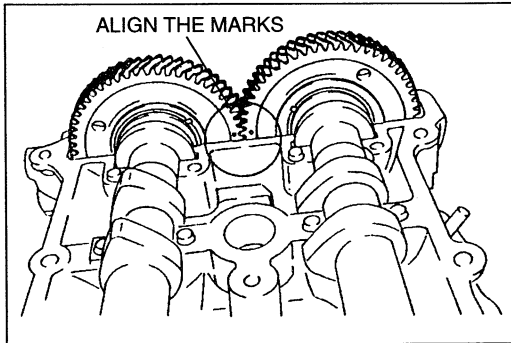


### HLA

1. Apply clean engine oil to the friction surfaces.
2. If the HLA are being reused, install them in the positions from which they were removed.
3. Verify that the HLA move smoothly in their bores.



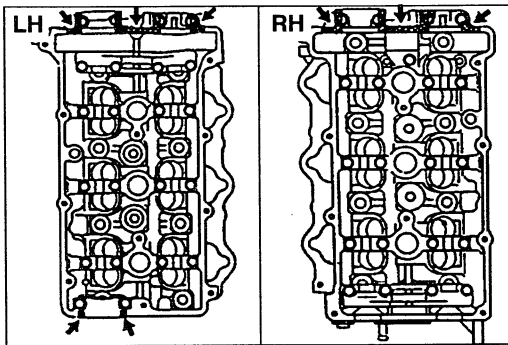
### Camshaft

#### Caution

- Camshafts must be assembled in the following procedure. Otherwise, camshaft can be broken or damaged because there is little camshaft clearance.

1. Apply clean engine oil to the camshaft journals and the supports.
2. Install the camshafts so that the intake camshaft gear mark and exhaust camshaft gear mark align.
3. Remove the oil and dirt from the mating surfaces between the front camshaft cap and the cylinder head, and degrease.
4. Apply a light coat of silicone sealant to the shaded areas shown.

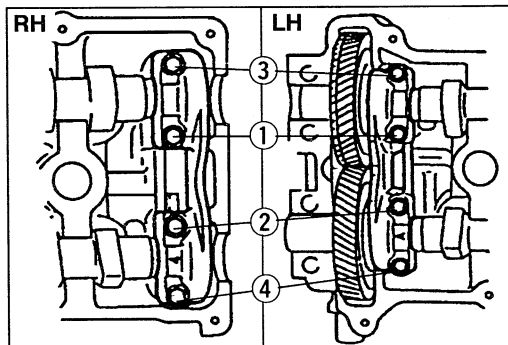
Thickness:  $\phi 1.5\text{--}2.5\text{ mm}$  {0.06—0.09 in}



#### Caution

- Install the thrust caps (RH is marked 4, LH is marked A) first. Otherwise, camshaft can be broken or damaged.

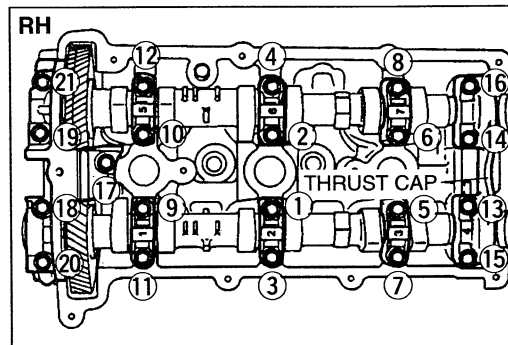
5. Install the thrust caps onto the cylinder heads. Hand tighten the bolts in five or six steps in the order shown, until the thrust caps fully seated on the cylinder heads.

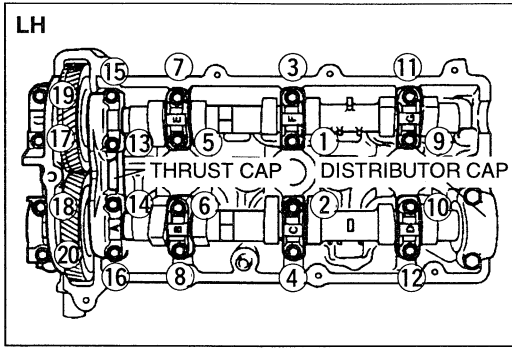


6. Install the camshaft caps onto the cylinder heads. Hand tighten the bolts gradually in five or six steps in the order shown, until the camshaft caps fully seated on the cylinder heads.
7. Tighten the bolts in the order shown.

