

## Engine Reassembly

### Oil Filter

Put a small quantity of oil on the mounting surface and tighten by hand.

### Engine Stop Solenoid

Tighten the engine stop solenoid with pliers, lightly.

### Cylinder Head Assembly

Rotate the crankshaft to get the piston to Top Dead Center (TDC) and then measure the projection or depression from the face of the cylinder block with a depth gauge or dial gauge.

*Note: Measure while pushing down the piston lightly by hand.*

*Use the cylinder with the largest projection or distance among the cylinders as reference. The variation among all the cylinders should be within 0.1 mm in measured value.*

Select a head gasket based on the measured values below.

Engine Model.	Measured Value (mm)	Thickness when tightened
<b>753</b>	<b>0.50 - 0.65</b>	<b>t = 1.2</b>
	<b>0.65 - 0.75</b>	<b>t = 1.3</b>
<b>773</b>	<b>0.55 - 0.65</b>	<b>t = 1.2</b>
	<b>0.65 - 0.75</b>	<b>t = 1.3</b>

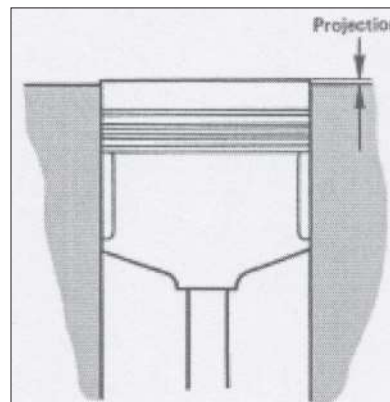
Tighten the cylinder head bolts in the order shown at right, in several steps. Tighten down with the below specified torque.

Cylinder head tightening torque:

**49 - 52 N•m (5.0 - 5.3 kgf•m) [36 - 38 ft.·lbs.]**

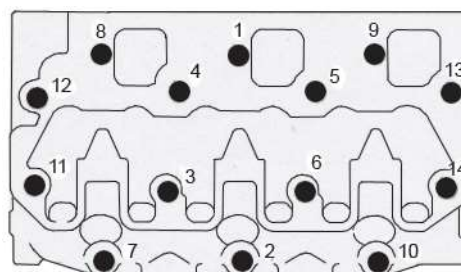
*Be careful of the spring pin which positions the cylinder head assembly.*

*Coat the threads with grease that contains disulfide molybdenum.*



ISMpiston

Tightening order



tighteningorder