

## SECTION **EM**

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## PRECAUTIONS

### Supplemental Restraint System (SRS) "AIR BAG"

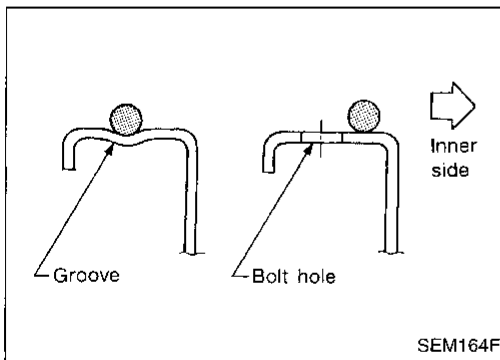
The Supplemental Restraint System "Air Bag", used along with a seat belt, helps to reduce the risk or severity of injury to the driver and front passenger in a frontal collision. The Supplemental Restraint System consists of air bag modules (located in the center of the steering wheel and on the instrument panel on the passenger side), sensors, a diagnosis unit, warning lamp, wiring harness and spiral cable. Information necessary to service the system safely is included in the **RS section** of this Service Manual.

#### WARNING:

- To avoid rendering the SRS inoperative, which could increase the risk of personal injury or death in the event of a collision which would result in air bag inflation, all maintenance must be performed by an authorized NISSAN dealer.
- Improper maintenance, including incorrect removal and installation of the SRS, can lead to personal injury caused by unintentional activation of the system.
- Do not use electrical test equipment on any circuit related to the SRS unless instructed to in this Service Manual. SRS wiring harnesses are covered with yellow insulation either just before the harness connectors or for the complete harness, for easy identification.

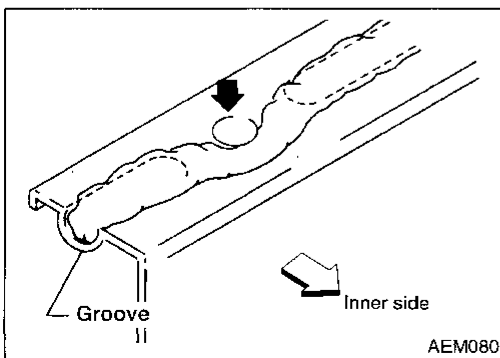
### Parts Requiring Angular Tightening

- Use an angle wrench for the final tightening of the following engine parts:
  - (1) Cylinder head bolts
  - (2) Connecting rod cap nuts.
- Do not use a torque value for final tightening.
- The torque value for these parts are for a preliminary step.
- Ensure thread and seat surfaces are clean and coated with engine oil.



### Liquid Gasket Application Procedure

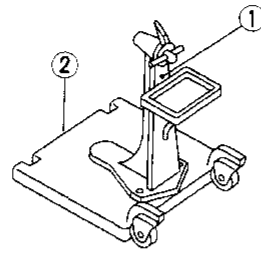
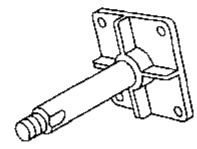
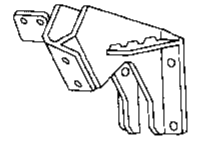
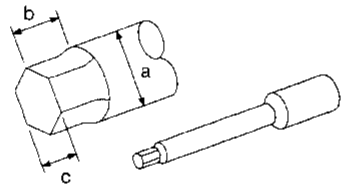
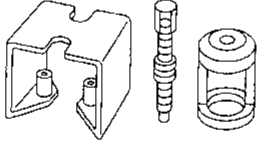
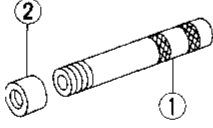
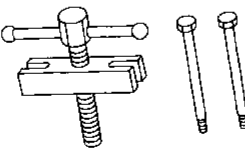
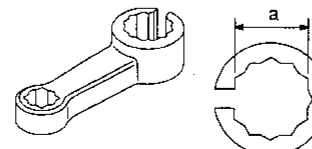
- Use a scraper to remove all traces of old liquid gasket from mating surfaces and grooves. Also, completely clean any oil from these areas.
- Apply a continuous bead of liquid gasket to mating surfaces. (Use Genuine Liquid Gasket or equivalent.)
  - Be sure liquid gasket is 3.5 to 4.5 mm (0.138 to 0.177 in) wide (for oil pan).
  - Be sure liquid gasket is 2.0 to 3.0 mm (0.079 to 0.118 in) wide (in areas except oil pan).
- Apply liquid gasket around the inner side of bolt holes (unless otherwise specified).
- Assembly should be done within 5 minutes after coating.
- Wait at least 30 minutes before refilling engine oil and engine coolant.



# PREPARATION

## Special Service Tools

The actual shapes of Kent-Moore tools may differ from those of special service tools illustrated here.

Tool number (Kent-Moore No.) Tool name	Description	GI
ST0501S000 ( — ) Engine stand assembly ① ST05011000 ( — ) Engine stand ② ST05012000 ( — ) Base	 Disassembling and assembling NT042	MA
KV10106500 ( — ) Engine stand shaft	 NT028	EC
KV10110001 ( — ) Engine sub-attachment	 NT032	CL
ST10120000 (J24239-01) Cylinder head bolt wrench	 Loosening and tightening cylinder head bolt NT583 a: 13 mm (0.51 in) dia. b: 12 mm (0.47 in) c: 10 mm (0.39 in)	AT
KV10111300 ( — ) Valve spring compressor	 Disassembling and assembling valve components NT017	PD
① KV10107501 ( — ) Valve oil seal drift ② KV10111400 ( — ) Attachment	 Installing valve oil seal NT026	FA
ST27180001 (J25726-A) Steering wheel puller	 Removing crankshaft pulley NT170	RA
KV10114400 (J38365) Heated oxygen sensor wrench	 Loosening or tightening heated oxygen sensor NT636 a: 22 mm (0.87 in)	BR

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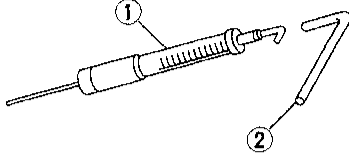
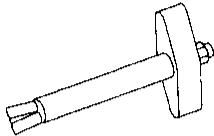
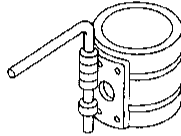
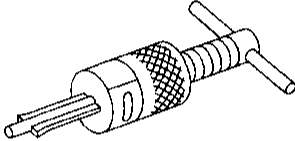
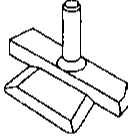
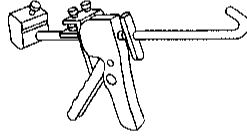
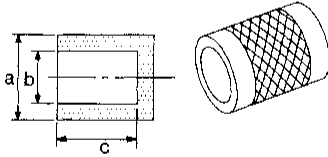
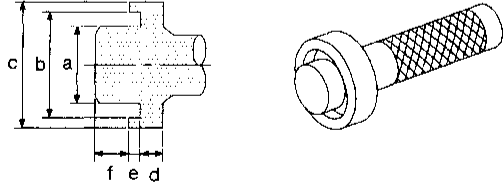
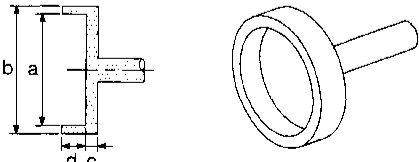
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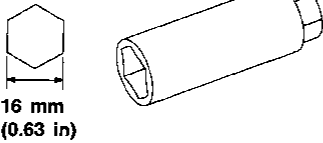
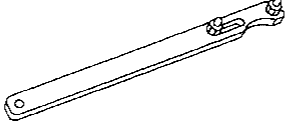
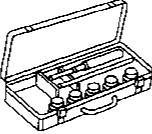
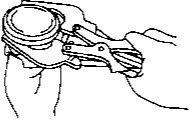
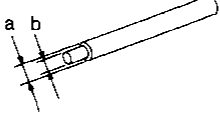
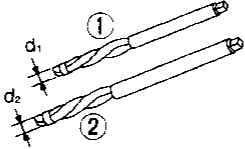
## PREPARATION

### Special Service Tools (Cont'd)

Tool number (Kent-Moore No.) Tool name	Description	
① EG14860000 (J38387) Push-pull gauge ② KV10112000 ( — ) Hook	 NT039	Adjusting timing belt tension
(J36467) Valve oil seal remover	 NT034	Removing valve oil seals
EM03470000 (J8037) Piston ring compressor	 NT044	Installing piston assembly into cylinder bore
ST16610001 (J23907) Pilot bushing puller	 NT045	Removing crankshaft pilot bushing
KV10111100 (J37228) Seal cutter	 NT046	Removing oil pan
WS39930000 ( — ) Tube presser	 NT052	Pressing the tube of liquid gasket
ST33200000 (J26082) Drift	 NT613	Installing camshaft oil seal  <b>a: 60 mm (2.36 in) dia.</b> <b>b: 44.5 mm (1.752 in) dia.</b> <b>c: 75 mm (2.95 in)</b>
KV38100300 (J22888) Drift	 NT606	Installing front oil seal  <b>a: 32 mm (1.26 in) dia.</b> <b>b: 46 mm (1.81 in) dia.</b> <b>c: 54 mm (2.13 in) dia.</b> <b>d: 15 mm (0.59 in)</b> <b>e: 5 mm (0.20 in)</b> <b>f: 10 mm (0.39 in)</b>
ST15310000 (J25640-B) Drift	 NT607	Installing rear oil seal  <b>a: 84 mm (3.31 in) dia.</b> <b>b: 96 mm (3.78 in) dia.</b> <b>c: 8 mm (0.31 in)</b> <b>d: 20 mm (0.79 in)</b>

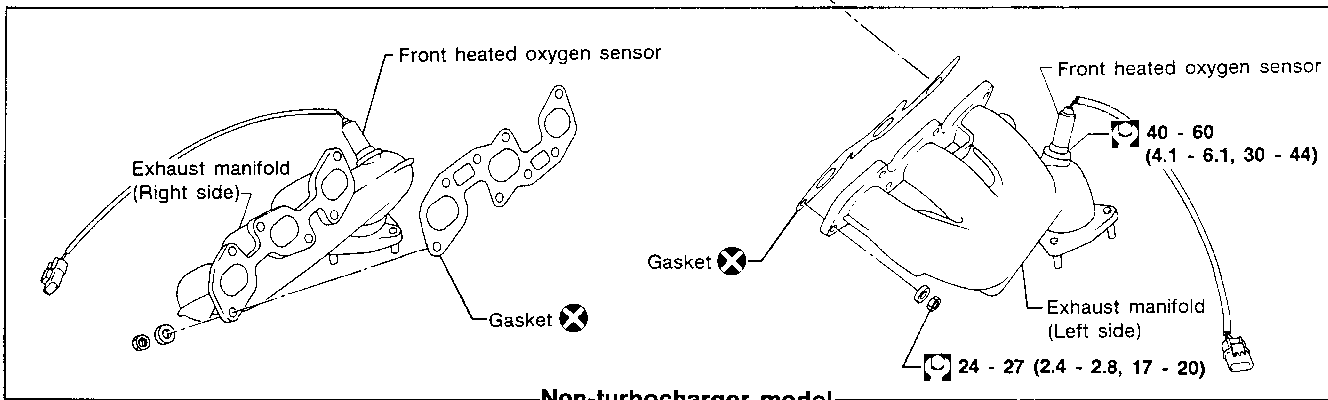
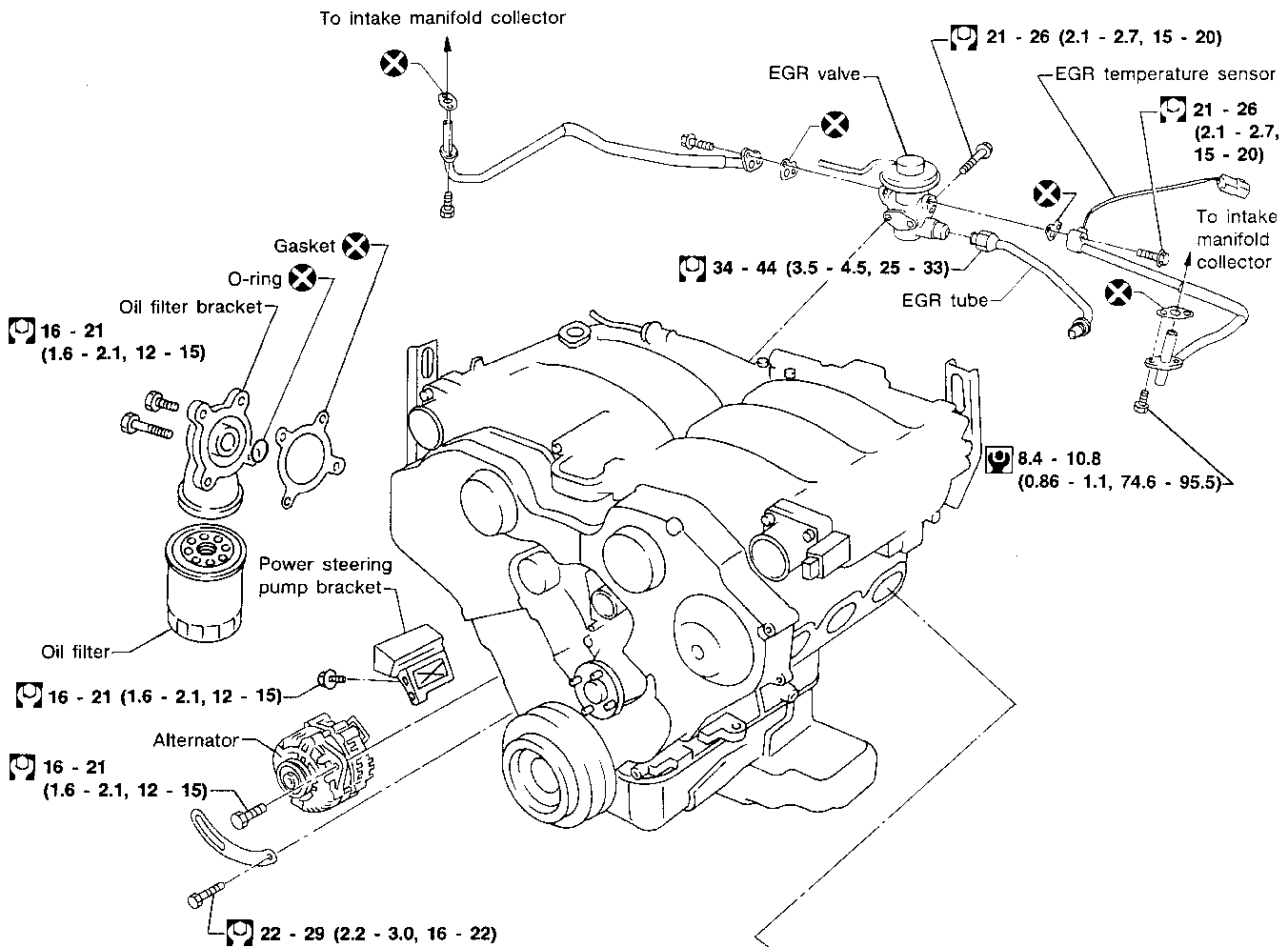
# PREPARATION

