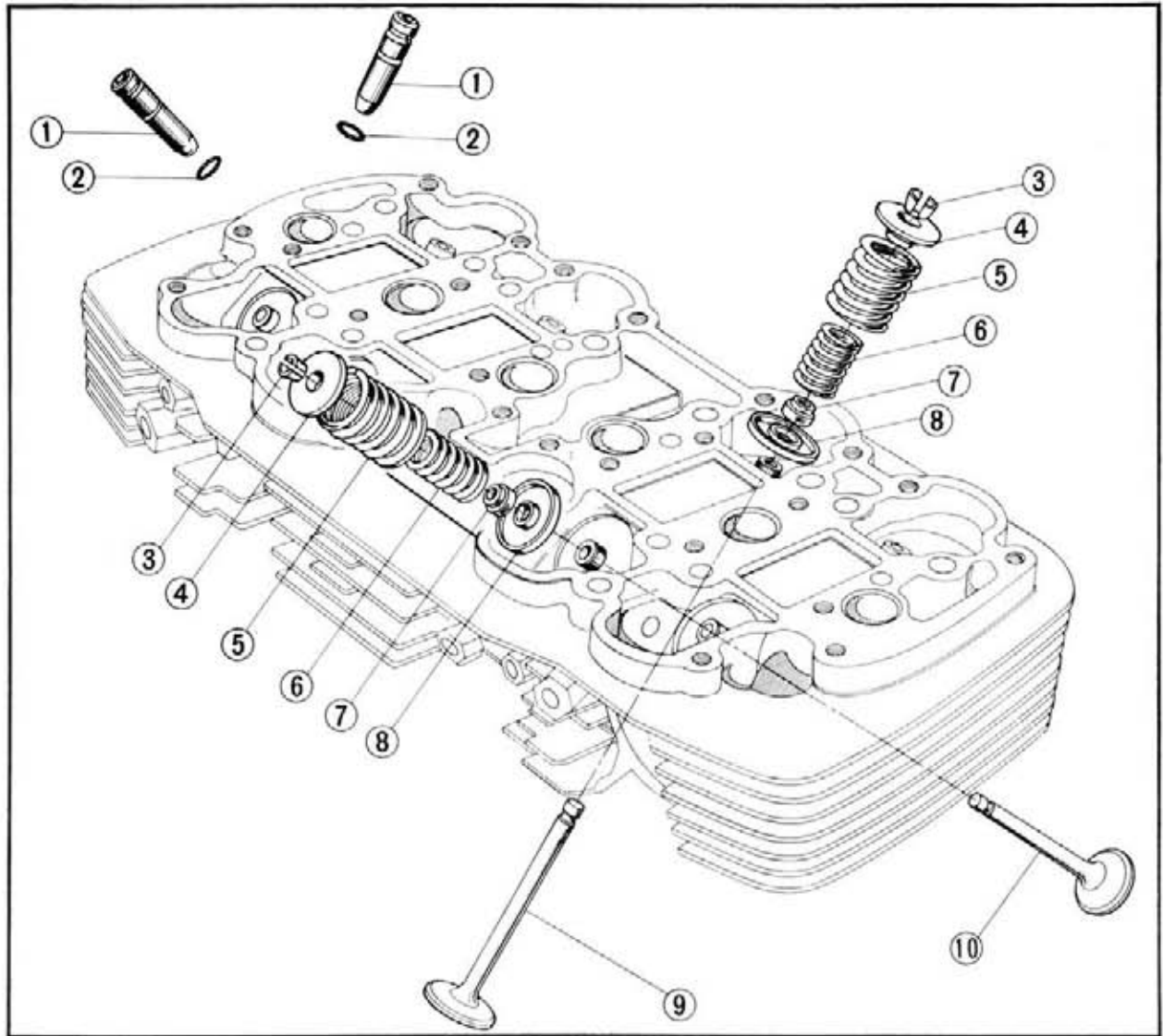


**d. Reassembly**

1. Clean the component parts of the cylinder head and assemble them in accordance with Fig. 3-55.



- |                      |                      |
|----------------------|----------------------|
| ① Valve guide        | ⑥ Inner valve spring |
| ② Set ring           | ⑦ Valve stem seal    |
| ③ Valve cotter       | ⑧ Valve spring seat  |
| ④ Valve retainer     | ⑨ Exhaust valve      |
| ⑤ Outer valve spring | ⑩ Inlet valve        |

Fig. 3-55

2. Install the cylinder head in accordance with section 3-3 d on page 36~38.
3. After assembling cylinder head, the valve tappet clearance should be performed to assure proper clearance in the following manner.
  - a. While slowly rotating the crankshaft clockwise (see arrow) watch the #1 cylinder inlet valve tappet. When this tappet retracts all the way and then starts to rise, watch for the alignment of the timing index mark and the "T" mark. Check the 1-4 cylinder mark. In this position the #1 piston will be at T.D.C. (top dead center) of the compression stroke, and both the inlet and exhaust valves in that cylinder should be fully closed. The valve tappet clearances of the valves marked with the O in the table on the next page can be checked. (Fig. 3-56)