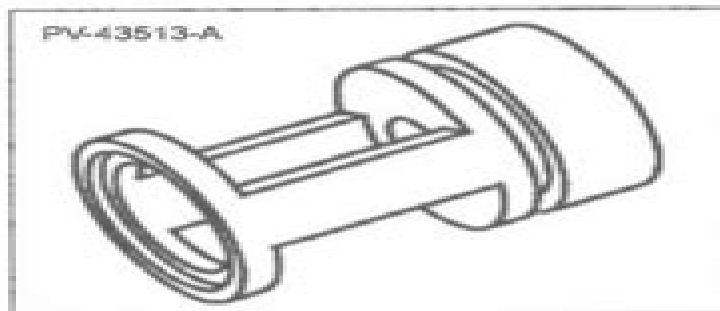
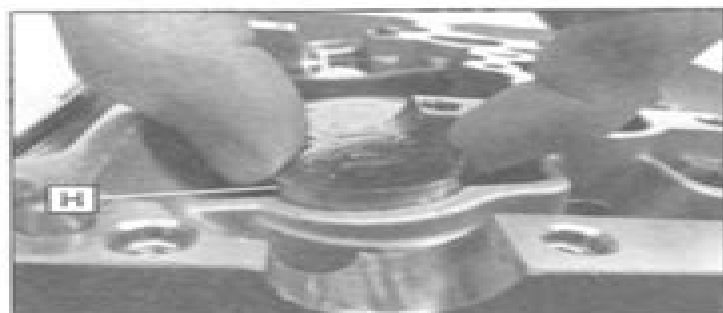


7. Compress the valve spring by hand using valve spring compressor adapter (PV-43513-A). Compress spring only enough to allow split keeper installation.



NOTE: To prevent damage to the valve seals, do not compress the valve spring more than necessary to install the keepers.

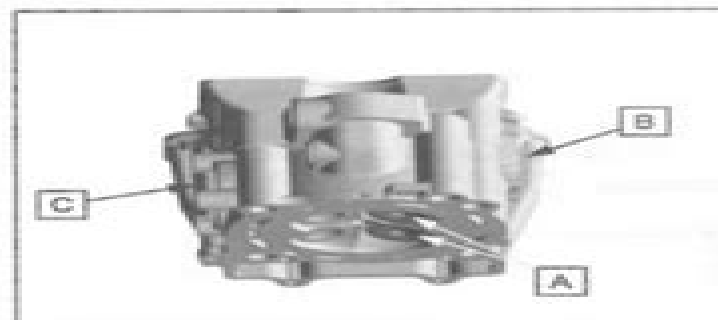
8. Install split keepers (E) with gap even on both sides.
 9. Repeat this procedure for remaining valves.
 10. Exercise each valve through its travel to ensure the valve keepers are seated correctly.
 11. Install the valve tappet (H) for each valve in the order they were removed.



NOTE: If any valve train components were replaced, refer to "Valve Clearance Adjustment" procedure prior to "Camshaft Installation / Timing" procedure.

Valve Sealing Test

1. Clean and dry the combustion chamber area (A).
2. Pour a small amount of clean solvent into each intake port (B) and check for leakage around the valves. The valve seats should hold fluid with no seepage.
3. Repeat for exhaust valves by pouring fluid into each exhaust port (C).



Cylinder Head Installation

NOTE: Head gasket and surfaces must be DRY and oil free. Use care during assembly to keep oil and finger prints off of gasket.

1. Prepare cylinder head gasket sealing surfaces by cleaning thoroughly to remove all residue. The new head gasket must be installed clean and dry, free from oil or grease.

NOTE: Do not touch sealing surfaces of the new head gasket.

2. Guide cam chain (D) through a new head gasket (E) and install the gasket on the cylinder, locating it on the alignment pins.
3. Carefully set the cylinder head (F) in place on alignment pins.

NOTE: Install new cylinder head bolts.

4. Install and finger tighten the (4) new cylinder head bolts (G) evenly.
5. Install and finger tighten the (2) new outer M6 bolts (H) evenly.

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Alan Ahlstrand, John Harold Haynes

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