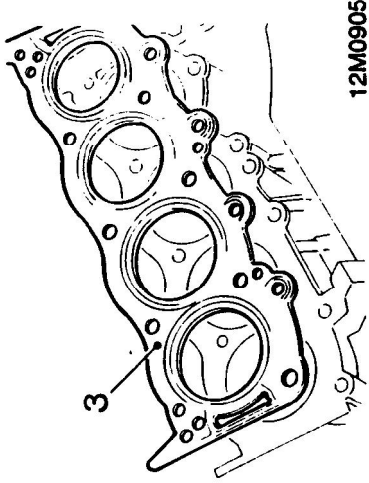


ENGINE

Cylinder head - refit

1. Clean cylinder block and cylinder head faces using suitable gasket removal spray and a plastic scraper.
2. Ensure that bolt holes in cylinder block are clean and dry.

 **CAUTION: Do not use metal scraper or machined surfaces may be damaged.**

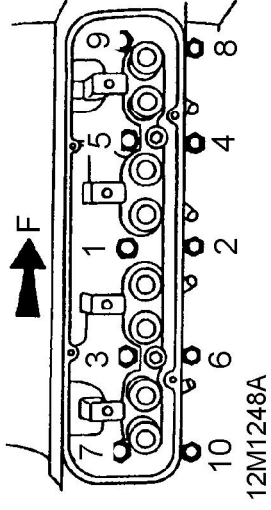


12M0905

3. Fit cylinder head gasket with the word 'TOP' uppermost.

 **NOTE: Gasket must be fitted dry.**

4. Carefully fit cylinder head and locate on dowels.
5. Lightly oil threads of new cylinder head bolts.



12M1248A

 **NOTE: RH cylinder head illustrated.**

6. Fit new cylinder head bolts:
Long bolts: 1, 3 and 5
Short bolts: 2, 4, 6, 7, 8, 9 and 10
Using sequence shown, tighten cylinder head bolts to:
Stage 1 - 20 Nm (15 lbf.ft)
Stage 2 - 90 degrees
Stage 3 - Further 90 degrees
- 7.

 **CAUTION: Do not tighten bolts 180° in one operation.**

Engines fitted with secondary air injection (SAI)

8. Fit new secondary air injection adapters and using a suitable hexagonal drive bit, tighten to 33 Nm (24 lbf.ft).

 **CAUTION: Do not use air tools to tighten adapters.**

All engines

9. Fit rocker shaft assembly.
10. Repeat above procedures for remaining cylinder head.