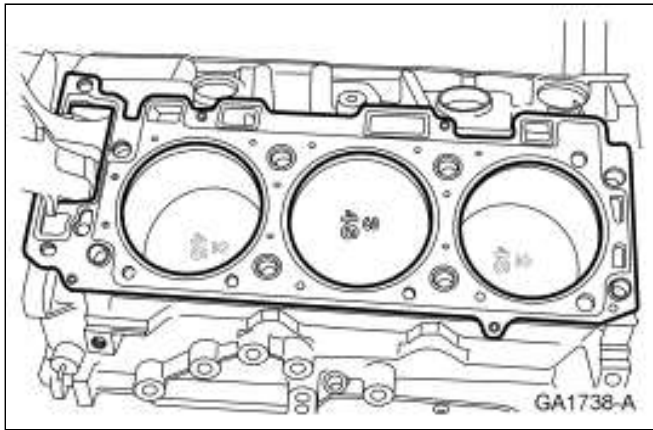


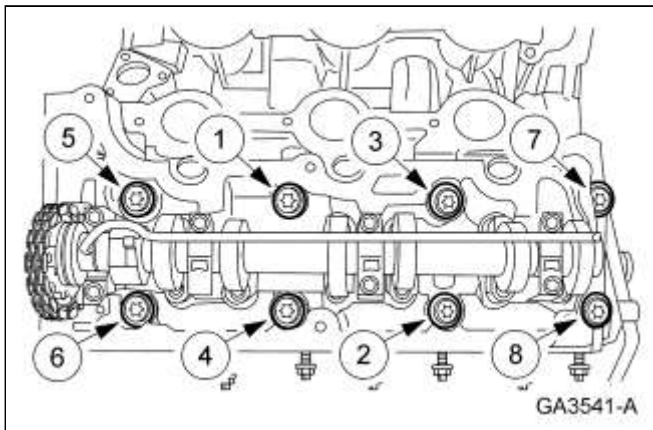
1. Position the cylinder head gasket and the cylinder head.



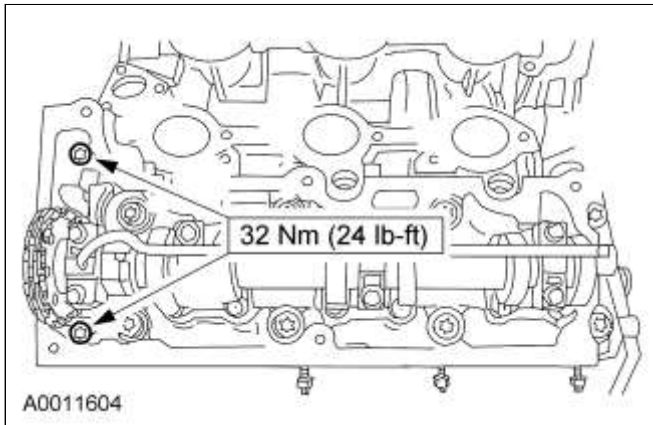
2. **NOTE:** Cylinder head bolts are a torque-to-yield design. New bolts must be installed.

Install the 12 mm (0.47 in) bolts and tighten in the sequence shown in two stages.

- Stage 1: Tighten to 12 Nm (9 lb-ft).
- Stage 2: Tighten to 25 Nm (18 lb-ft).

