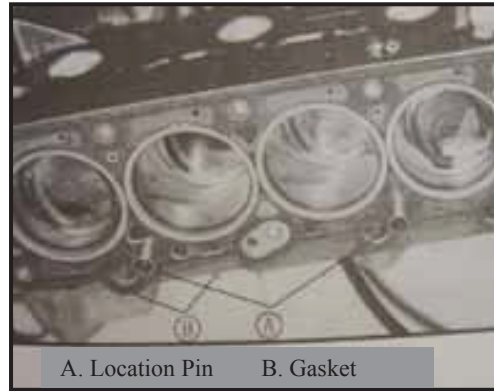


Put the cylinder gasket into the dowel.

Note: The side with indicator of the cylinder gasket shall be upward.

Install the cylinder head in place with the key slot of the cam shaft downward vertically.

Note: The cylinder gasket can only be used for one time, so the removed one shall be replaced with a new one when removing the cylinder head.



Put the bolts and the flat gasket of the cylinder head into the threaded hole to screw them in by hands.



Tighten the bolts of the cylinder head in four steps according to the order illustrated in the figure:

- First step: tighten it at the moment of 20-40N.
- Second step: tighten it at the moment of 20-40N.
- Third step: rotate 90 degrees.
- Fourth step: rotate 90 degrees.
- Moment-angular tension indicating wrench can be used for degree rotation.

