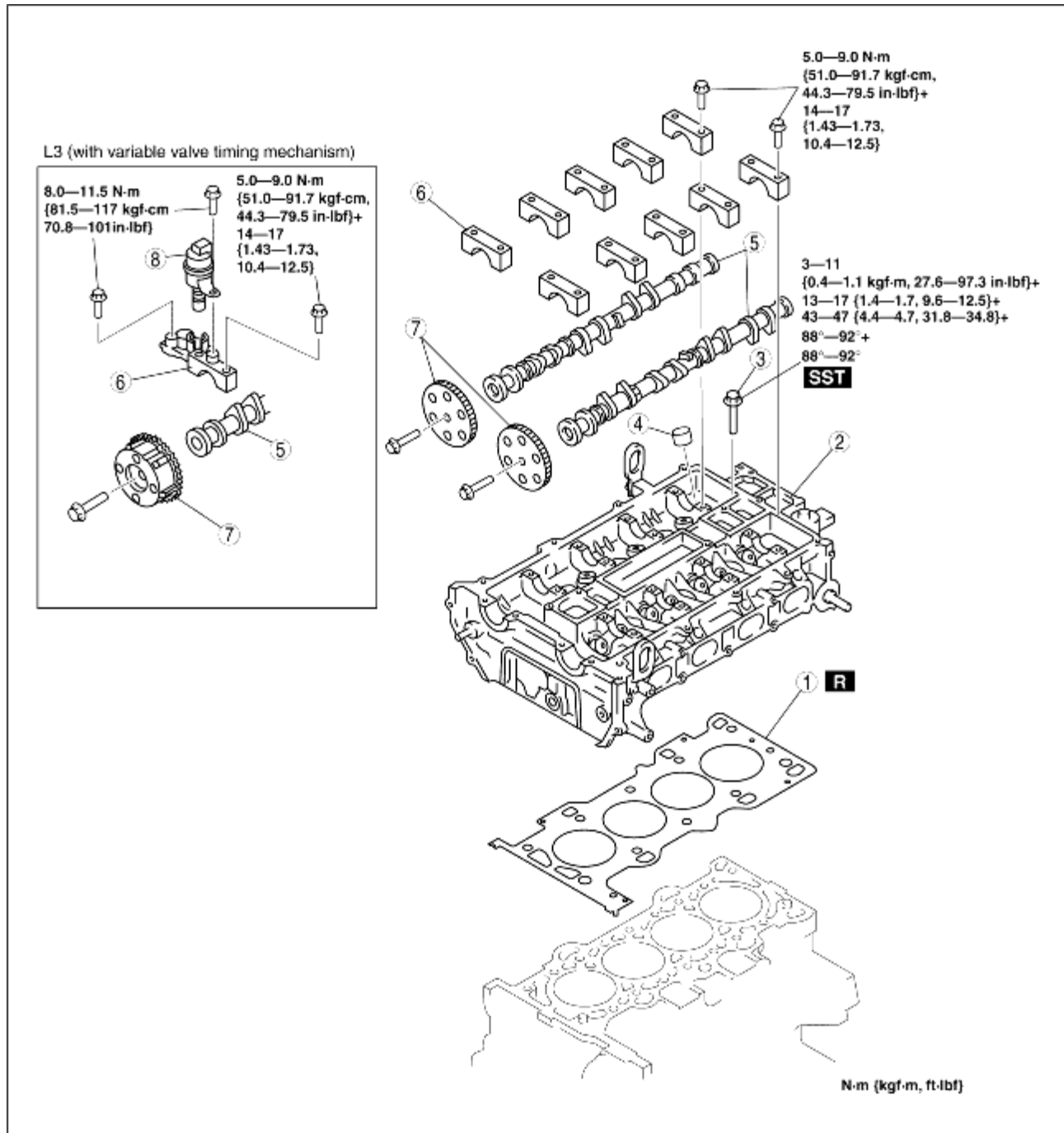


CYLINDER HEAD (II) ASSEMBLY

B3E011002000211

1. Assemble in the order indicated in the table.



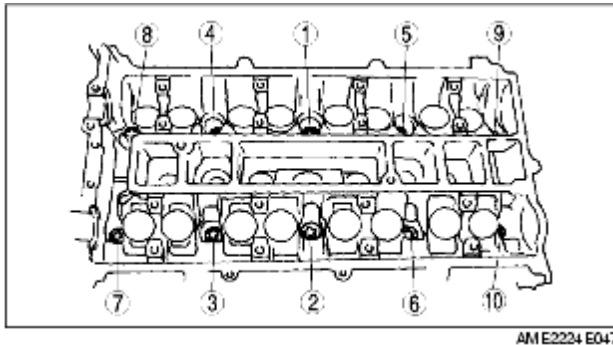
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1	Cylinder head gasket
2	Cylinder head
3	Cylinder head bolt (See Cylinder Head Bolt Assembly Note)
4	Tappet

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 5 steps using the **SST (49 D032 316)**.

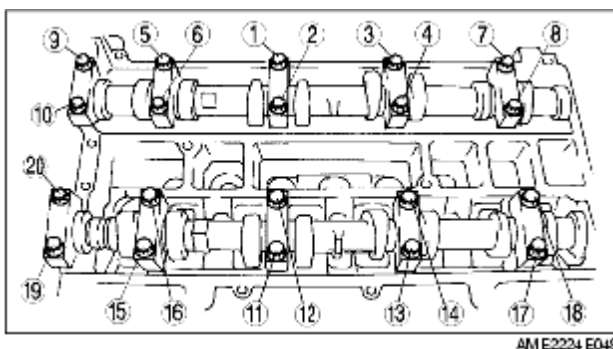


Tightening torque

- (1) 3-11 N·m
{0.4-1.1 kgf·m, 27.6-97.3 in·lbf}
- (2) 13-17 N·m
{1.4-1.7 kgf·m, 9.59-12.5 ft·lbf}
- (3) 43-47 N·m
{4.4-4.7 kgf·m, 31.8-34.6 ft·lbf}
- (4) 88°-92°
- (5) 88°-92°

Camshaft Assembly Note

1. Set the cam position of No.1 cylinder at the top dead center (TDC) and install the camshaft.
2. Temporarily tighten the camshaft bearing caps evenly in 2-3 passes.
3. Tighten the camshaft cap bolt in the order shown two steps.



Tightening torque

- (1) 5.0-9.0 N·m
{51.0-91.7 kgf·cm, 44.3-79.6 in·lbf}
- (2) 14.0-17.0 N·m

{1.5-1.7 kgf·m, 10.4-12.5 ft·lbf}

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

1. Temporarily tighten the camshaft sprocket or variable valve timing actuator (L3 (with variable valve timing mechanism)) installation bolts by hand until the timing chain is installed.
2. Fully tighten the camshaft sprocket or variable valve timing actuator (L3 (with variable valve timing mechanism)) installation bolts after timing chain installation.