## Commercial Service Tools

Tool name	Description	
Spark plug wrench	 <p>16 mm (0.63 in)</p> <p>NT047</p>	<p>GI</p> <p>MA</p> <p><b>EM</b></p>
Pulley holder	 <p>NT035</p>	<p>LC</p> <p>EC</p>
Valve seat cutter set	 <p>NT048</p>	<p>FE</p> <p>CL</p>
Piston ring expander	 <p>NT030</p>	<p>MT</p> <p>AT</p>
Valve guide drift	 <p>NT015</p> <p><b>Intake &amp; Exhaust:</b>  <b>a = 9.5 mm (0.374 in) dia.</b>  <b>b = 5.5 mm (0.217 in) dia.</b></p>	<p>PD</p> <p>FA</p>
Valve guide reamer	 <p>NT016</p> <p><b>d<sub>1</sub> = 6.0 mm (0.236 in) dia.</b>  <b>d<sub>2</sub> = 10.2 mm (0.402 in) dia.</b></p>	<p>RA</p> <p>BR</p>
		<p>ST</p> <p>RS</p> <p>BT</p> <p>HA</p> <p>EL</p> <p>IDX</p>

# OUTER COMPONENT PARTS

SEC. 140-147-226-231

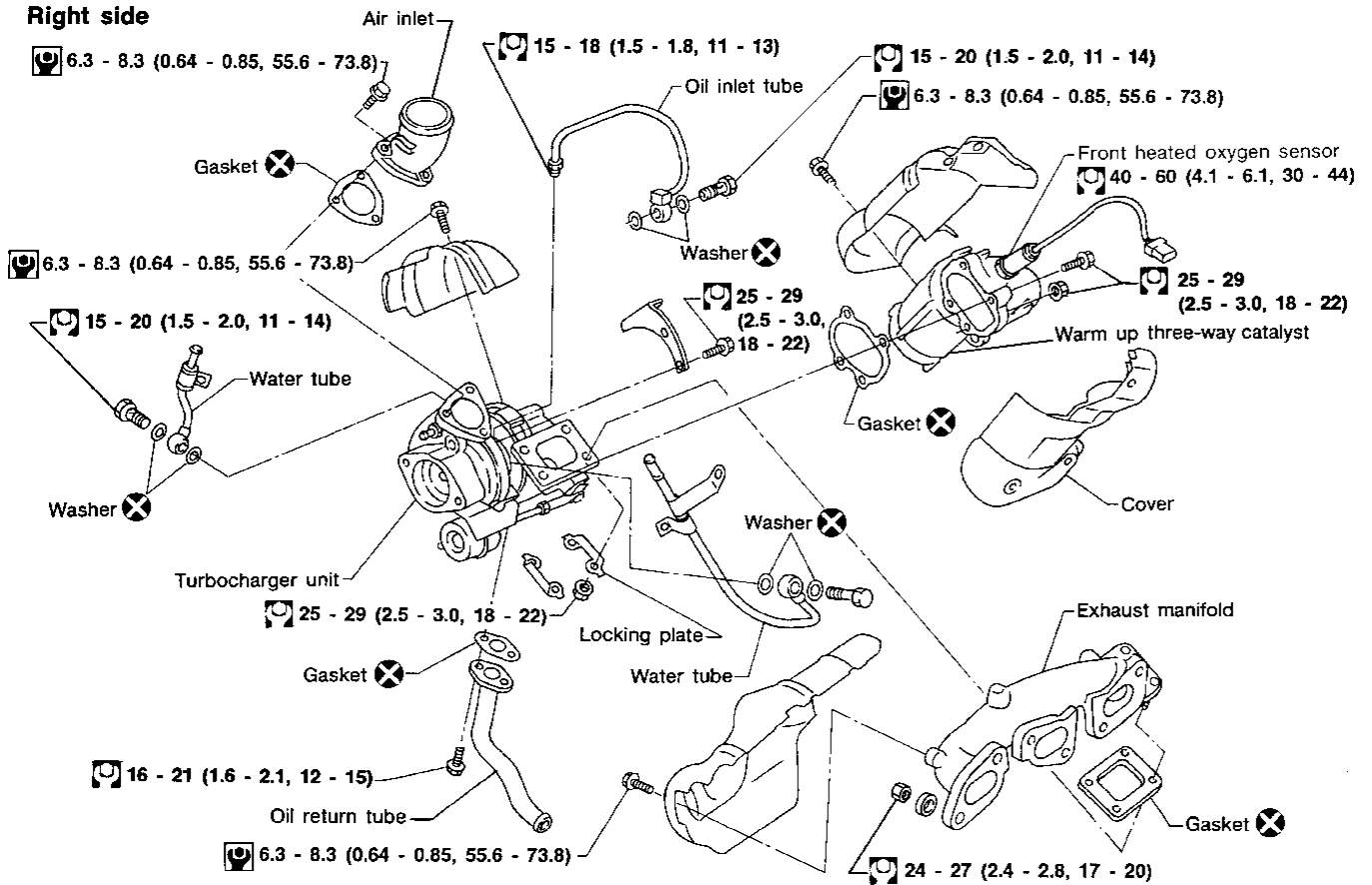


- : N·m (kg-m, in-lb)
- : N·m (kg-m, ft-lb)

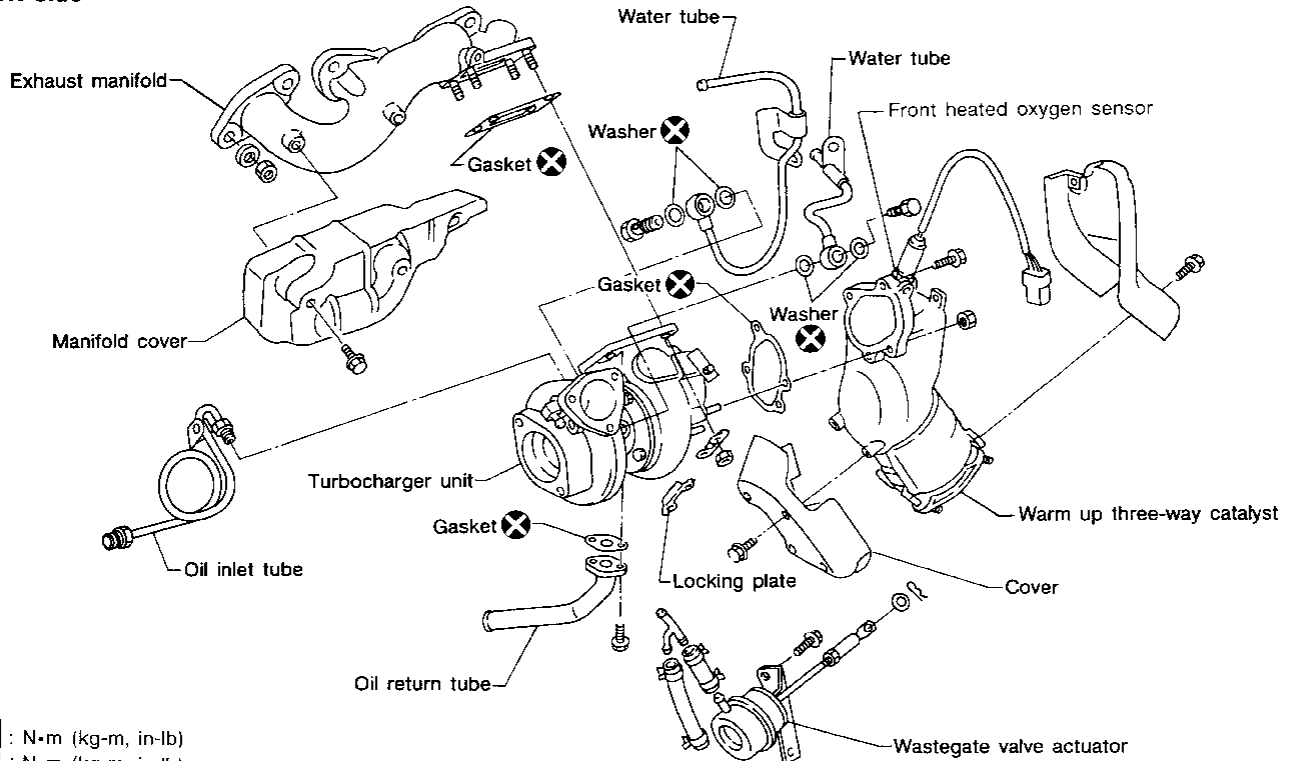
# OUTER COMPONENT PARTS

## Turbocharger model

### Right side



### Left side



: N·m (kg-m, in-lb)  
 : N·m (kg-m, in-lb)

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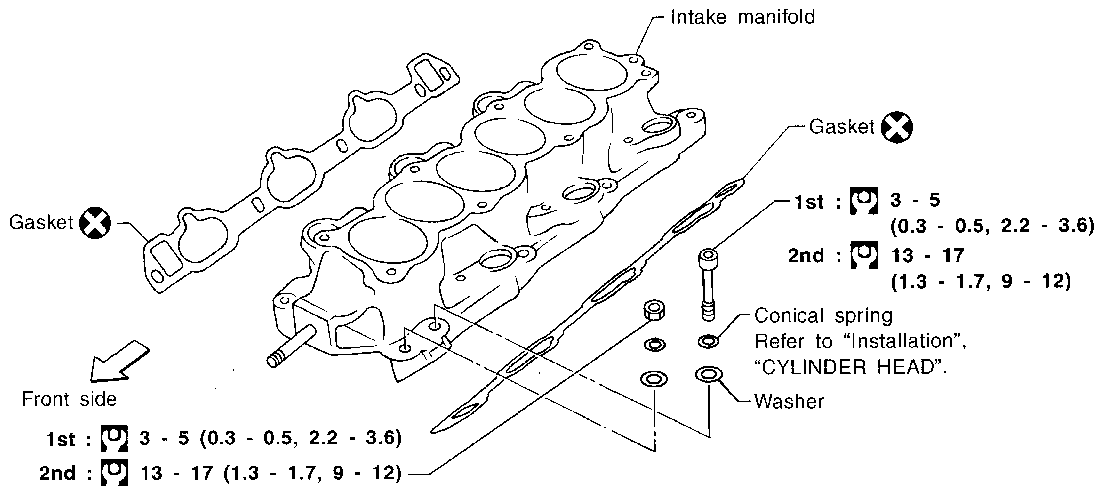
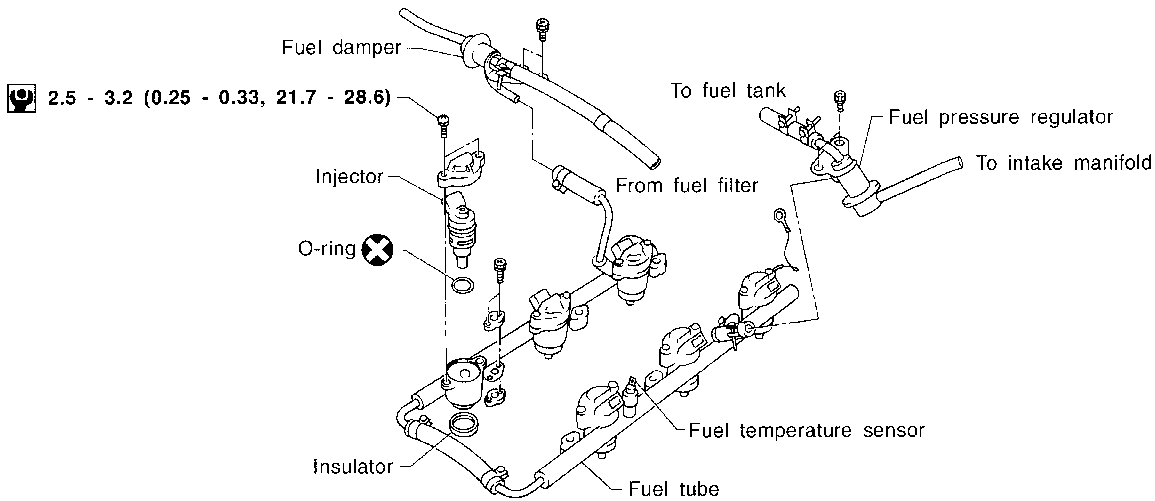
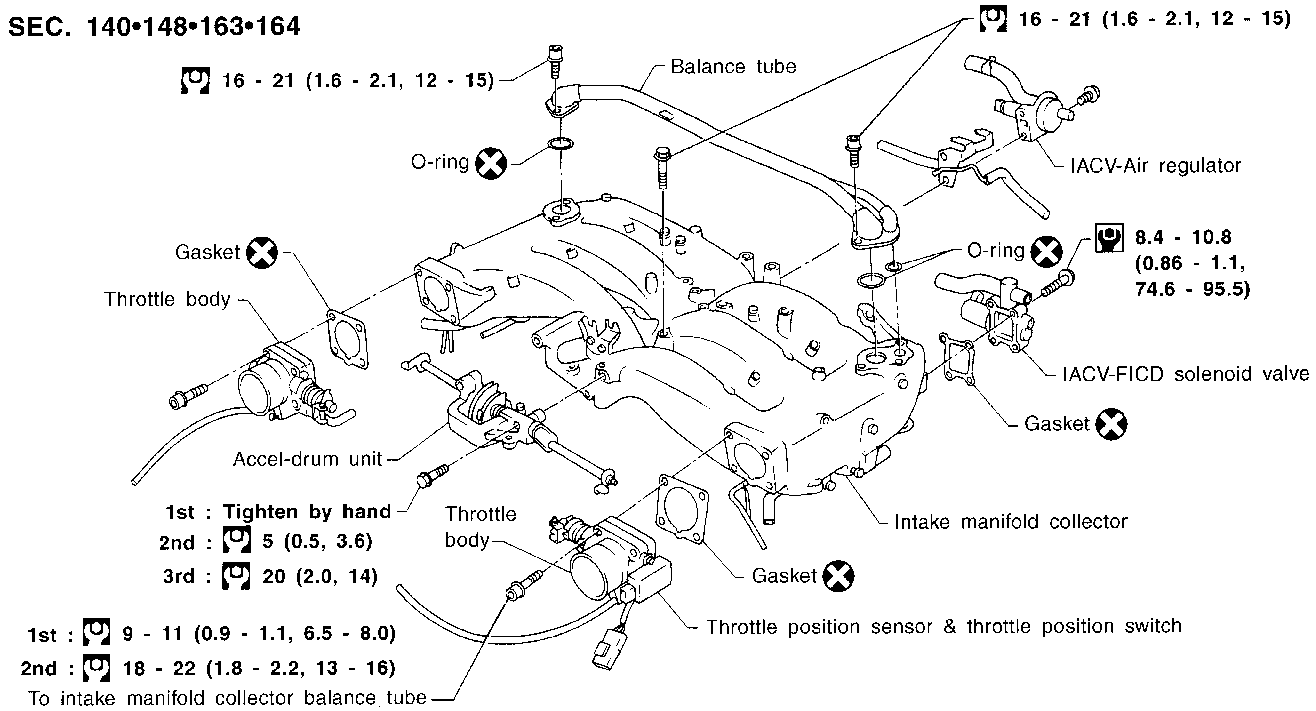
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# OUTER COMPONENT PARTS

## SEC. 140•148•163•164



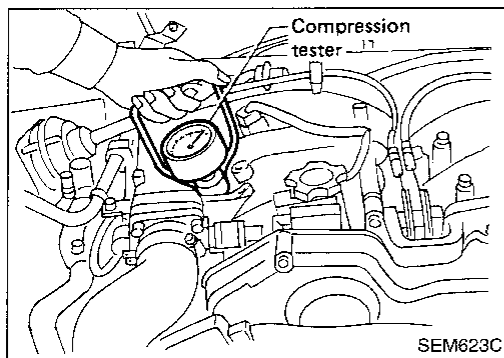
: N·m (kg-m, ft-lb)

: N·m (kg-m, in-lb)



## Measurement of Compression Pressure

1. Warm up engine.
2. Turn ignition switch off.
3. Release fuel pressure.  
Refer to "Fuel Pressure Release", "BASIC SERVICE PROCEDURE" in EC section.
4. Remove all spark plugs.
5. Disconnect camshaft position sensor harness connector.
6. Attach a compression tester to No. 1 cylinder.
7. Depress accelerator pedal fully to keep throttle valve wide open.
8. Crank engine and record highest gauge indication.
9. Repeat the measurement on each cylinder as shown.



