolt type	Tightening torque
IN side	Washer based bolt	69-75 {7.1-7.6, 50.9-55.3}
EX side	Bolt and washer assembly	69-75 {7.1-7.6, 50.9-55.3}
	Washer based bolt	89-95 {9.1-9.6, 65.7-70.0}



AME2224E078