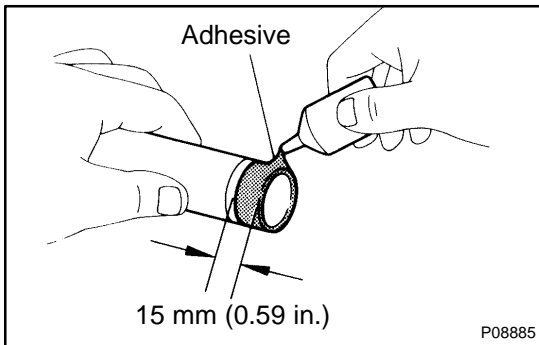


# REASSEMBLY

**HINT:**

- Thoroughly clean all parts to be assembled.
- Before installing the parts, apply new engine oil to all sliding and rotating surfaces.
- Replace all gaskets and oil seals with new ones.



## 1. INSTALL SPARK PLUG TUBES

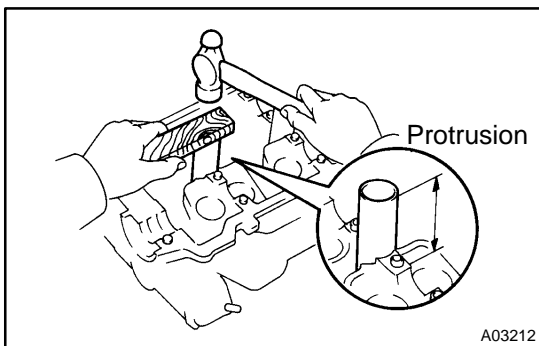
**HINT:**

When using a new cylinder head, spark plug tubes must be installed.

- (a) Apply adhesive to the end of the spark plug tube.

**Adhesive:**

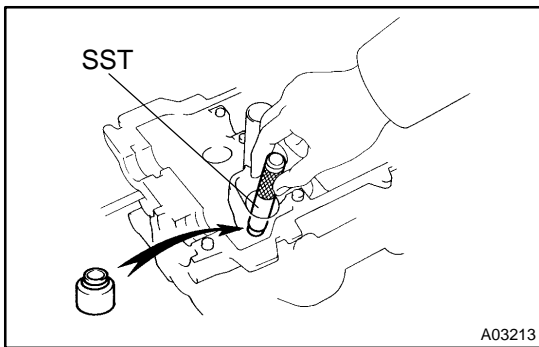
**Part No. 08833-00070, THREE BOND 1324 or equivalent**



- (b) Using a wooden block and hammer, tap in a new spark tube until there is 48.4 – 49.6 mm (1.906 – 1.953 in.) protruding from the camshaft bearing cap installation surface of the cylinder head.

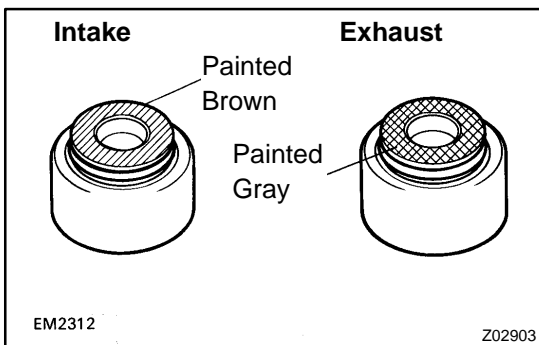
**NOTICE:**

**Avoid tapping a new spark plug tube in too far by measuring the amount of the protrusion while tapping.**



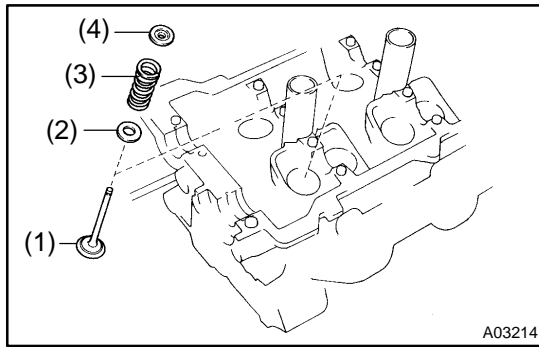
## 2. INSTALL VALVES

- (a) Using SST, push in a new oil seal.  
SST 09201-41020

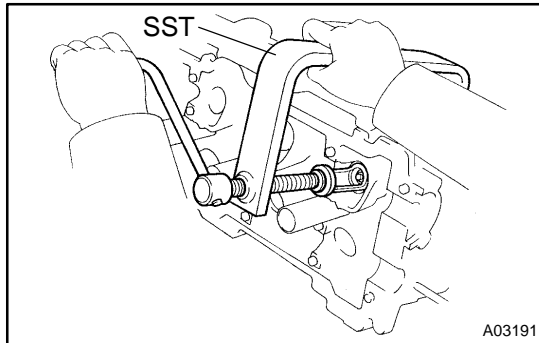


**HINT:**

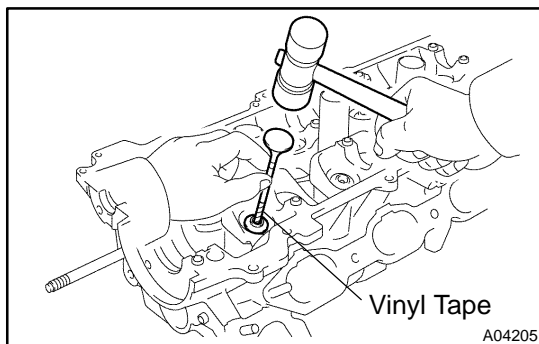
The intake valve oil seal is brown and the exhaust valve oil seal is gray.



- (b) Install these parts:
- (1) Valve
  - (2) Spring Seat
  - (3) Valve spring
  - (4) Spring retainer



- (c) Using SST, compress the valve spring and place the 2 keepers around the valve stem.  
SST 09202-70020 (09202-00010)



- (d) Using a plastic-faced hammer and the valve stem (not in use) tip wound with vinyl tape, lightly tap the valve stem tip to assure proper fit.

**NOTICE:**

**Be careful not to damage the valve stem tip.**

**3. INSTALL VALVE LIFTERS AND SHIMS**

- (a) Install the valve lifter and shim.
- (b) Check that the valve lifter rotates smoothly by hand.