**Always use a fully-charged battery to obtain specified engine speed.**

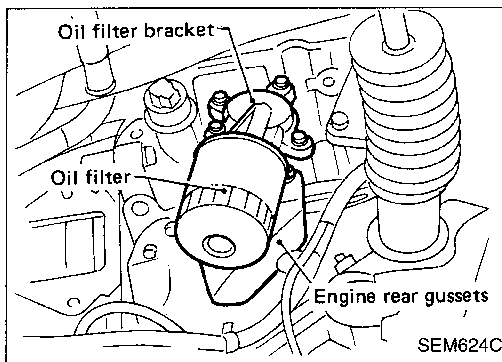
**Compression pressure:**

Unit: kPa (kg/cm<sup>2</sup>, psi)/300 rpm

	VG30DE	VG30DETT
Standard	1,285 (13.1, 186)	1,177 (12.0, 171)
Minimum	981 (10.0, 142)	883 (9.0, 128)
Difference limit between cylinders	98 (1.0, 14)	

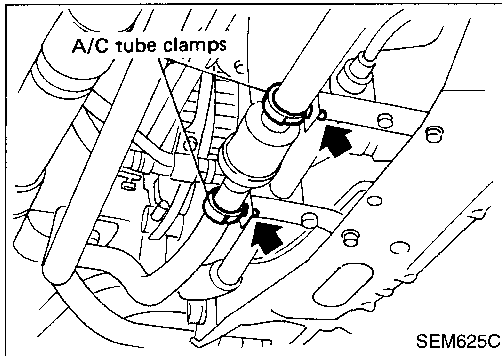
10. If compression in one or more cylinders is low:
  - a. Pour a small amount of engine oil into cylinders through spark plug holes.
  - b. Retest compression.
  - **If adding oil helps compression, piston rings may be worn or damaged. If so, replace piston rings after checking piston.**
  - **If pressure stays low, a valve may be sticking or seating improperly. Inspect and repair valves and valve seats. Refer to SDS (EM-57). If valves or valve seats are damaged excessively, replace them.**
  - **If compression stays low in two cylinders that are next to each other:**
    - a. **The cylinder head gasket may be leaking, or**
    - b. **both cylinders may have valve component damage. Inspect and repair as necessary.**

# OIL PAN

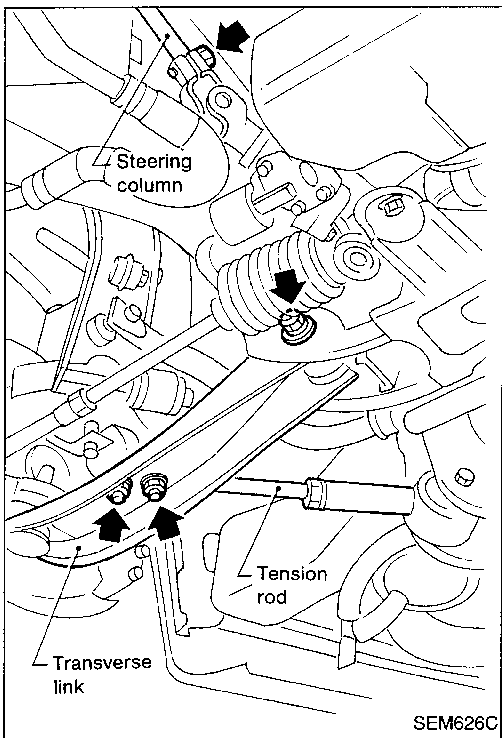


## Removal

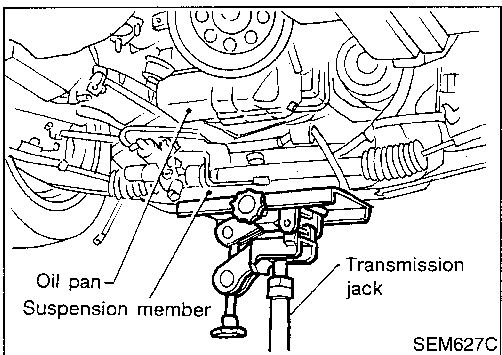
1. Drain engine oil.
2. Remove engine under cover.
3. Remove oil filter and bracket.
4. Remove engine rear gussets from both sides.



5. Disconnect A/C tube clamps as shown.



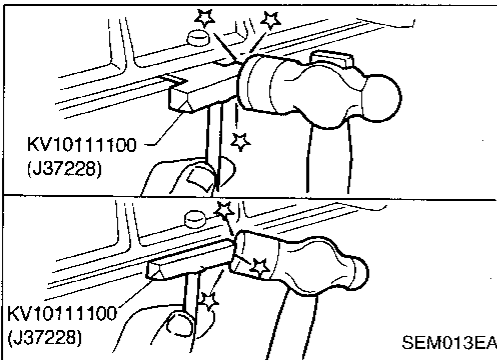
6. Disconnect steering column lower joint.
7. Remove tension rod fixing bolts from both sides.
8. Loosen transverse link bolts on both sides.



9. Set a suitable transmission jack under the suspension member.
  - At this time, hoist engine with engine slingers.
10. Remove suspension member fixing bolts.
11. Remove engine mounting bolts from both sides and then slowly lower transmission jack.
12. Remove oil pan bolts.

# OIL PAN

## Removal (Cont'd)



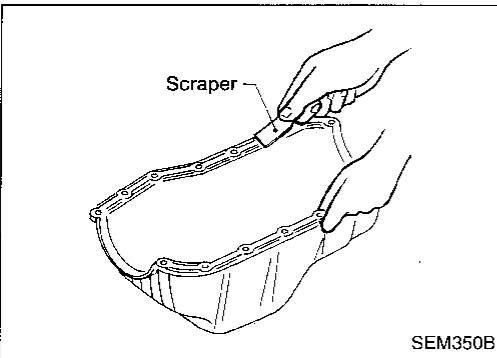
13. Remove oil pan.
  - (1) Insert Tool between cylinder block and oil pan.
    - **Be careful not to damage aluminum mating surface.**
    - **Do not insert screwdriver, or oil pan flange may be deformed.**
  - (2) Slide Tool by tapping its side with a hammer, and remove oil pan.

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## Installation



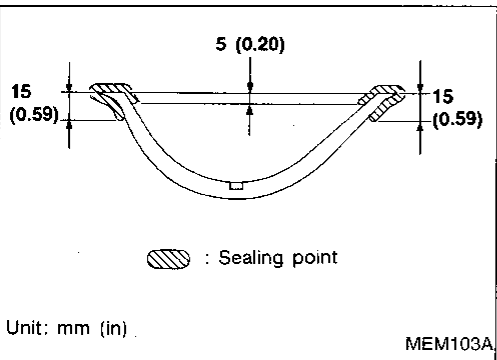
1. Use a scraper to remove all traces of liquid gasket from mating surfaces.
  - Also remove traces of liquid gasket from cylinder block mating surface.
  - **Remove old liquid gasket from the bolt holes and threads.**

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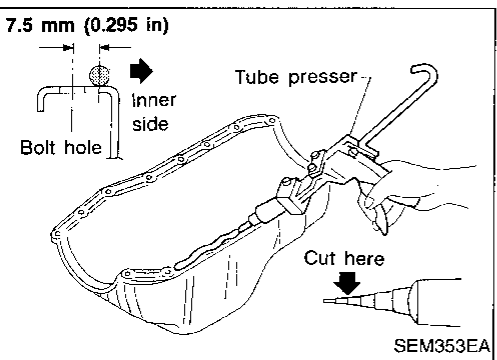
2. Apply sealant to oil pump gasket and rear oil seal retainer gasket.

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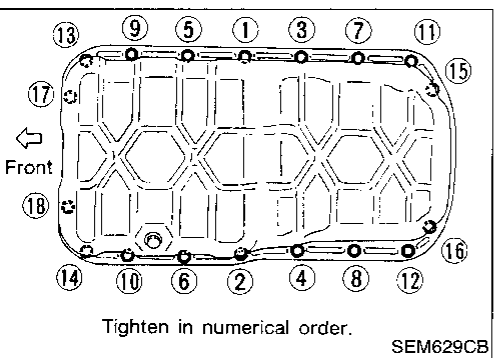
3. Apply a continuous bead of liquid gasket to oil pan mating surface.
  - **Use Genuine Liquid Gasket or equivalent.**
  - **Be sure liquid gasket is 3.5 to 4.5 mm (0.138 to 0.177 in) wide.**
  - **Attaching should be done within 5 minutes after coating.**

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4. Install oil pan.
  - **Install bolts in the reverse order of removal.**
  - **Wait at least 30 minutes before refilling engine oil.**

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### Tightening procedure

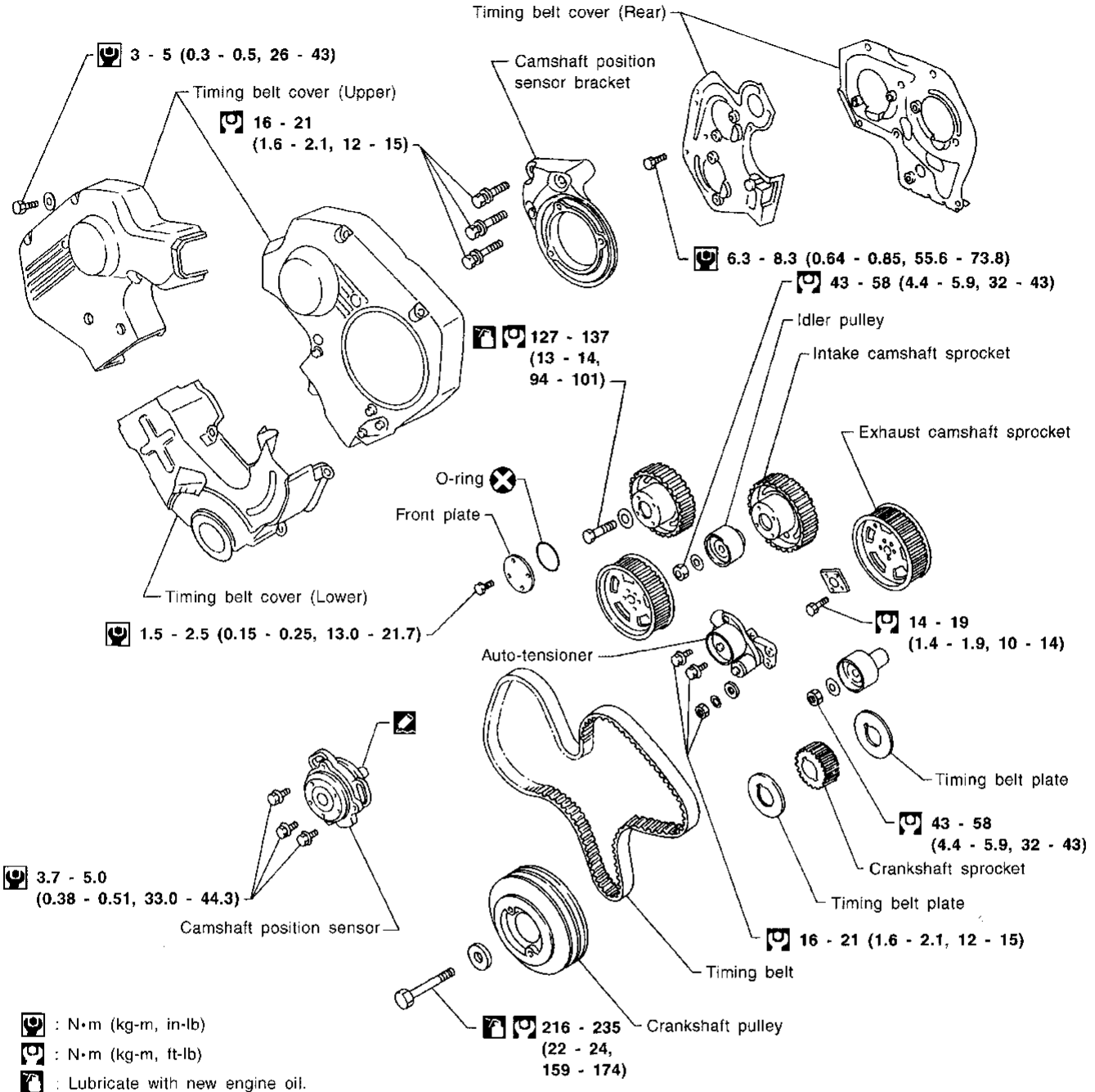
- ① - ⑫ (M8 bolt): 16 - 21 N·m (1.6 - 2.1 kg·m, 12 - 15 ft·lb)
- ⑬ - ⑱ (M6 bolt): 6.3 - 8.3 N·m (0.64 - 0.85 kg·m, 55.6 - 73.8 in·lb)

