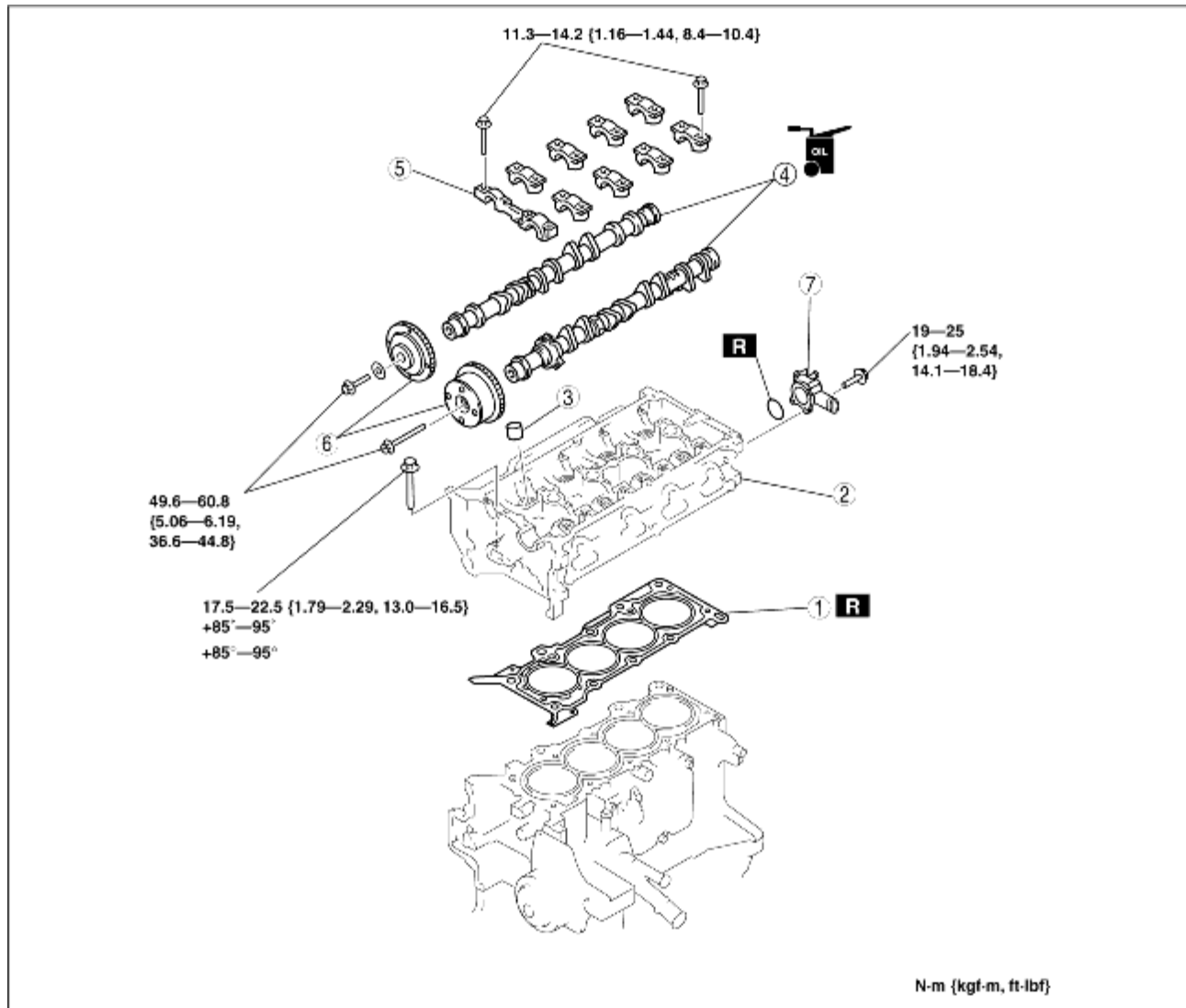


## CYLINDER HEAD (II) ASSEMBLY

B3E011010100E05

1. Assemble in the order indicated in the table.

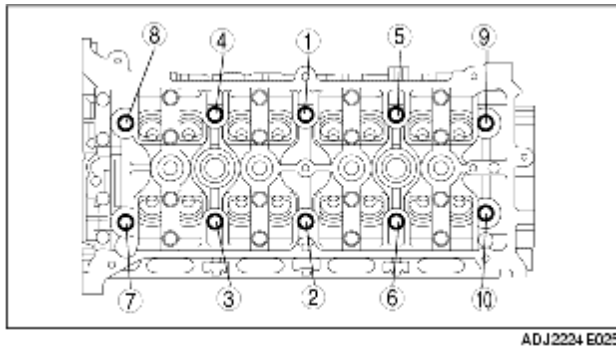


B3E0110E030

1	Cylinder head gasket
2	Cylinder head (See <a href="#">Cylinder Head Assembly Note</a> )
3	Tappet
4	Camshaft (See <a href="#">Camshaft Assembly Note</a> )
5	Camshaft cap (See <a href="#">Camshaft Assembly Note</a> )
6	Camshaft sprocket, variable valve timing actuator (See <a href="#">Camshaft Sprocket, Variable Valve Timing Actuator Assembly Note</a> )
7	Water outlet

## Cylinder Head Assembly Note

1. Tighten the cylinder head installation bolts in three steps in the order shown in the figure.



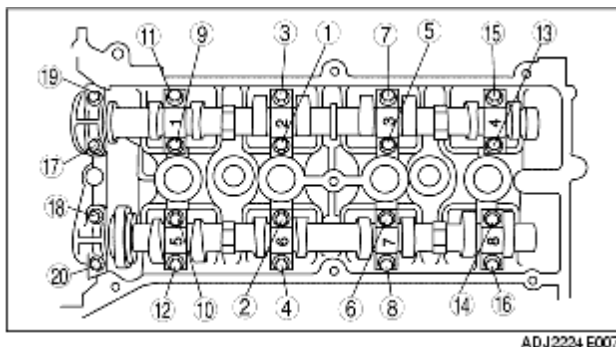
- (1) Tightening torque  
17.5-22.5 N·m {1.79-2.29 kgf·m, 13.0-16.5 ft·lbf}
- (2) Tightening angle  
85°-95°
- (3) Tightening angle  
85°-95°

## Camshaft Assembly Note

### Note

- Install the camshaft with the No.1 camshaft positioned at TDC of the compression stroke.

1. Install the camshaft cap to the position shown in the figure, and temporarily tighten the No.2 and No.7 camshaft installation bolts.



2. Tighten the camshaft cap installation bolts in two to three passes uniformly in the order shown in the figure.

- Tightening torque  
11.3-14.2 N·m {1.16-1.44 kgf·m, 8.4-10.4 ft·lbf}

## Camshaft Sprocket, Variable Valve Timing Actuator Assembly Note

1. Fix the camshaft using a suitable wrench on the cast hexagon as shown in the figure.

2. Tighten the camshaft sprockets and variable valve timing actuator installation bolts.

**Tightening torque****49.6-60.8 N·m {5.06-6.19 kgf·m, 36.6-44.8 ft·lbf}**