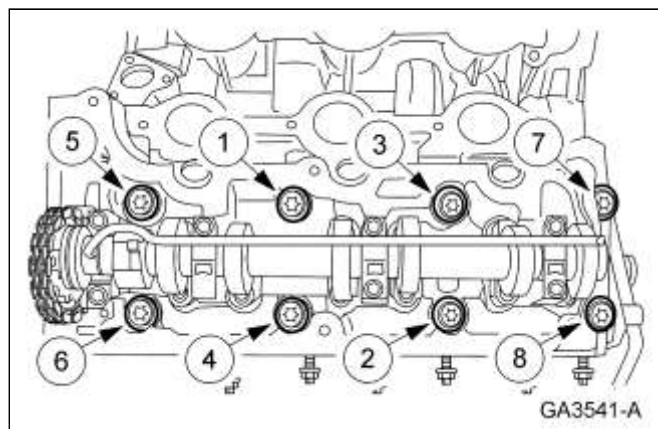


3. Install the two 8 mm (0.31 in) bolts.

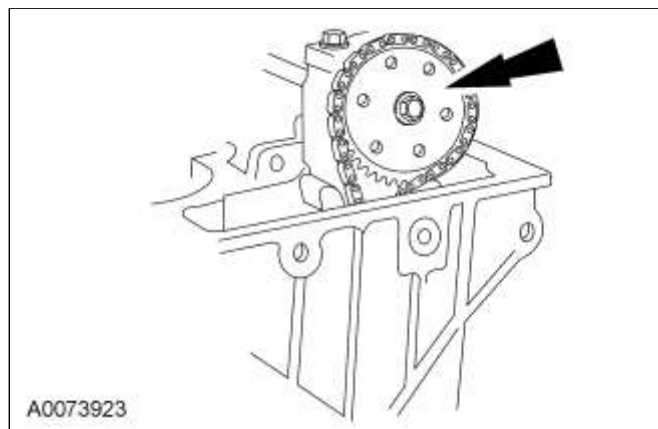


4. Tighten the eight 12 mm (0.47 in) bolts in two stages in the sequence shown.

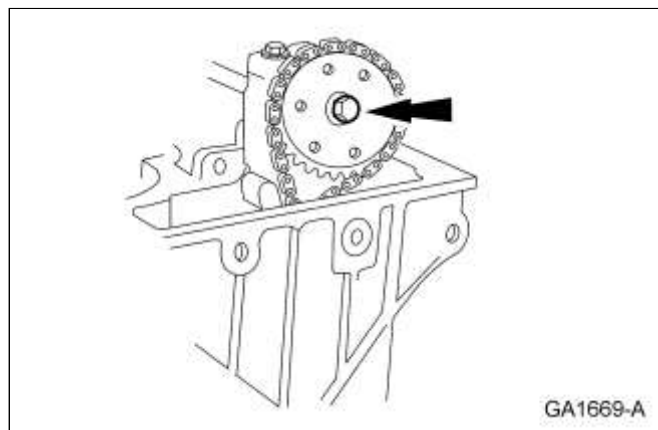
- Stage 1: Tighten the bolts 90 degrees.
- Stage 2: Tighten the bolts an additional 90 degrees.



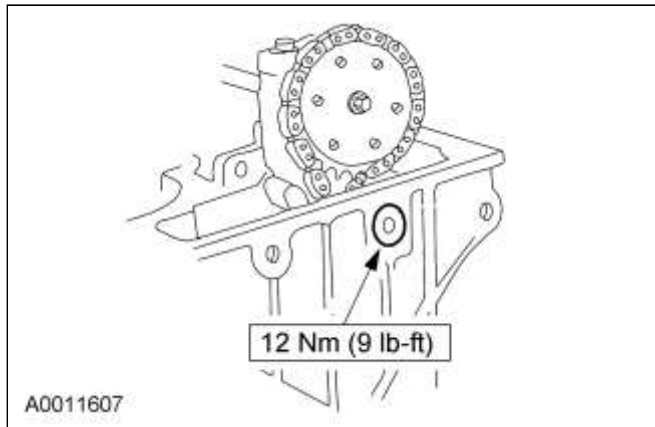
5. Install the LH camshaft sprocket in the cassette.



6.  **CAUTION:** The camshaft sprocket must turn freely on the camshaft. **DO NOT** tighten the bolt.  
Install the camshaft sprocket bolt.



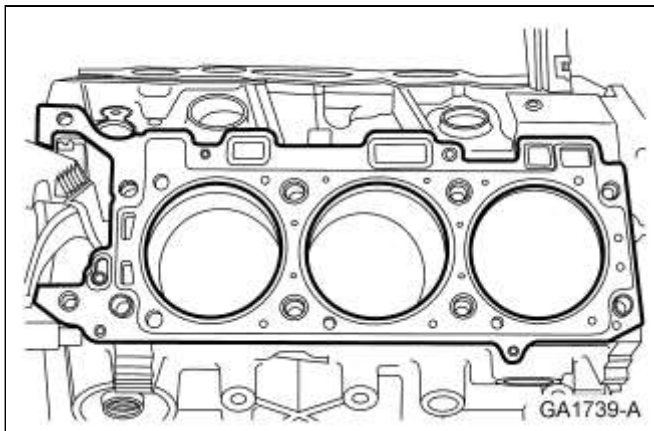
7. Install the chain guide bolt.



