3) Loosen the piston assembly (23), and align the hole
   position in order to install the screw (24).

   REMARK

   • Do not loosen the piston assembly (23) too much.

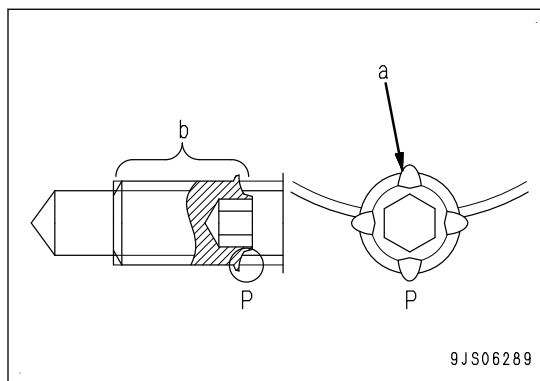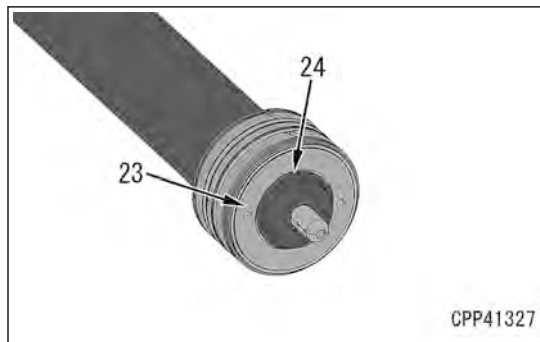4) Install the screw (24), and fix the piston assembly
   (23).

   Threaded portion of the screw (24):
       Liquid adhesive (Loctite No. 262 or equiva-
       lent)

   Screw (24):
       58.9 to 73.6 Nm {6 to 7.5 kgm}

   NOTICE

   **After installing the screw (24), punch the screw
   (24) at 4 peripheral places (a) to prevent it from re-
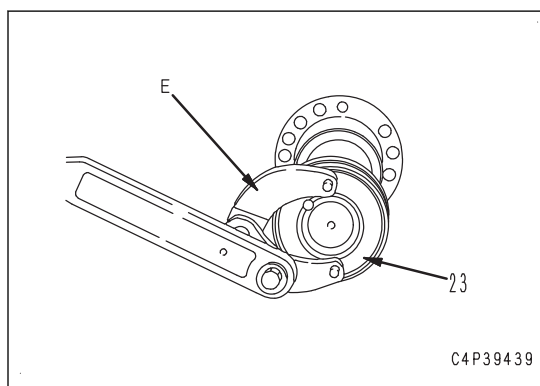   moving.**

CPP41327

9JS06289

27. When replacing one or both of the piston rod (22) and pis-
    ton assembly (23) with new ones, install the new ones ac-
    cording to the following procedure.

   1) By using the wrench assembly (E), tighten the piston
      assembly (23) until it stops.

      Piston assembly (23):
          294±29.4 Nm {30±3.0 kgm}

C4P39439

   2) Drill a screw hole for the screw (24) in the threaded
      portions of the piston rod (22) and piston assembly
      (23).

      Tap hole diameter of the screw (24) 10.3 mm
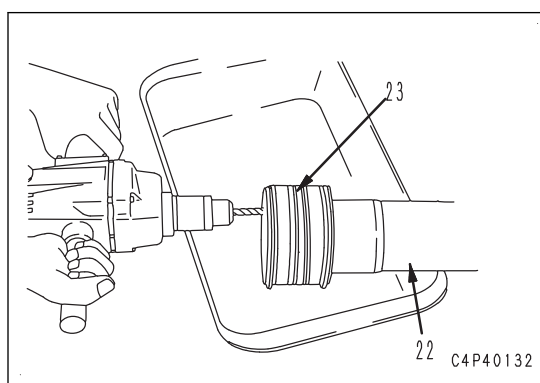
      Tap hole depth of the screw (24) 27 mm

   3) Drill a screw hole to the tap hole of the screw (24).