#### Tightening torque:

11.3—14.2 N·m {115—145 kgf·cm, 100—125 in·lbf}





8. Retighten the bolts in the order shown.

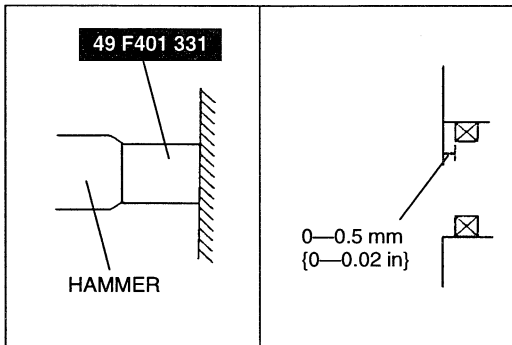
**Tightening torque:**

11.3—14.2 N·m {115—145 kgf·cm, 100—125 in·lbf}

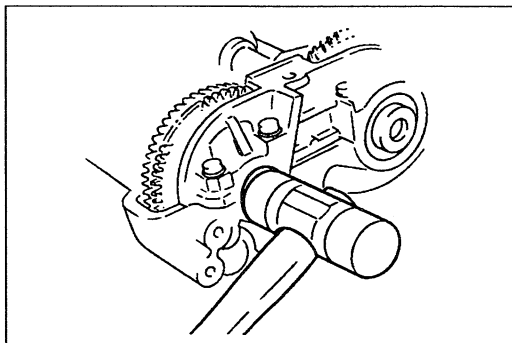
- 9. Install the distributor cap onto the cylinder head. (LH)
- 10. Tighten the distributor cap bolts.

**Tightening torque:**

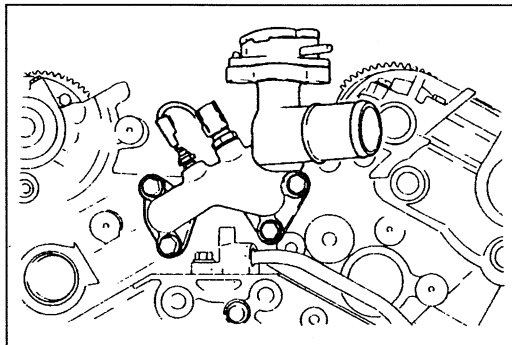
11.3—14.2 N·m {115—145 kgf·cm, 100—125 in·lbf}



- 11. Apply clean engine oil to the lip of the new camshaft oil seal.
- 12. Push the oil seal slightly in by hand.
- 13. Using the **SST** and a hammer, tap the camshaft oil seal in evenly until it is flush with the edge of the camshaft cap.



14. Tap in the new blind cap by using a plastic hammer.

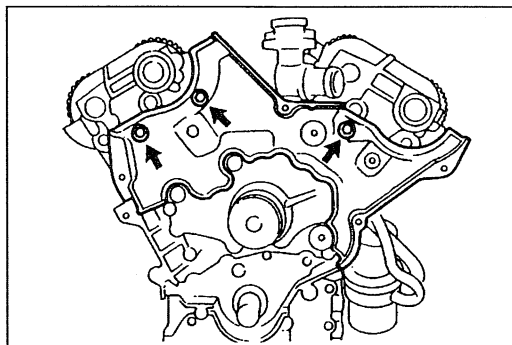


**Water Outlet**

Install the water outlet with new O-rings.

**Tightening torque:**

19—25 N·m {1.9—2.6 kgf·m, 14—18 ft·lbf}



**Seal Plate**

Install the seal plate.

**Tightening torque:**

7.9—10.7 N·m {80—110 kgf·cm, 70—95.4 in·lbf}