

Check mating surface between cylinder and cylinder head for contamination. If so, clean both surfaces.

Clean of support through the cylinder head from contamination.



1. 20 pins to fix the timing chain guide (fixed)
2. 20 pins to fix the timing chain guide (flexible)
3. 20 pins to fix the timing chain guide (flexible)

#### Inspecting the Cylinder Head Camshaft Bearing

Measure camshaft bearing in cylinder head.



① 1000 long (mm) diameter

CAMSHAFT BEARING (TIMING CHAIN SIDE)	
Size	35.000mm to 35.025mm (1.3780 in to 1.3789 in)
Service limit	35.040mm (1.3789 in)

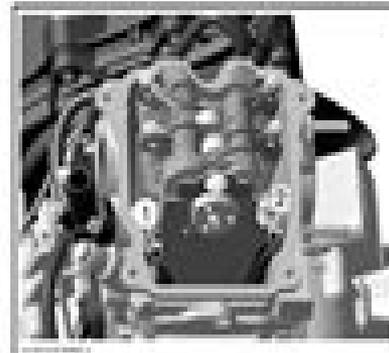
CAMSHAFT BEARING (SPARK PLUG SIDE)	
Size	33.000mm to 33.021mm (1.3007 in to 1.3017 in)
Service limit	33.040mm (1.3017 in)

#### Installing the Cylinder Head

For installation, reverse the removal procedure. Pay attention to the following details.

Ensure dowel pins are in place.

**NOTE** Timing chain guide (fixed) has to be fixed between cylinder and cylinder head.

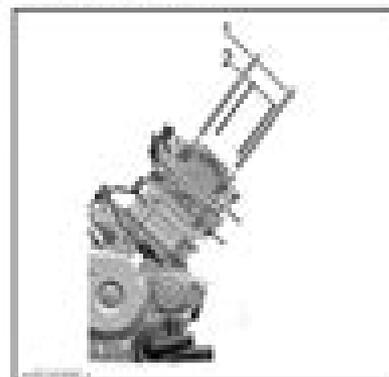


**NOTE**  
1. Study clear guide (between valve retainer and piston) using clear guide (fixed between cylinder and cylinder head)

Install a NEW cylinder head gasket.

Install cylinder head screws.

**NOTE** Check for proper lengths of the cylinder head screws.

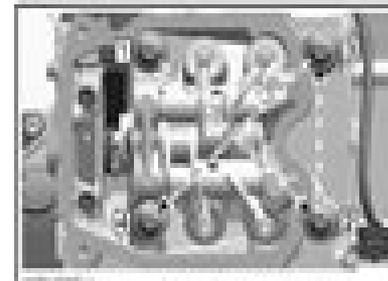


① 1000mm (mm)  
② 1000mm (mm)

#### CYLINDER HEAD SCREW IDENTIFICATION

LOCATION NO. 1	M10 x 120
LOCATION NO. 2	M8 x 100

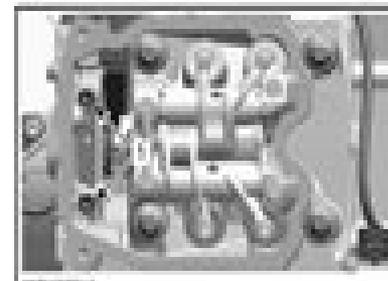
Tighten M10 cylinder head screws P107 as per following specifications.



TIGHTENING TORQUE - M10 CYLINDER HEAD SCREWS

M10 Cylinder head screws	TIGHTENING TORQUE	
	Step A	25Nm ± 1Nm (18.5lbfm ± 0.7lbfm)
	Step B	100° ± 1°

Tighten M8 cylinder head screws as per following specification.



TIGHTENING TORQUE

M8 Cylinder head screws	10Nm ± 1Nm (8.8lbfm ± 0.7lbfm)
-------------------------	-----------------------------------

Check timing chain guide (between side) for movement.

#### VALVE SPRINGS

##### Removing the Valve Spring

Refer to following procedures in this subsection to remove:

- CAMSHAFT
- CYLINDER HEAD

Compress valve spring

REQUIRED TOOL	
VALVE SPRING COMPRESSOR (PN 129 036 234)	
VALVE SPRING COMPRESSOR CUP (PN 129 036 270)	



① 1000 valve spring compressor is correct of the size

Remove valve cotter.



① Valve spring retainer  
② Valve spring compressor cup  
③ Valve spring

Remove tools and withdraw valve spring retainer and valve spring.

# Pc 800 Service Manual

**Huangqi Zhang**



## **Pc 800 Service Manual:**

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