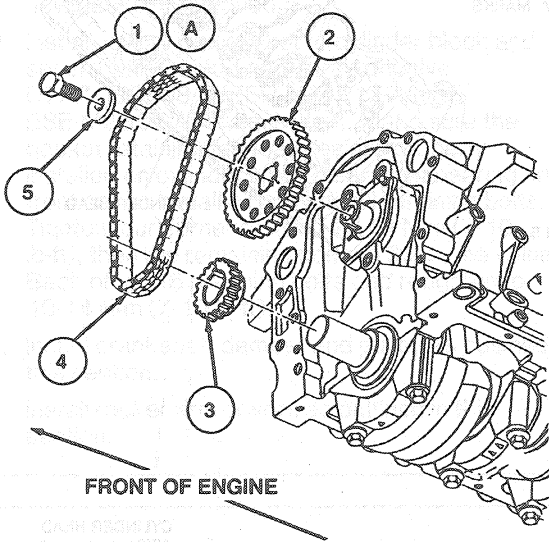


## REMOVAL AND INSTALLATION (Continued)

7. Lubricate timing chain and sprockets with Engine Assembly Lubricant D9AZ-19579-D (ESR-M99C80-A) or equivalent. Align marks as illustrated. Inspect camshaft sprocket bolt for blockage of drilled oil passages and clean as required. Install bolt and washer and tighten to 50-70 N·m (41-52 lb-ft).



A8590-C

Item	Part Number	Description
1A	6279	Bolt
2	6256	Camshaft Sprocket
3	6306	Crankshaft Sprocket
4	6268	Timing Chain Lubricate With Oil
5	6278	Washer-Cam Sprocket
A		Tighten to 50-70 N·m (37-51 Lb-Ft)

TA8590C

8. Lubricate tappets and bore with Engine Assembly Lubricant D9AZ-19579-D (ESR-M99C80-A) or equivalent.
9. Install tappets into original bores.  
NOTE: Install plate with the word "UP" and or button visible.

10. Aligning tappet flats, install tappet guide plate.
11. Install guide plate retainer assembly over guide plates. Hand start two retaining bolts. Tighten bolts to 12 N·m (9 lb-ft).
12. Apply a 6mm 1/4 inch drop of Silicone Rubber D6AZ-19562-AA or BA (ESB-M4G92-A) or equivalent to intersection of cylinder block and cylinder head assembly at four corners as shown.
13. Position intake gaskets onto cylinder heads. Align intake gasket locking tabs to the provisions on the cylinder head gaskets as shown.
14. Install front and rear intake manifold seals as shown. Secure with retaining features.
15. Carefully lower intake manifold into position aligning manifold bolt holes to those in the cylinder head. Use care to prevent disturbing the rubber sealer which can cause sealing voids. Install bolts No. one, two, three and four and hand tighten. Install remaining bolts and tighten in a two step process. Tighten in numerical sequence to 7-15 N·m (5-11 lb-ft), then again to 26-38 N·m (19-28 lb-ft).
16. On unleaded gasoline only, coat distributor gear teeth with Engine Assembly Lubricant D9AZ-19579-D (ESR-M99C80-A) or equivalent. Install distributor and align to premarked location on cylinder block and rotor position. Install retaining bolt and washer and hand tighten.
17. Apply Engine Assembly Lubricant D9AZ-19579-D (ESR-M99C80-A) or equivalent to removed push rods and rocker arms. Install push rods. Move rocker arms into position with push rod and valve stem.
18. Rotate crankshaft to align camshaft and crankshaft timing marks as shown to position "A". Tighten retaining bolts of specified rocker arms to 11 N·m (8 lb-ft) to seat fulcrums into cylinder head. Rotate crankshaft to position "B". Tighten retaining bolts of remaining rocker arms to 11 N·m (8 lb-ft). Final tighten bolts to 32 N·m (24 lb-ft) in any position. If new tappets are being installed check collapsed tappet gaps. Refer to Section 03-00.