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# TIMING BELT

SEC. 120•130•135•221

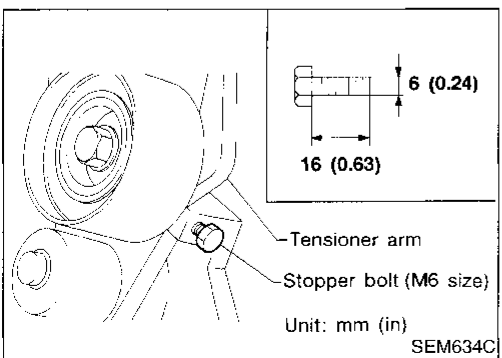
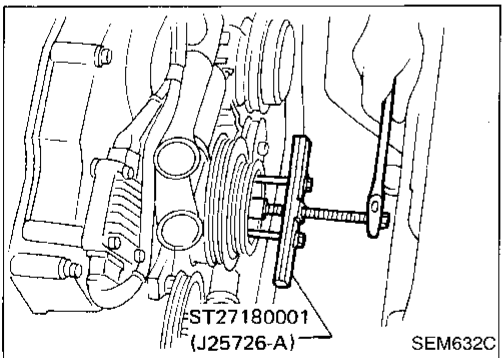
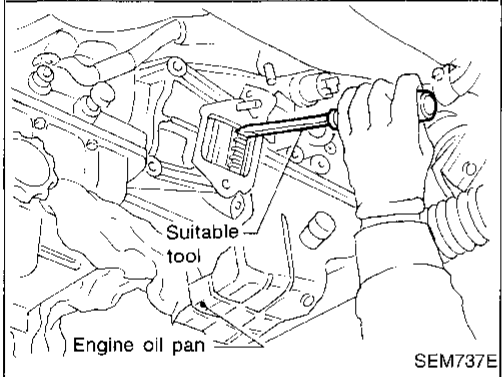
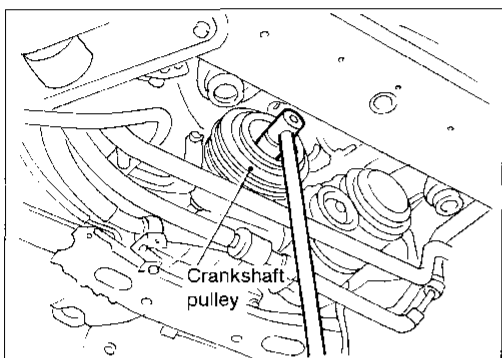
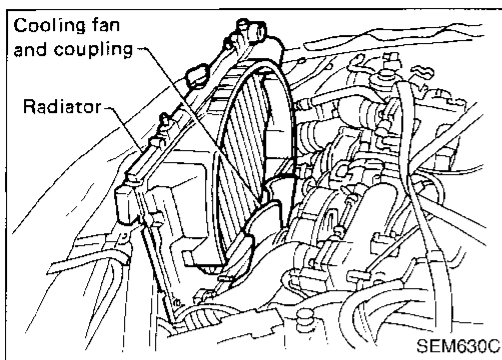


MEM135AA

**CAUTION:**

Apply new engine oil to bolt threads and seat surfaces when installing cylinder head, camshaft sprockets and crankshaft pulley.

# TIMING BELT



## Removal

1. Remove engine under cover.
2. Drain coolant from both cylinder block drain plugs, and radiator drain cock.
3. Remove radiator.
4. Remove drive belts, cooling fan and coupling.
5. Remove crankshaft pulley bolt.  
(At this time, remove starter motor and set a suitable tool to ring gear so that crankshaft cannot rotate.)
  - **Be careful not to damage the ring gear teeth on flywheel or drive plate.**

6. Remove crankshaft pulley using Tool.
7. Remove water inlet and outlet.
8. Remove front timing belt covers.

9. Install a suitable stopper bolt (M6) into tensioner arm of auto-tensioner so that auto-tensioner pusher does not spread out.

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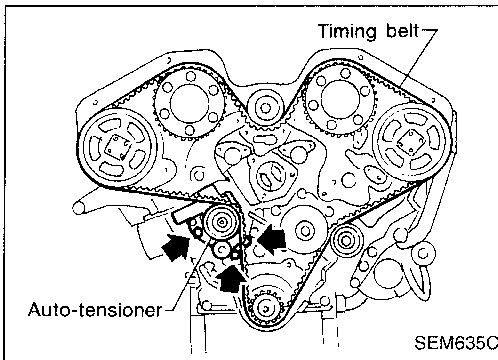
# TIMING BELT

## Removal (Cont'd)

10. Set No. 1 cylinder at TDC on its compression stroke.
11. Remove auto-tensioner and timing belt.

### CAUTION:

- Do not bend or twist timing belt.
- After removing timing belt, do not turn crankshaft and camshaft separately because valves will strike piston heads.
- Make sure that timing belt, camshaft sprocket, crankshaft sprocket, idler pulley and auto-tensioner are clean and free of oil and water.



## Inspection

Visually check the condition of timing belt.  
Replace if any abnormality is found.

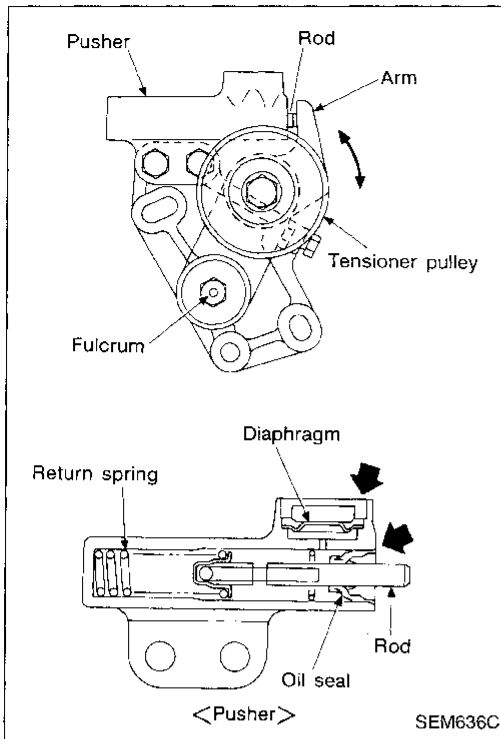
Item to check	Problem	Cause
Tooth is broken/tooth root is cracked.		<ul style="list-style-type: none"> <li>• Camshaft jamming</li> <li>• Damaged camshaft/crankshaft oil seal</li> </ul>
Back surface is cracked/worn.		<ul style="list-style-type: none"> <li>• Tensioner jamming</li> <li>• Overheated engine</li> <li>• Interference with belt cover</li> </ul>
Side surface is worn.		<ul style="list-style-type: none"> <li>• Improper installation of belt</li> <li>• Malfunctioning crankshaft pulley plate/timing belt plate</li> </ul>
Teeth are worn.		<ul style="list-style-type: none"> <li>• Poor belt cover sealing</li> <li>• Coolant leakage at water pump</li> <li>• Camshaft not functioning properly</li> <li>• Excessive belt tension</li> </ul>
Oil/Coolant or water is stuck to belt.		<ul style="list-style-type: none"> <li>• Poor oil sealing</li> <li>• Coolant leakage at water pump</li> <li>• Poor belt cover sealing</li> </ul>

# TIMING BELT

## Inspection (Cont'd)

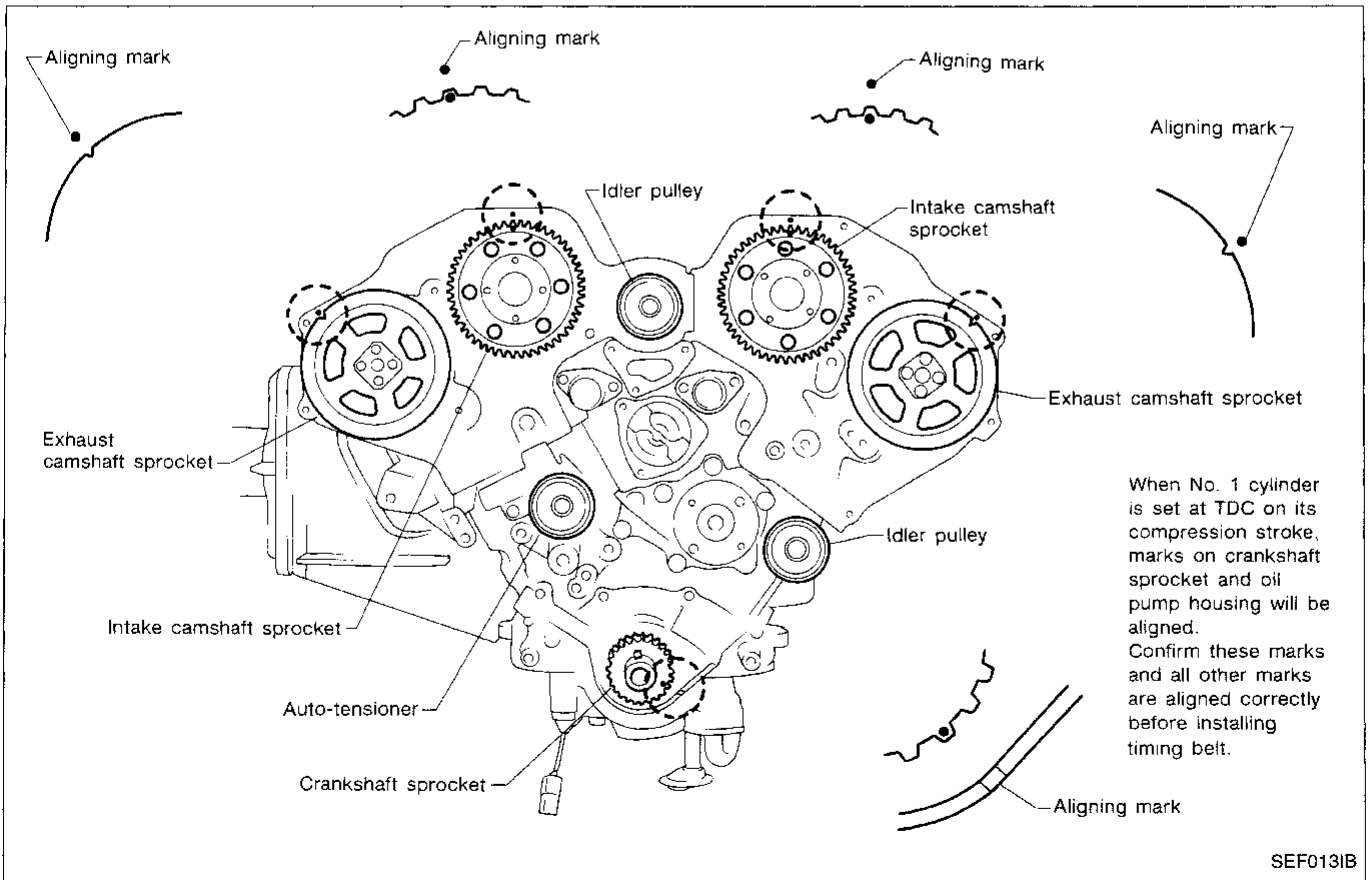
### AUTO-TENSIONER

Check for oil leaks from pusher rod and diaphragm.



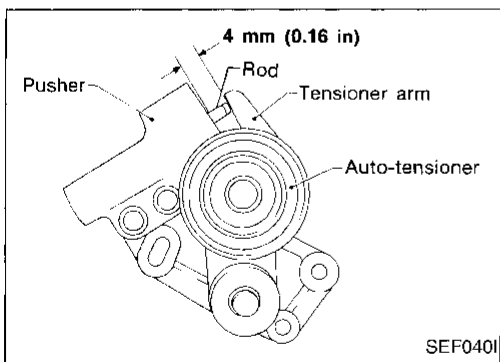
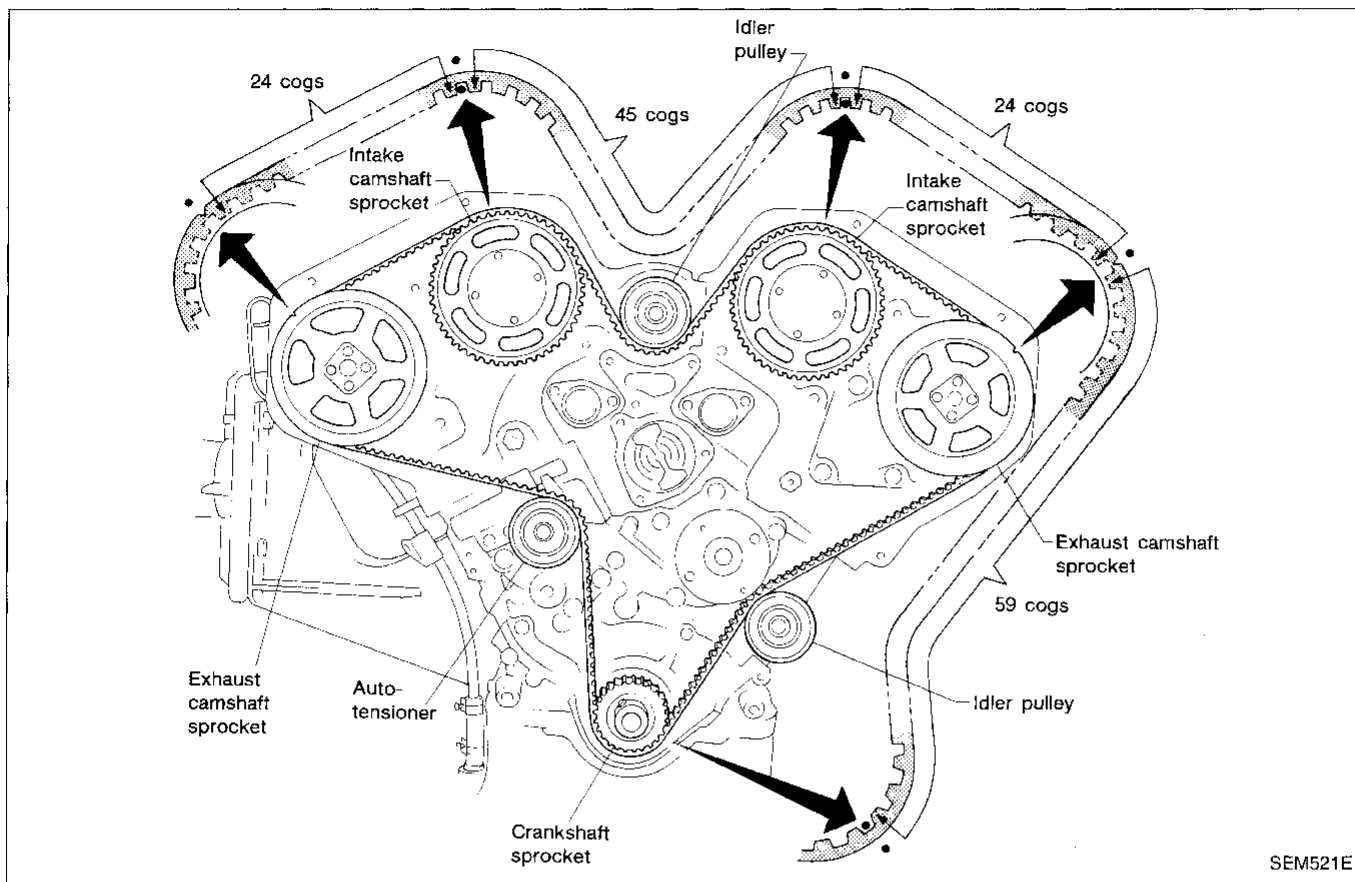
## Installation

1. Confirm that No. 1 cylinder is set at TDC on its compression stroke.
2. Align matching marks on camshaft and crankshaft sprockets with aligning marks on rear belt cover and oil pump housing.
3. Remove all spark plugs.



