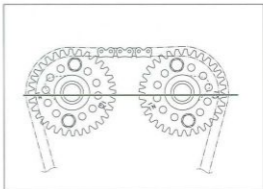


Apply molybdenum oil solution to the camshaft journals of the cylinder head and camshaft holder.

Install the cam chain over the cam sprockets and then install the intake and exhaust camshafts.

- Install each camshaft to the correct locations with the identification marks.
"IN": Intake camshaft
"EX": Exhaust camshaft
- Make sure that the timing marks on the cam sprockets are facing outward and flush with the cylinder head upper surface as shown.



Apply molybdenum oil solution to the camshaft holder as shown.

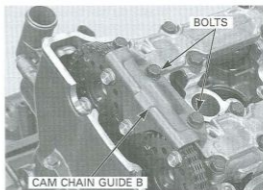
Be sure the dowel pins in the camshaft holder align properly with the holes in the cylinder head.



Install the camshaft holder onto the camshafts.

Apply engine oil to the threads and seating surfaces of the camshaft holder bolts.

Install the cam shaft holder B and holder bolt (color: silver) from the front side of the cam sprockets. Install the twenty bolts to the cam shaft holder. Finger tighten the bolts.



The camshaft holder has the number "1" through 20 cast into it.

Gradually tighten the #6, #5, #8, and #7 bolts (in that order) 1/4 to 1/2 turn at a time to draw the holder down evenly until the clearance between the cylinder head and the holder is 2 - 3 mm all the way around.

If the holder tilts toward the #1 cylinder during this process, readjust bolts #6, #5, #8, and #7 as necessary to keep the holder level.

When the holder is parallel with the cylinder head, resume tightening the bolts in the sequence specified above.

