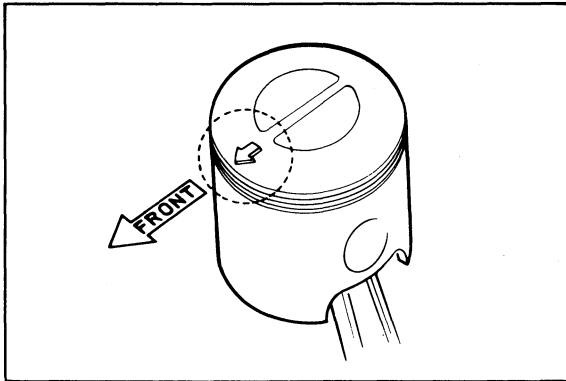


5. Oil the connecting rod, and install the piston. The arrow on the piston crown must point at the front of the engine.

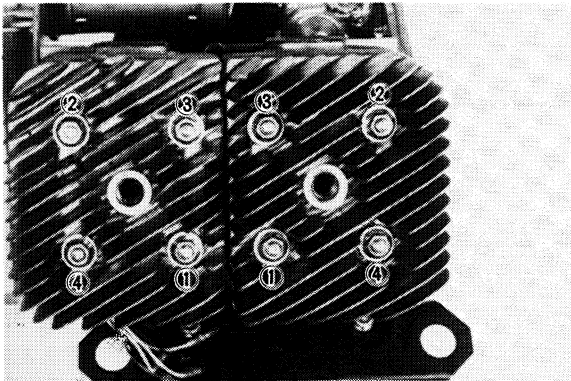


6. Oil the piston pin, and install it in the piston. Be sure the piston pin clip is correctly seated in the groove.
7. Oil the piston, and install the cylinder onto the crankcase. Use a new cylinder gasket.
8. Install cylinder head gasket and cylinder head. Working in a crisscross pattern, tighten head nuts in two steps.

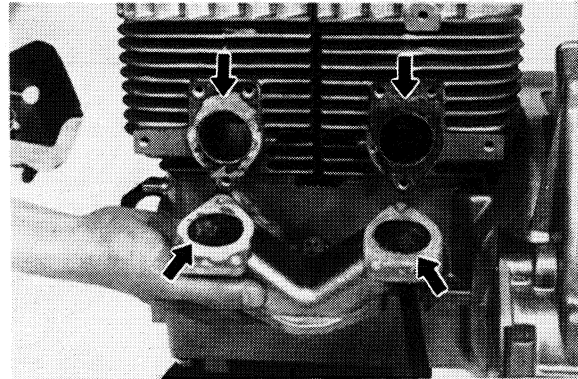
Head nut torque:

First: 20 Nm (2.0 m·kg, 14 ft·lb)

Final: 25 Nm (2.5 m·kg, 18 ft·lb)



9. Clean the mating surface of cylinder and joint.
10. Coat the mating surfaces of the intake manifold with Three Bond No. 50 and install new intake manifold gaskets.



11. Install intake manifold.

Tightening torque

11 Nm (1.1 m·kg, 8 ft·lb)