8. Install the LH exhaust manifold. For additional information, refer to [Exhaust Manifold LH](#) in this section.

### RH cylinder head

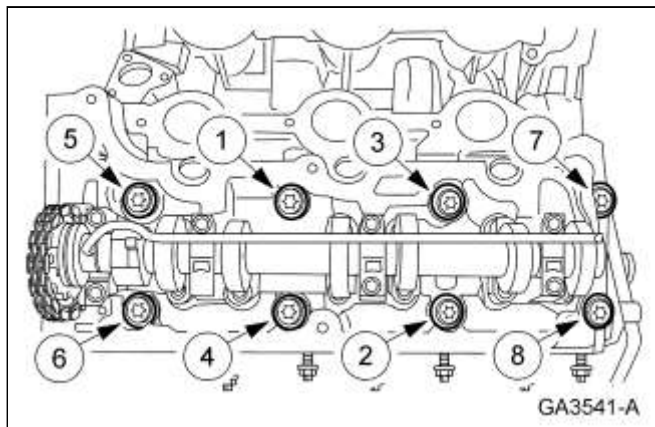
9. Position the cylinder head gasket and the cylinder head.



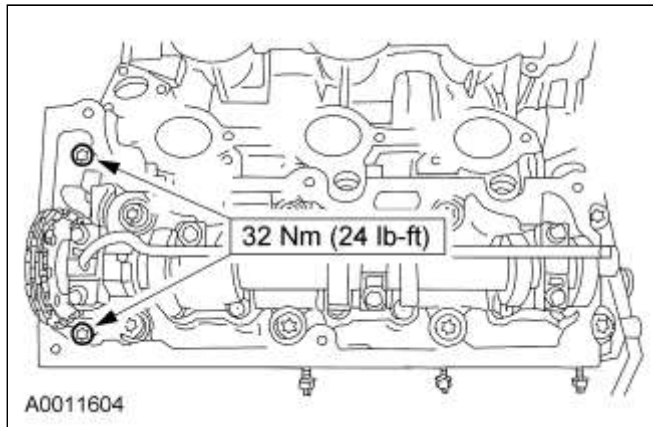
10. **NOTE:** Cylinder head bolts are a torque-to-yield design. New bolts must be installed.

Install the 12 mm (0.47 in) bolts and tighten in the sequence shown in two stages.

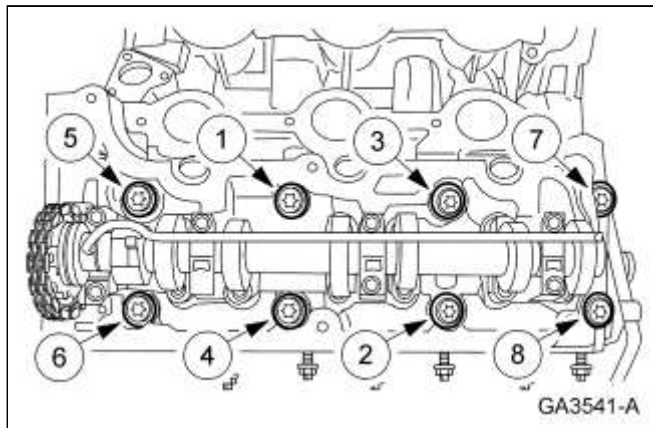
- Stage 1: Tighten to 12 Nm (9 lb-ft).
- Stage 2: Tighten to 25 Nm (18 lb-ft).



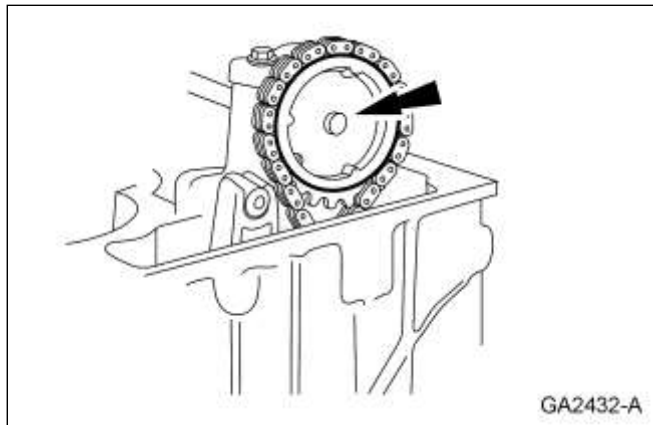
11. Tighten the two 8 mm (0.31 in) bolts.




12. Tighten the eight 12 mm (0.47 in) bolts in two stages in the sequence shown.
- Stage 1: Tighten the bolts 90 degrees.
  - Stage 2: Tighten the bolts an additional 90 degrees.



13. Install the RH camshaft sprocket in the cassette.



14.  **CAUTION:** The camshaft sprocket must turn freely. **DO NOT** tighten the bolt.
- Install the RH camshaft sprocket bolt.