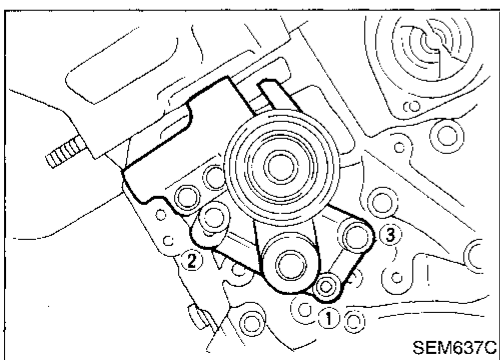
## TIMING BELT Installation (Cont'd)

4. Set timing belt.
  - a. Ensure timing belt and sprockets are clean and free from oil or water. Do not bend or twist timing belt.
  - b. Align white lines on timing belt with matching mark on camshaft sprocket and crankshaft sprocket.
  - c. Point arrow on timing belt towards the front.



5. Secure in a vise and adjust to attain a 4 mm (0.16 in) clearance between tensioner arm and pusher of auto-tensioner. Insert stopper bolt into tensioner arm to maintain this clearance.

**When adjusting clearance, do not push tensioner arm with stopper bolt fitted because it will damage thread portion of stopper bolt.**

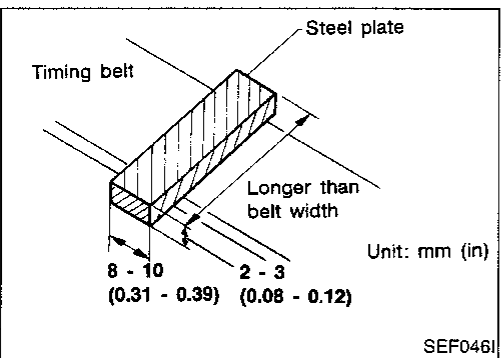
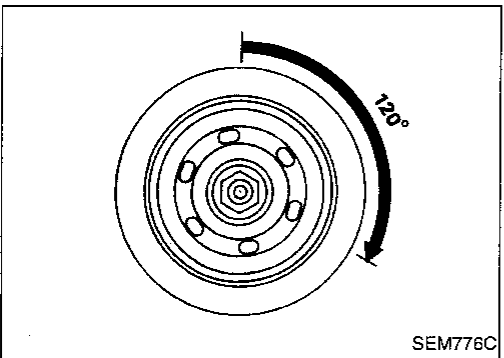
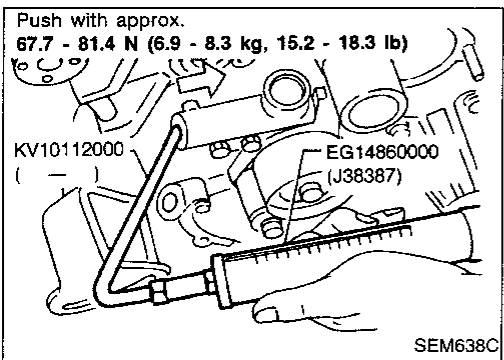
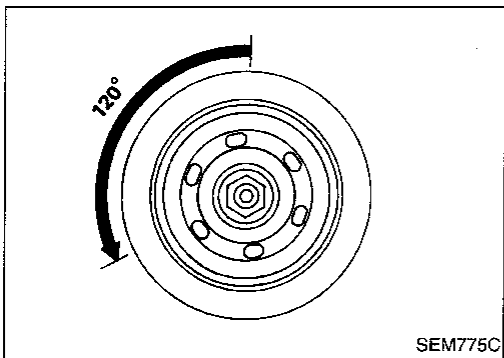
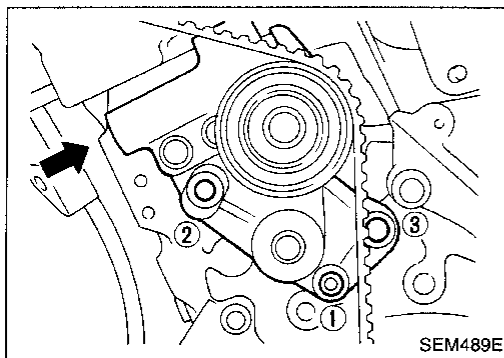


6. Install auto-tensioner and tighten nut (1) and bolts (2, 3) slightly by hand.



## TIMING BELT

### Installation (Cont'd)



7. Push auto-tensioner slightly towards timing belt to prevent belt from slipping.  
Set tensioner slightly by pushing timing belt. Then, turn crankshaft 10 degrees clockwise and tighten nut (①) and bolts (②, ③) to 16 to 21 N·m (1.6 to 2.1 kg·m, 12 to 15 ft·lb).

**At this time, do not push auto-tensioner hard, or belt will be adjusted too tightly.**

8. Turn crankshaft 120 degrees counterclockwise.
9. Loosen nut (①) and bolts (②, ③) 1/2 turn to set tensioner body as far back as it will go.
10. Turn crankshaft clockwise and set No. 1 cylinder at TDC on its compression stroke.

11. Push the end of pusher with approx. 67.7 to 81.4 N (6.9 to 8.3 kg, 15.2 to 18.3 lb) force using Tool (push-pull gauge) and tighten nut (①) and bolts (②, ③) to 16 to 21 N·m (1.6 to 2.1 kg·m, 12 to 15 ft·lb).

**If deflection of timing belt exceeds specification in procedure 15., change applied pushing force.**

12. Turn crankshaft 120 degrees clockwise.
13. Turn crankshaft 120 degrees counterclockwise and set No. 1 cylinder at TDC on its compression stroke.

14. Prepare a suitable steel plate to measure belt deflection as shown.

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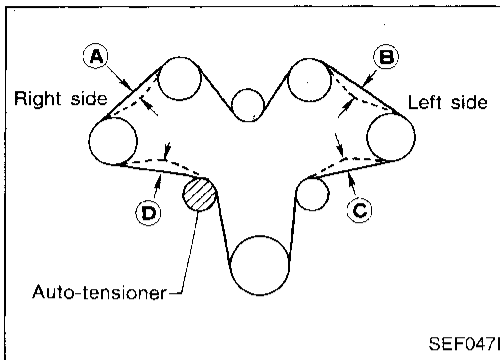
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## TIMING BELT

### Installation (Cont'd)



15.

- (1) Set plate and push it with 49 N (5 kg, 11 lb) force using Tool (push-pull gauge) at each position of timing belt mid-way between pulleys as shown.
- (2) Measure each deflection.

**Deflection:**

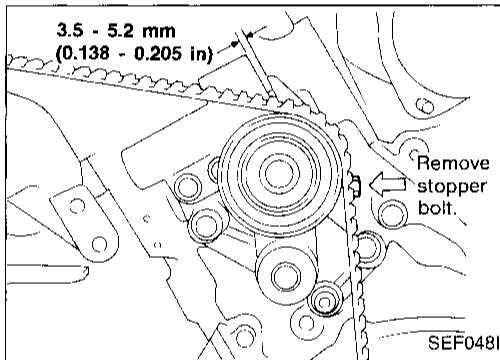
6 - 7 mm (0.24 - 0.28 in) or the average of each portion

$$\frac{(A) + (B) + (C) + (D)}{4}$$

is 6 - 7 mm (0.24 - 0.28 in)

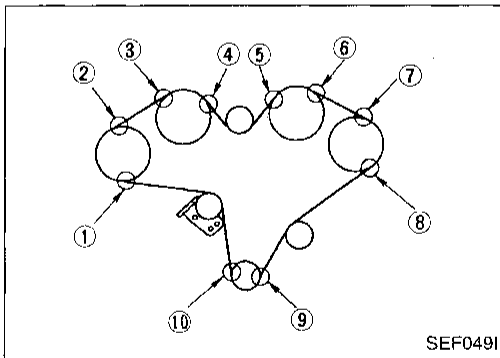
If not within specification, repeat procedure from step 7 through step 15.

16. Confirm auto tensioner fixing nuts and bolts are tightened to 16 to 21 N·m (1.6 to 2.1 kg·m, 12 to 15 ft·lb).

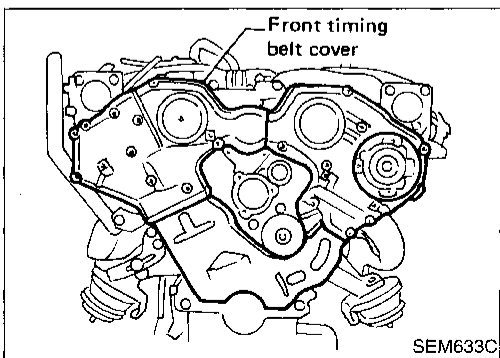


17.

- Remove the auto-tensioner stopper bolt.
- After 5 minutes check the projection of the rod (clearance between tensioner arm and pusher) stays at 3.5 to 5.2 mm (0.138 to 0.205 in).

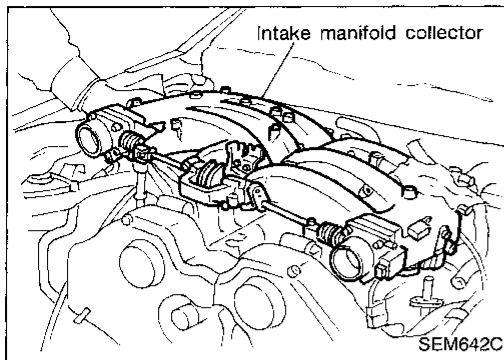


18. Check the proper installation (no slip or misplacement) of timing belt at each position as shown.



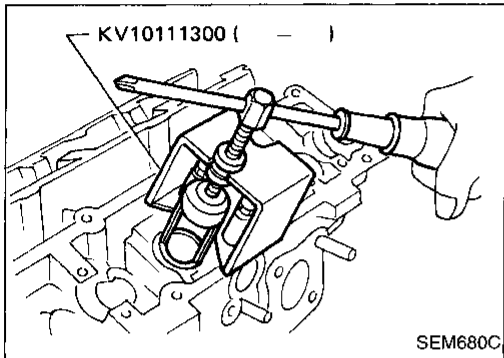
19. Install timing belt covers.

# OIL SEAL REPLACEMENT

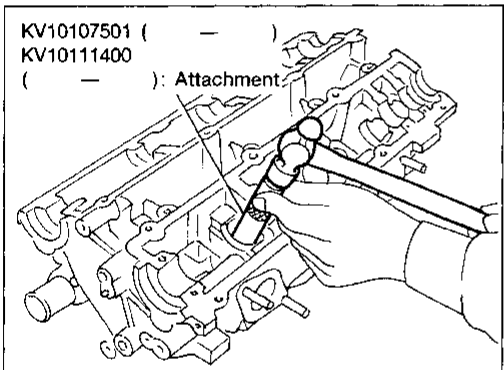


## VALVE OIL SEAL

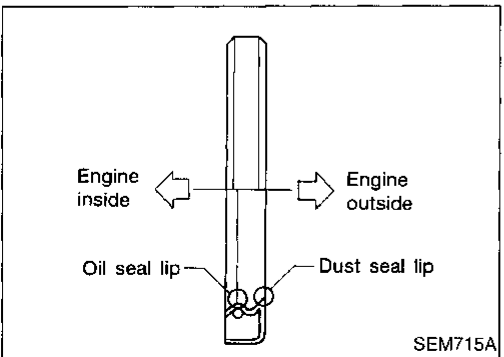
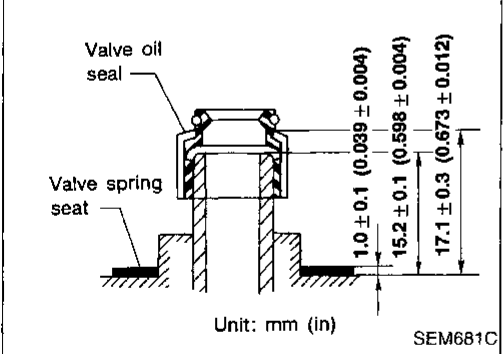
1. Remove intake manifold collector and valve cover.
2. Remove timing belt, camshaft sprocket and rear belt cover.
3. Remove camshaft brackets, camshaft and valve lifter.



4. Remove valve spring using Tool or a suitable tool.
  - Piston concerned should be set at TDC to prevent valve from falling.
5. Pry out valve oil seal.



6. Apply engine oil to new valve oil seal and install it.
  - Before installing valve oil seal, install inner valve spring seat.



## OIL SEAL INSTALLATION DIRECTION

- Install new oil seal in the direction shown in the figure.

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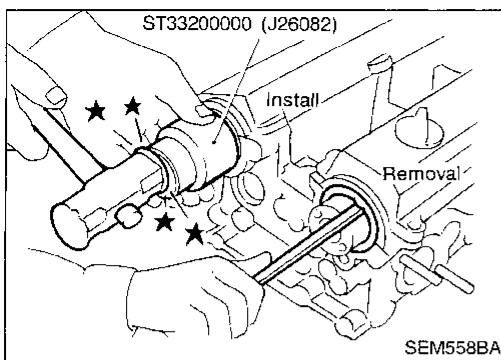
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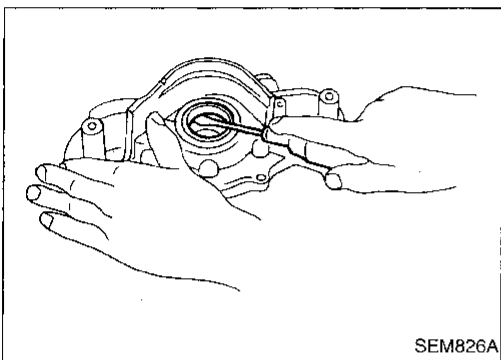
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# OIL SEAL REPLACEMENT



## CAMSHAFT OIL SEAL

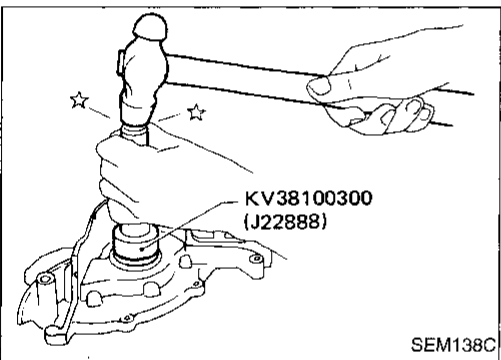
1. Remove timing belt and camshaft sprocket.
  2. Remove rear belt cover and camshaft oil seal.
- Be careful not to scratch camshaft.**
3. Apply engine oil to new camshaft oil seal and install it using Tool or a suitable tool.



