

(1) Apply a coat of engine oil to the seal washers and bolt threads.

NOTE:

- Use a new seal washer.
- To prevent mixture of engine oil into the water jacket, do not apply a large amount.

(2) Tighten all bolts with a torque of 10 N·m (1.0 kgf-m, 7.4 ft-lb) in the numerical sequence as shown in the figure.

(3) Tighten all bolts with a torque of 45 N·m (4.5 kgf-m, 33.2 ft-lb) in the numerical sequence as shown in the figure.

(4) Loosen all bolts by 360° in the reverse order as shown in the figure.

(5) Tighten all bolts with a torque of 15 N·m (1.5 kgf-m, 11.1 ft-lb) in the numerical sequence as shown in the figure.

(6) Tighten all bolts with a torque of 23 N·m (2.3 kgf-m, 17.0 ft-lb) in the numerical sequence as shown in the figure.

(7) Tighten all bolts again with a torque of 23 N·m (2.3 kgf-m, 17.0 ft-lb) in the numerical sequence as shown in the figure.

(8) Tighten all bolts by 90° in numerical order as shown in the figure.

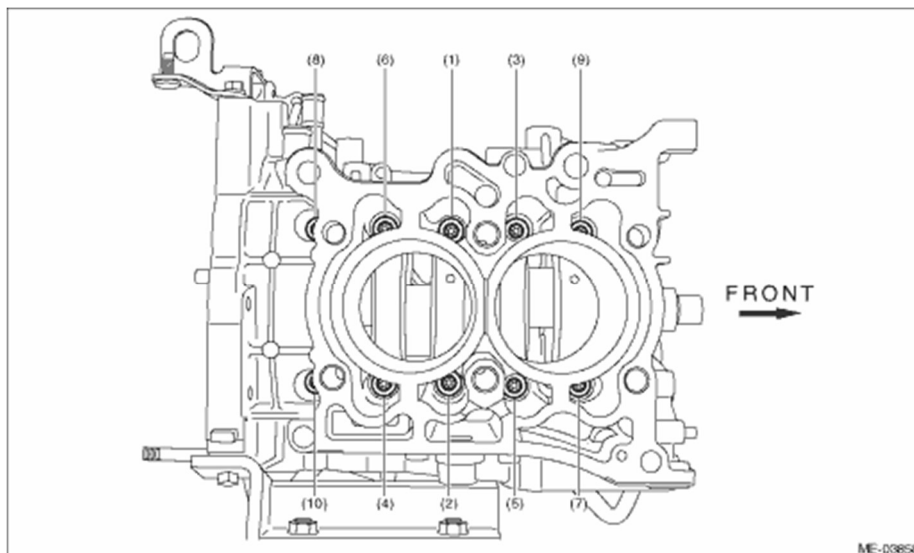
CAUTION:

The tightening angle of the bolt should not exceed 90°.

(9) Tighten bolts (1) – (6) bolts by 45° in numerical order as shown in the figure.

CAUTION:

The tightening angle of the bolt should not exceed 45°.



(10) Install the upper bolt to cylinder block.

Tightening torque:

25 N·m (2.5 kgf-m, 18.4 ft-lb)

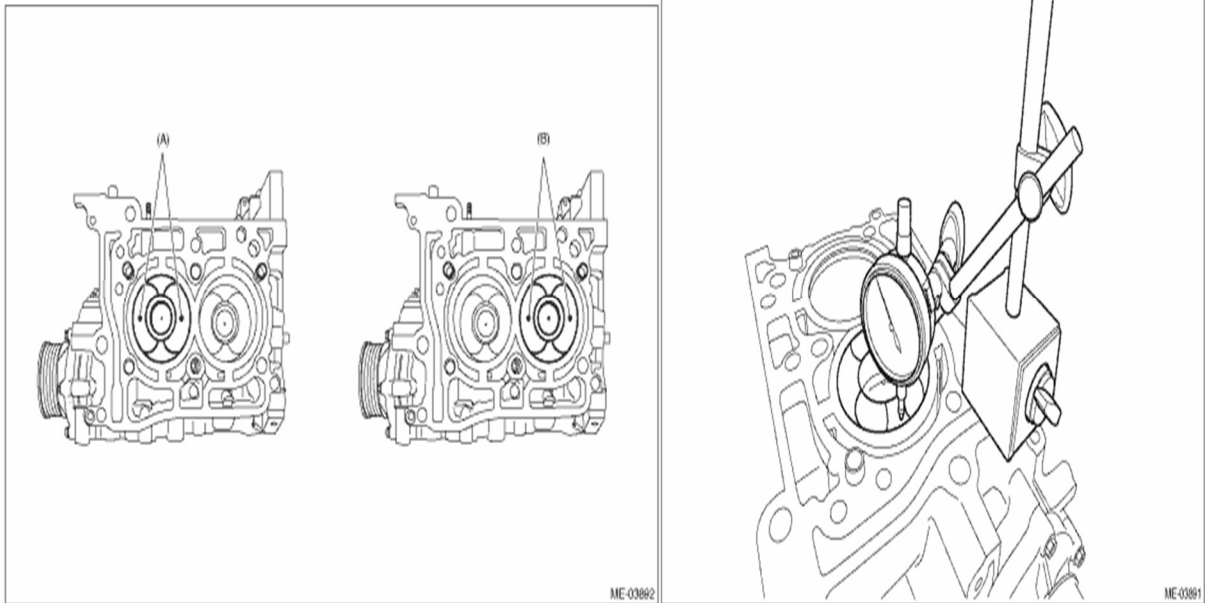
Amount of piston protrusion from the cylinder block end face:

Minimum value

0.200 mm (0.0079 in)

Maximum value

0.400 mm (0.0157 in)



Piston protrusion	Part No.	Thickness	Grade	Number of identification holes
0.200 mm (0.0079 in) — 0.275 mm (0.0108 in)	10944AA040	0.95 mm (0.0374 in)	A	1
0.275 mm (0.0108 in) — 0.325 mm (0.0128 in)	10944AA030	1.00 mm (0.0394 in)	B	2
0.325 mm (0.0128 in) — 0.400 mm (0.0157 in)	10944AA050	1.05 mm (0.0413 in)	C	3