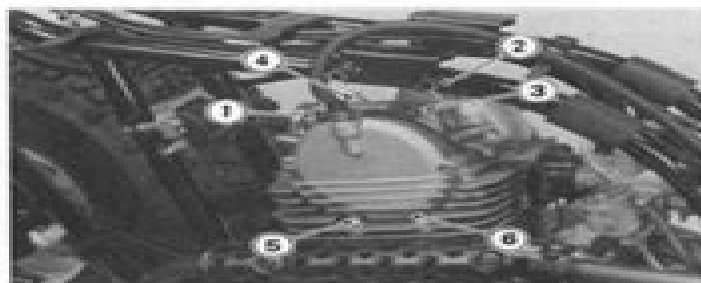


3-8 ENGINE TOP END

- Apply oil to the flanged portion of the cylinder head bolts, and install them.
- Tighten the cylinder head bolts in a criss-cross pattern as shown, in two steps.



Cylinder Head Bolt Torque

First Torquing

8 mm Bolt: 13 N·m (1.3 kg-m, 113 in-lb)

6 mm Bolt: 5.9 N·m (0.60 kg-m, 52 in-lb)

Final Torquing

8 mm Bolt: 25 N·m (2.5 kg-m, 18.0 ft-lb)

6 mm Bolt: 9.8 N·m (1.0 kg-m, 87 in-lb)

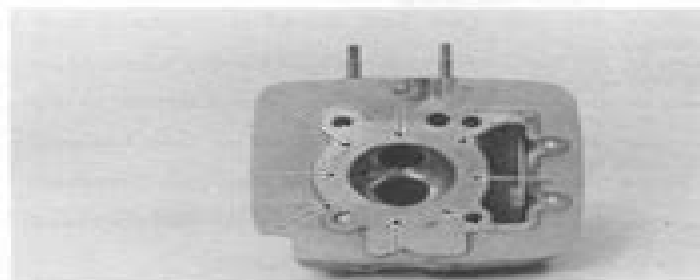
- Tighten the banjo bolts with new gaskets to the specified torque (see Exploded View).
- Install the cylinder head brackets, and tighten the bolts to the specified torque (see Exploded View in the Engine Removal/Installation chapter).
- Be sure that the collar is in place in the damper in each bracket.
- Install the camshaft sprocket (see Camshaft Sprocket Installation).
- Install the camshaft chain tensioner (see Camshaft Chain Tensioner Installation).
- Install the exhaust pipe and muffler (see Exhaust Pipe and Muffler Installation).
- Install the carburetor (see Carburetor Installation in the Fuel System chapter).
- Install the fuel tank (see Fuel Tank Installation in the Fuel System chapter).
- Install the seat (see Seat Installation in the Frame chapter).

Cylinder Head Cleaning

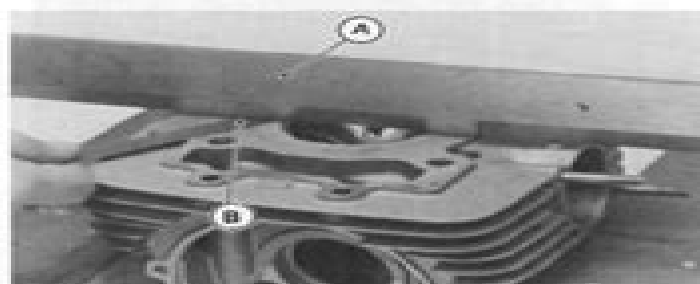
- Remove the cylinder head (see Cylinder Head Removal).
- Disassemble the cylinder head.
- Remove the following parts from the cylinder head, Camshaft, Valves and KACR Unit.
- Wash the head with a high flash-point solvent.
- Scrape the carbon out of the combustion chamber and exhaust port with a suitable tool.
- Assemble the cylinder head.
- Install the cylinder head (see Cylinder Head Installation).

Cylinder Head Warp

- Clean the cylinder head (see Cylinder Head Cleaning).
- Lay a straightedge across the lower surface of the cylinder head at the positions shown.



- Use a thickness gauge to measure the space between the straightedge and the head (see Specifications).



A. Straightedge

B. Thickness Gauge

- If the cylinder head is warped more than the service limit, replace it.
- If the cylinder head is warped less than the service limit, repair the head by rubbing the lower surface on emery paper secured to a surface plate (first No. 200, then No. 400).

Valves, Guides, Seats, Springs, Oil Seals

Valves:

Valve Clearance Check

NOTE

- Check the valve clearance only when the engine is cold (cool to the touch).

Klf185 Service Manual

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