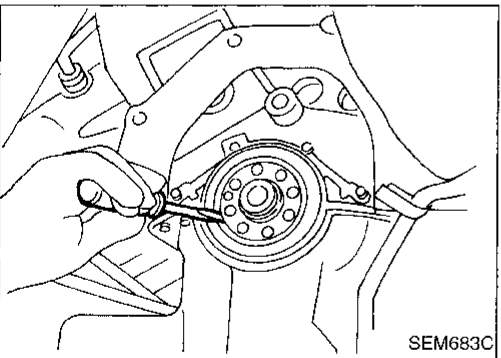
## FRONT OIL SEAL

1. Remove timing belt and crankshaft sprocket.
2. Remove oil pan and oil pump assembly.
3. Remove front oil seal from oil pump body.

**Be careful not to scratch oil pump body.**



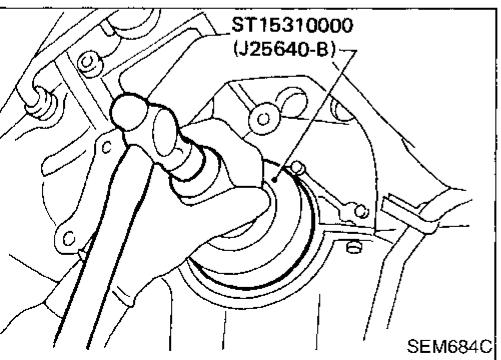
4. Apply engine oil to new oil seal and install it using Tool or a suitable tool.



## REAR OIL SEAL

1. Remove flywheel or drive plate.
2. Remove rear oil seal from retainer.

**Be careful not to scratch crankshaft.**



3. Apply engine oil to new oil seal and install it using Tool or a suitable tool.

# THROTTLE BODIES

## Precaution

A letter, "U" or "L", is stamped on the throttle bodies. When changing throttle body, replace it with new one that has the same mark.

## Installation

The intention of this installation and adjustment procedure is to assure accurate synchronization of the throttle body opening points.

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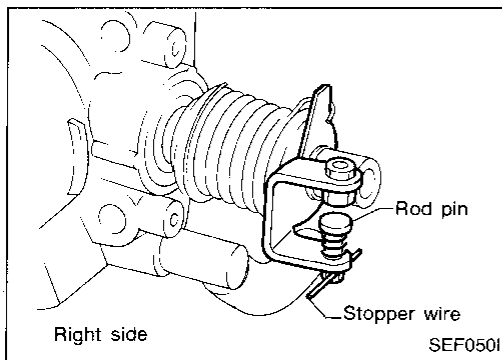
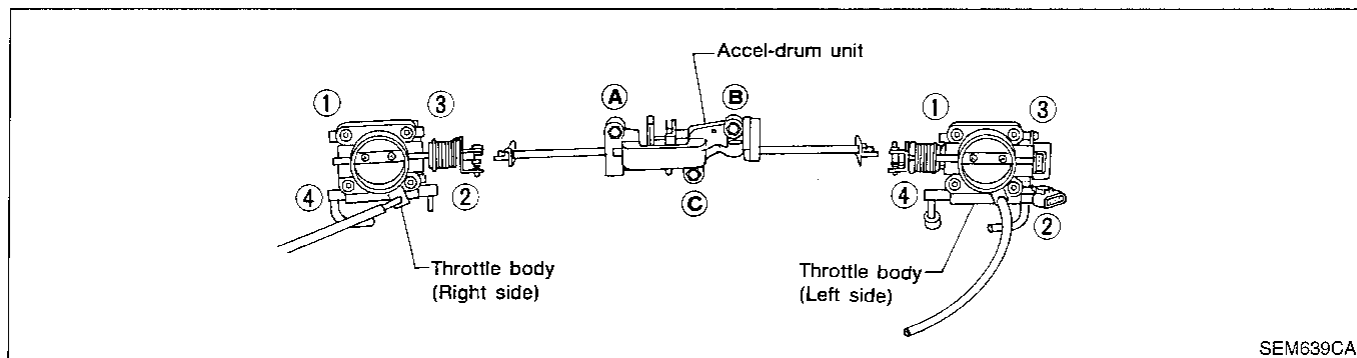
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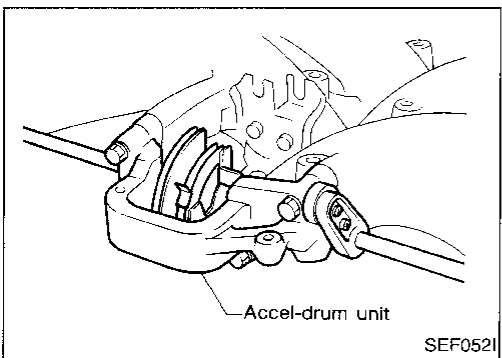
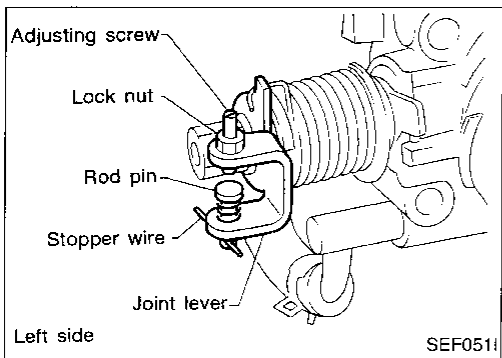


- Before installing each throttle body, confirm that stopper wire is installed in hole of rod pin. If not, install suitable wire.
- When tightening bolts, free accel-drum unit so that drum unit is left under its own weight. Do not apply external force to accel-drum unit.
- When replacing throttle bodies only, you need not perform procedures (3), (4) and (5).

1. Install accel-drum unit and throttle bodies (right side and left side).

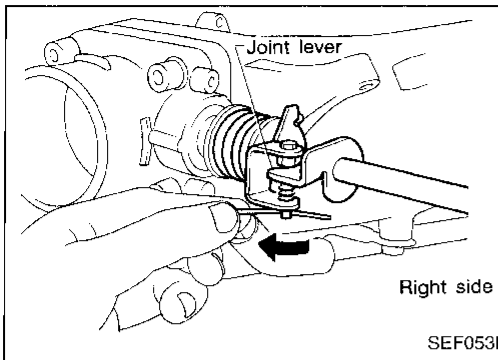
### Tightening order:

- (1) ① → ② → ③ → ④:  
9 - 11 N·m (0.9 - 1.1 kg-m, 6.5 - 8.0 ft-lb)
- (2) ① → ② → ③ → ④:  
18 - 22 N·m (1.8 - 2.2 kg-m, 13 - 16 ft-lb)
- (3) A → B → C: Tighten by hand
- (4) A → B → C:  
5 N·m (0.5 kg-m, 3.6 ft-lb)
- (5) A → B → C:  
20 N·m (2.0 kg-m, 14 ft-lb)

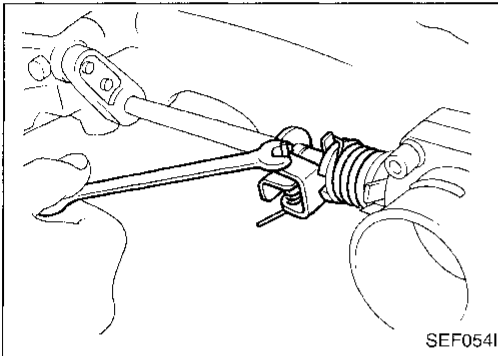


## THROTTLE BODIES

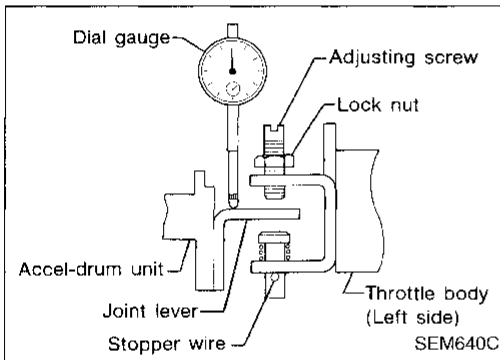
### Installation (Cont'd)



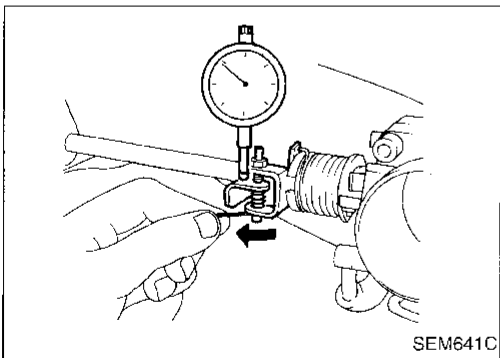
2. Pull out stopper wire of right side throttle body in order to secure right side joint lever.



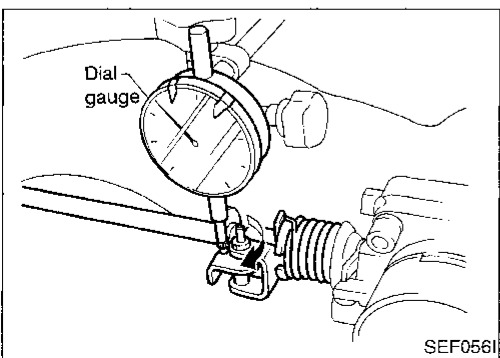
3. Loosen left side throttle body lock nut and back adjusting screw until clearance is made between the screw and joint lever.



4. Set dial gauge on joint lever and set indicator to zero. Confirm that bottom end of adjusting screw is not in contact with joint lever of accelerator drum unit.



5. Pull out left side throttle body stopper wire from rod pin.



6. Turn adjusting screw until dial gauge indicates within the following range.

**Range: 0.07 - 0.13 mm (0.0028 - 0.0051 in)**

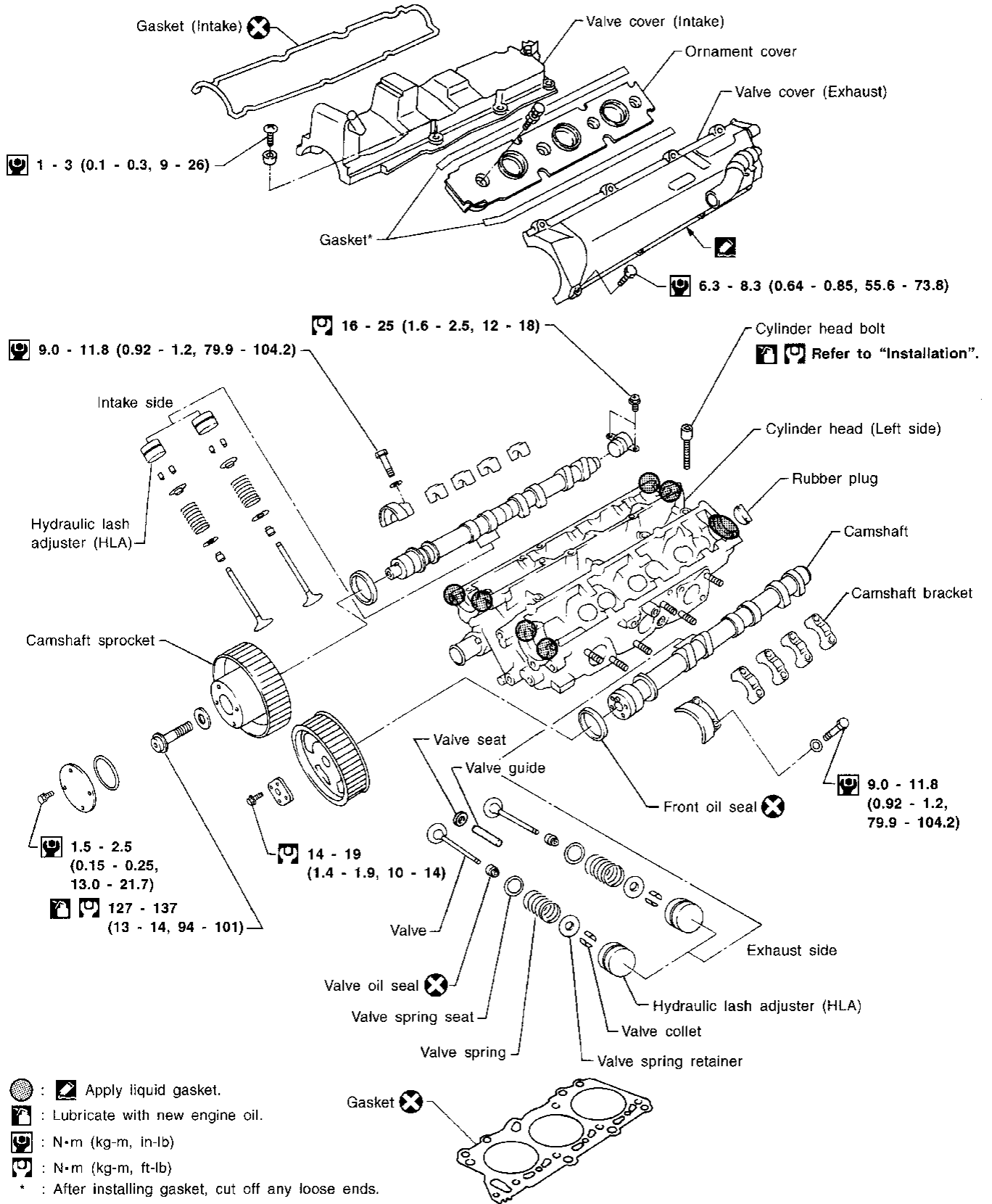
**Then tighten lock nut.**

7. Confirm that the dial gauge indicator is still within the above range.

# CYLINDER HEAD

## SEC. 111•130•140

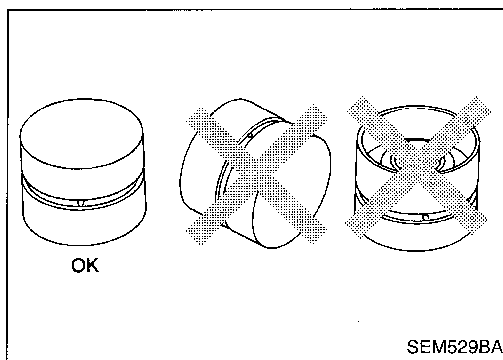
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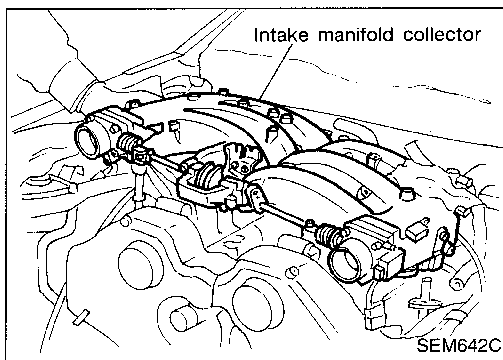
## CYLINDER HEAD

### CAUTION:

- When installing camshafts, camshaft bracket, oil seals, or other sliding parts, lubricate contacting surfaces with new engine oil.
- Apply new engine oil to threads and seat surfaces when installing cylinder head, camshaft sprocket, and camshaft bracket.