      Screw hole size of the screw (24) M12, pitch 1.75 mm

      Screw hole depth of the screw (24) 20 mm

      NOTICE

      **After drilling the screw hole, remove chips and
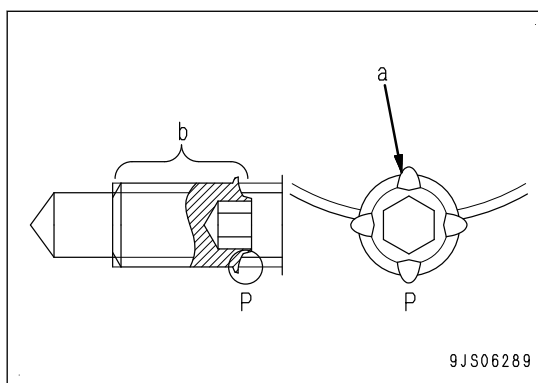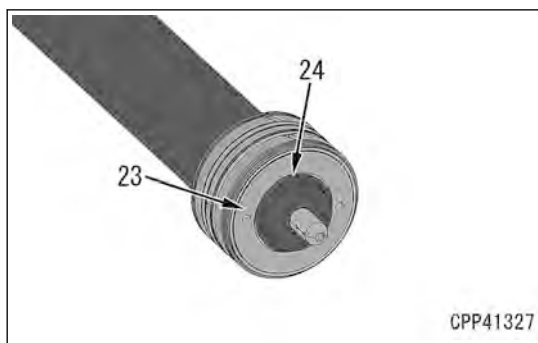   other dirt and thoroughly clean the area.**

C4P40132

4) Install the screw (24), and fix the piston assembly (23).

> Threaded portion of the screw (24):
> Liquid adhesive (Loctite No. 262 or equivalent)

> Screw (24):
> 58.9 to 73.6 Nm {6 to 7.5 kgm}

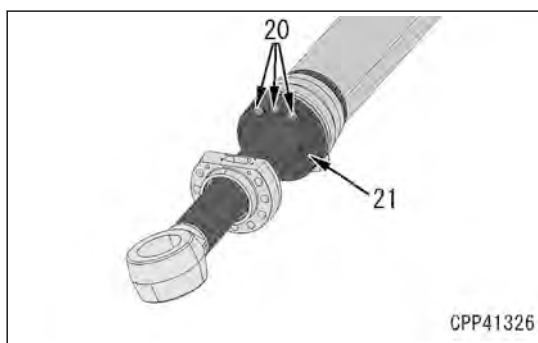**NOTICE**

After installing the screw (24), punch the screw (24) at 4 peripheral places (a) to prevent it from removing.

CPP41327

9JS06289

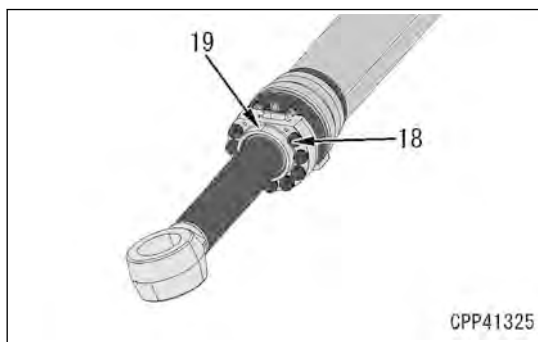28. Install the cylinder head assembly (21) with the bolts (20) (3 pieces).

> Bolt (20):
> 530±78.5 Nm {54.0±28.0 kgm}

Bolt (20) hexagonal socket width across flats: 17 mm

CPP41326

29. Install the housing assembly (19) with the bolts (18) (9 pieces).

> Bolt (18):
> 530±78.5 Nm {54.0±28.0 kgm}

CPP41325

Tube

30. Install the bands (50), (51), (52), and (53).

NOTICE

Tighten the bands (50), (51), (52), and (53) lightly since the angle will be adjusted later.

CPP41345