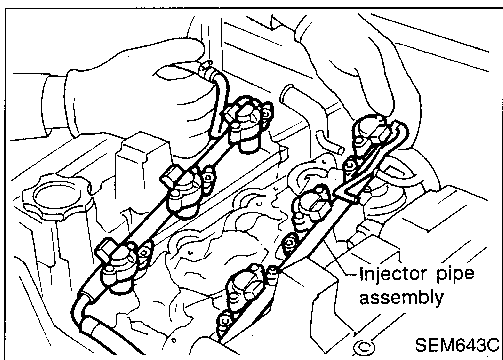


- Do not put hydraulic lash adjusters (HLA) upside down, otherwise air will enter HLA, causing it to make a noise.
- Do not disassemble HLA.
- Attach tags to HLA so as not to mix them up.
- HLA should be immersed in engine oil.

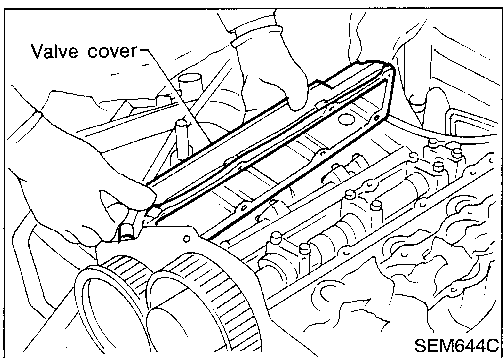


### Removal

1. Remove intake manifold collector.



2. Remove injector pipe assembly.



3. Remove valve covers.



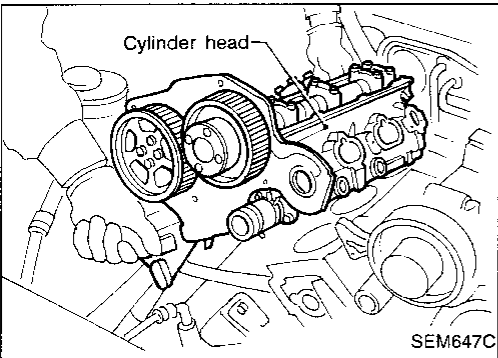
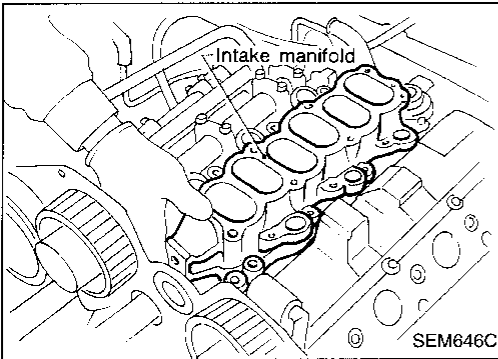
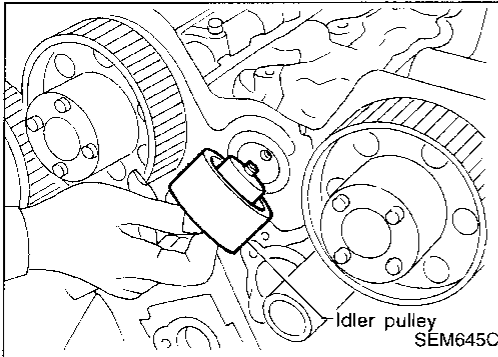
## CYLINDER HEAD

### Removal (Cont'd)

4. Remove timing belt.

Refer to "Removal" of TIMING BELT. (EM-12)

5. Remove idler pulley and its stud bolt.



6. Remove intake manifold.

7. Disconnect front exhaust tube from exhaust manifold.

8. Remove cylinder head with exhaust manifold.

**Cylinder head bolts should be loosened in two or three steps.**

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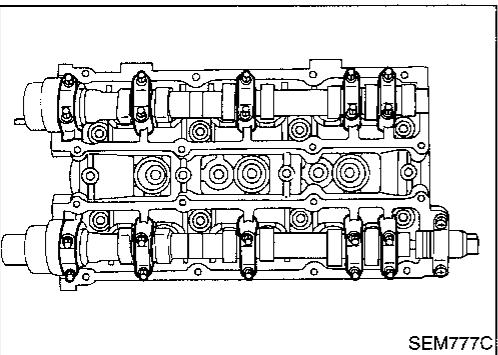
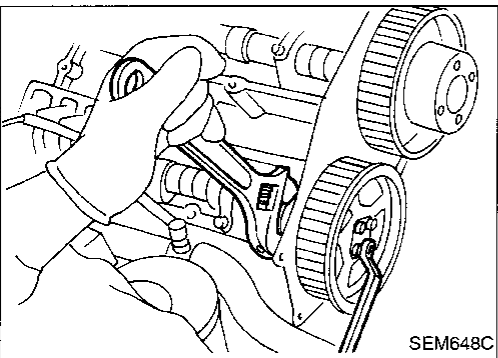
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### Disassembly

1. Remove exhaust manifold from cylinder head.

2. Remove camshaft sprockets.

3. Remove timing belt rear cover.



4. Remove camshaft brackets.

**Bolts should be loosened in two or three steps.**

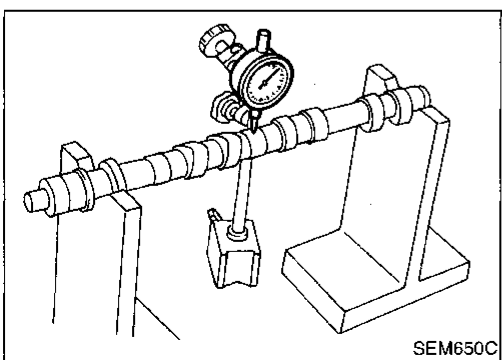
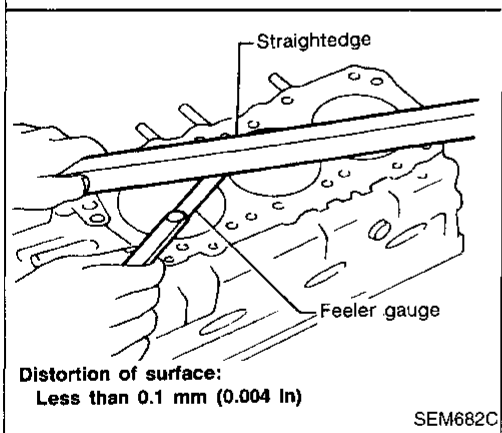
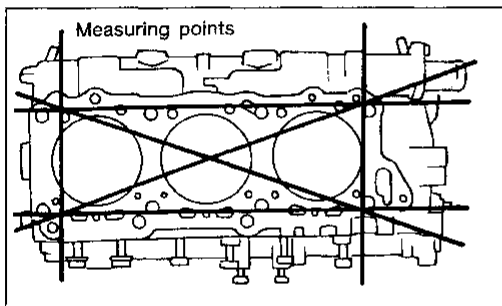
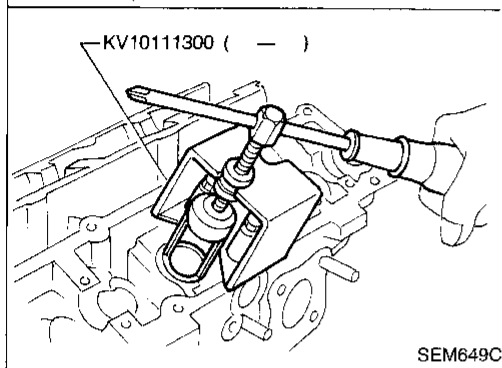
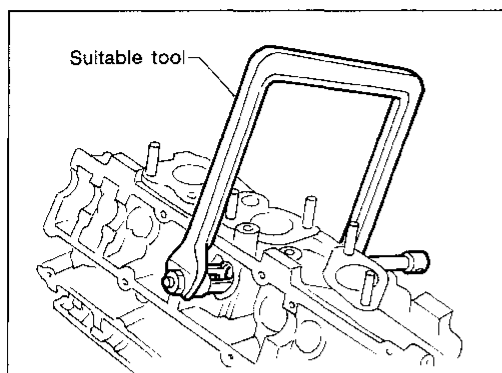
**Before removing camshaft, measure camshaft end play.**

5. Remove oil seals, camshafts and hydraulic lash adjusters.

## CYLINDER HEAD

### Disassembly (Cont'd)

6. Remove valve springs with Tool or a suitable tool.
7. Pull out valve oil seals.



### Inspection

#### CYLINDER HEAD DISTORTION

Clean surface of cylinder head.  
Use a reliable straightedge and feeler gauge to check the flatness of cylinder head surface.

##### Head surface flatness:

**Less than 0.1 mm (0.004 in)**

If beyond the specified limit, resurface it or replace it.

**The limit for cylinder head resurfacing is determined by the cylinder block resurfacing.**

##### Resurfacing limit:

**Amount of cylinder head resurfacing is "A".**

**Amount of cylinder block resurfacing is "B".**

**The maximum limit is as follows:**

**$A + B = 0.2 \text{ mm (0.008 in)}$**

After resurfacing cylinder head, check that camshaft rotates freely by hand. If resistance is felt, cylinder head must be replaced.

**Nominal cylinder head height from camshaft center:**

**Refer to SDS (EM-57).**

#### CAMSHAFT VISUAL CHECK

Check camshaft for scratches, seizure and wear.

#### CAMSHAFT RUNOUT

1. Measure camshaft runout at the center journal.

**Runout (Total indicator reading):**

**Limit 0.1 mm (0.004 in)**

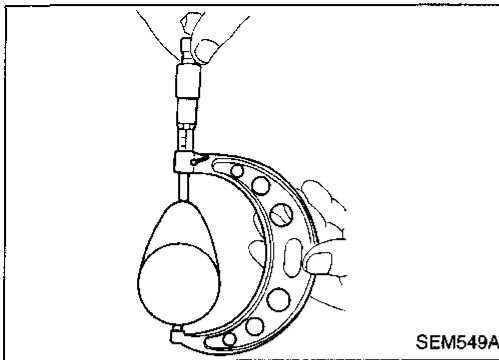
2. If it exceeds the limit, replace camshaft.

## CYLINDER HEAD

### Inspection (Cont'd)

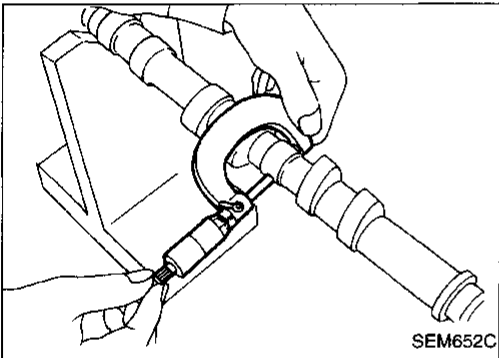
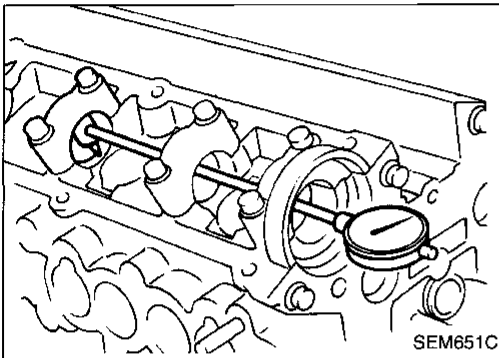
#### CAMSHAFT CAM HEIGHT

1. Measure camshaft cam height.  
**Standard cam height:**  
Intake 39.605 - 39.795 mm (1.5592 - 1.5667 in)  
Exhaust 40.405 - 40.595 mm (1.5907 - 1.5982 in)  
**Cam height wear limit: 0.15 mm (0.0059 in)**
2. If wear is beyond the limit, replace camshaft.



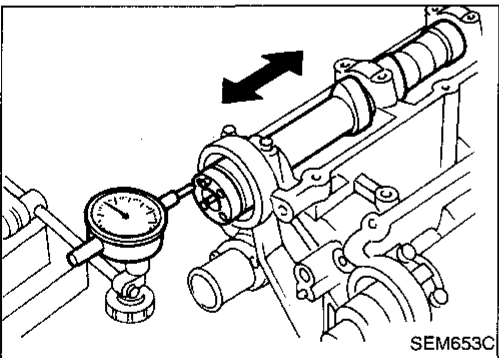
#### CAMSHAFT JOURNAL CLEARANCE

1. Install camshaft bracket and tighten bolts to the specified torque.
2. Measure inner diameter of camshaft bearing.  
**Standard inner diameter:**  
28.000 - 28.021 mm (1.1024 - 1.1032 in)
3. Measure outer diameter of camshaft journal.  
**Standard outer diameter:**  
27.935 - 27.955 mm (1.0998 - 1.1006 in)
4. If clearance exceeds the limit, replace camshaft and/or cylinder head.  
**Camshaft journal clearance limit:**  
0.15 mm (0.0059 in)



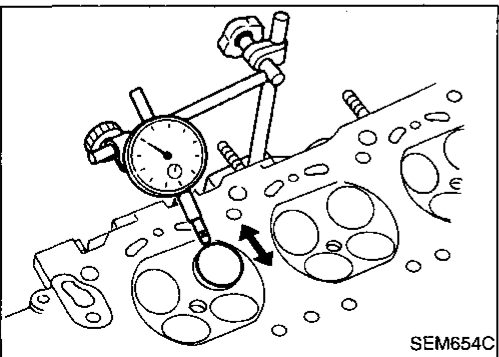
#### CAMSHAFT END PLAY

1. Install camshaft in cylinder head.
2. Measure camshaft end play.  
**Camshaft end play:**  
**Standard**  
0.03 - 0.08 mm (0.0012 - 0.0031 in)



#### VALVE GUIDE CLEARANCE

1. Push valve stem out so that its end is even with valve guide end. Measure valve runout by moving valve.  
**Valve deflection limit (Dial gauge reading):**  
0.20 mm (0.0079 in)



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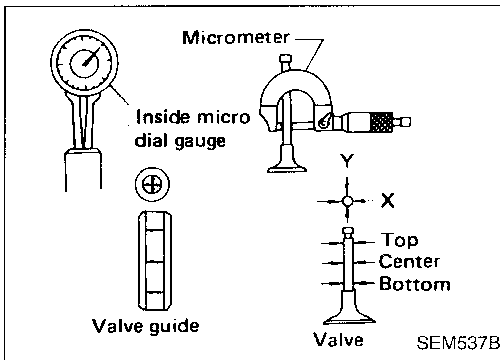
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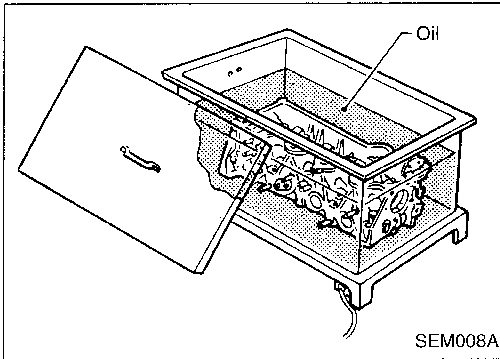
## CYLINDER HEAD

### Inspection (Cont'd)

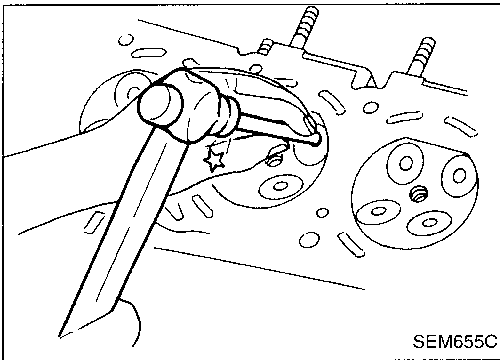


2. If it exceeds the limit, check valve stem to valve guide clearance.
  - a. Measure valve stem diameter and valve guide inner diameter.
  - b. Check that clearance is within specification.  
**Valve stem to valve guide clearance limit:  
0.10 mm (0.0039 in)**
  - c. If it exceeds the limit, replace valve or valve guide.

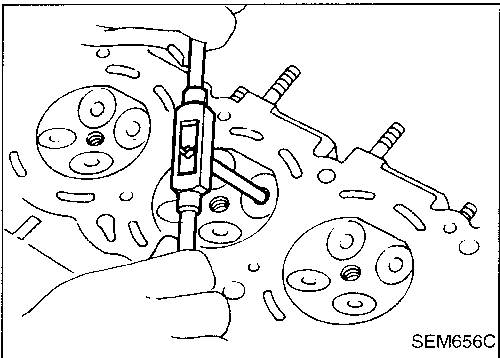
### VALVE GUIDE REPLACEMENT



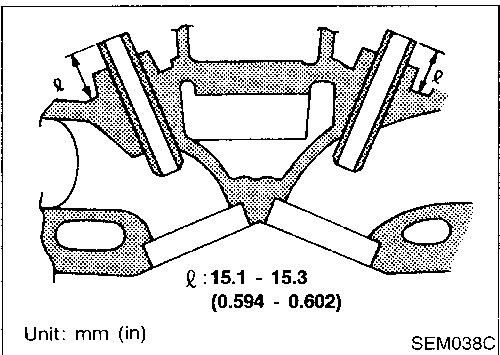
1. To remove valve guide, heat cylinder head to 150 to 160°C (302 to 320°F).



2. Drive out valve guide with a press [under a 20 kN (2 ton, 2.2 US ton, 2.0 Imp ton) pressure] or hammer and suitable tool.



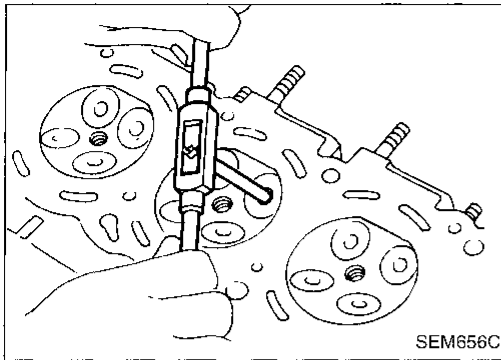
3. Ream cylinder head valve guide hole.  
**Valve guide hole diameter  
(for service parts):  
Intake and Exhaust  
10.175 - 10.196 mm (0.4006 - 0.4014 in)**



4. Heat cylinder head to 150 to 160°C (302 to 320°F) and press service valve guide onto cylinder head.  
**Projection "ℓ":  
15.1 - 15.3 mm (0.594 - 0.602 in)**

## CYLINDER HEAD

### Inspection (Cont'd)



5. Ream valve guide.

**Finished size:**

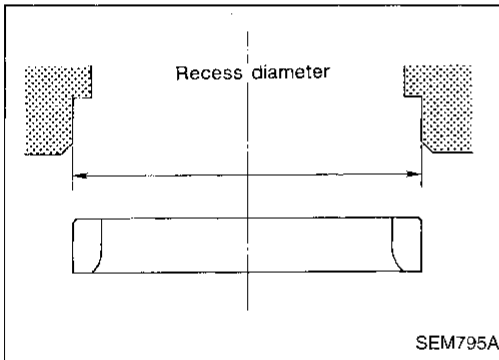
**Intake and Exhaust**

**6.000 - 6.018 mm (0.2362 - 0.2369 in)**

### VALVE SEATS

Check valve seats for any evidence of pitting at valve contact surface, and reseat or replace if it has worn excessively.

- **Before repairing valve seats, check valve and valve guide for wear. If they have worn, replace them. Then correct valve seat.**
- **Use both hands to cut uniformly.**

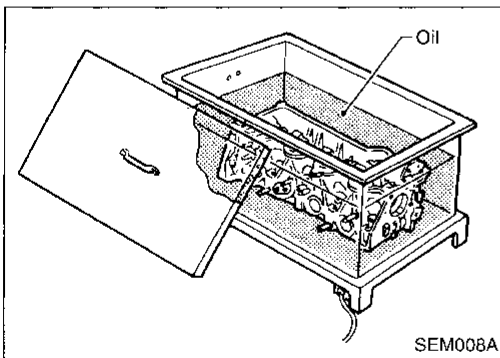


### REPLACING VALVE SEAT FOR SERVICE PARTS

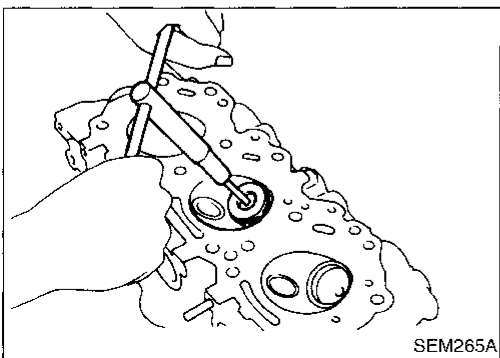
1. Bore out old seat until it collapses. Boring should not continue beyond the bottom face of the seat recess in cylinder head. Set the machine depth stop to ensure this.
2. Ream cylinder head recess for service valve seat.  
**Oversize [0.5 mm (0.020 in)]:**  
**Intake 36.500 - 36.516 mm (1.4370 - 1.4376 in)**  
**Exhaust 32.000 - 32.016 mm (1.2598 - 1.2605 in)**

**Be sure to ream in circles concentric to the valve guide center.**

**This will enable valve seat to fit correctly.**



3. Heat cylinder head to 150 to 160°C (302 to 320°F).
4. Press fit valve seat until it seats on the bottom.



5. Cut or grind valve seat using suitable tool at the specified dimensions as shown in SDS (EM-58).
6. After cutting, lap valve seat with abrasive compound.
7. Check valve seat contact condition.

## CYLINDER HEAD

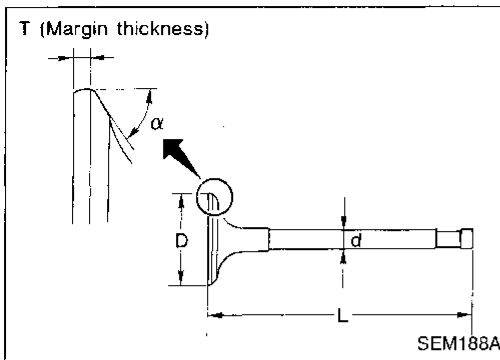
### Inspection (Cont'd)

#### VALVE DIMENSIONS

Check dimensions of each valve. For dimensions, refer to SDS (EM-57).

When valve head has been worn down to 0.5 mm (0.020 in) in margin thickness, replace valve.

**Grinding allowance for valve stem tip is 0.2 mm (0.008 in) or less.**



#### VALVE SPRING

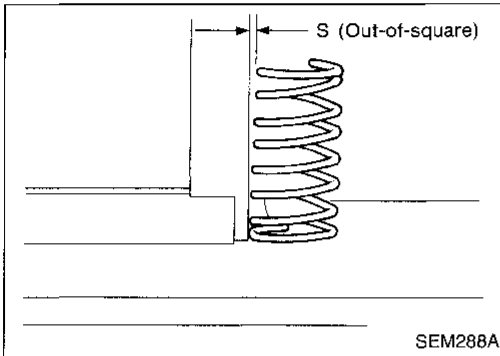
##### Squareness

1. Measure dimension "S".

**Out-of-square:**

**Less than 1.8 mm (0.071 in)**

2. If it exceeds the limit, replace spring.



##### Pressure

Check valve spring pressure at specified spring height.

**Pressure: N (kg, lb) at height mm (in)**

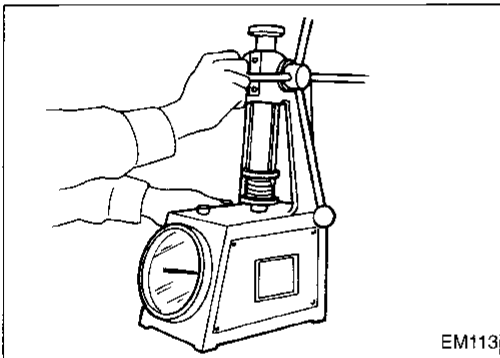
**Standard:**

**536.4 (54.7, 120.6) at 26.5 (1.043)**

**Limit:**

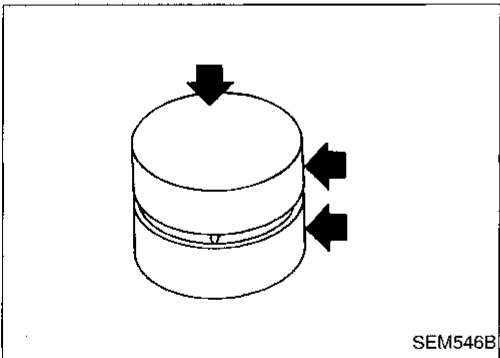
**452.79 (46.17, 101.80) at 26.5 (1.043)**

**If it exceeds the limit, replace spring.**



#### HYDRAULIC LASH ADJUSTER (HLA)

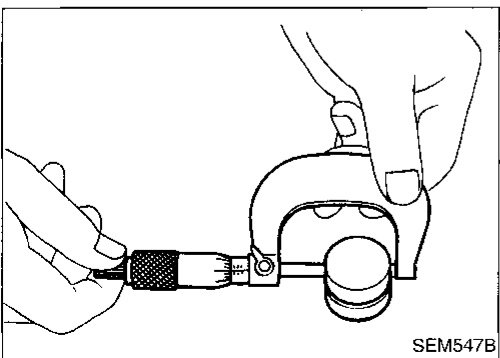
1. Check contact and sliding surfaces for wear or scratches.



2. Check diameter of HLA.

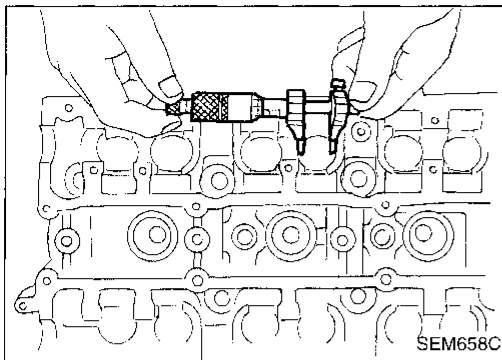
**Outer diameter:**

**30.955 - 30.965 mm (1.2187 - 1.2191 in)**



# CYLINDER HEAD

## Inspection (Cont'd)



3. Check HLA guide hole diameter.

Inner diameter:

31.000 - 31.020 mm (1.2205 - 1.2213 in)

Standard clearance between HLA and HLA guide hole:

0.035 - 0.065 mm (0.0014 - 0.0026 in)

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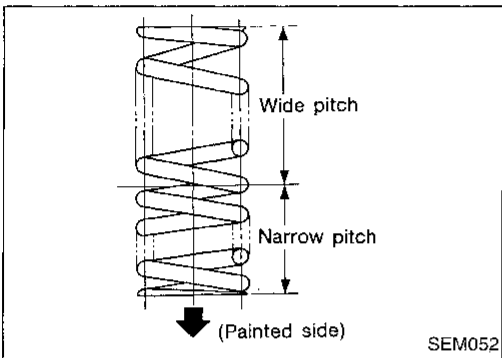
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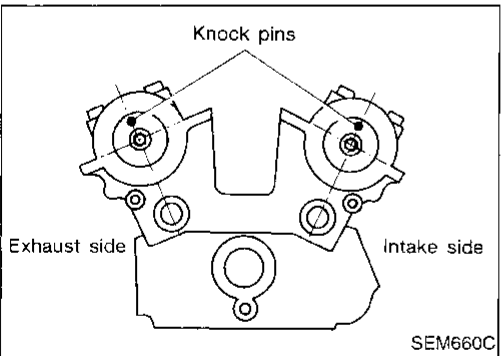
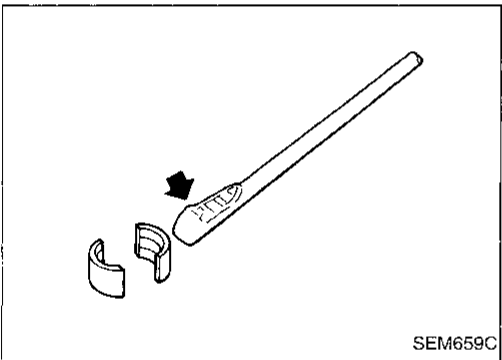
## Assembly

1. Install valve component parts.

- Always use new valve oil seal. Refer to OIL SEAL REPLACEMENT (EM-19).
- Install valve spring (uneven pitch type) with its narrow pitch side (painted side) toward cylinder head side.
- After installing valve component parts, tap valve stem tip with plastic hammer to assure a proper fit.

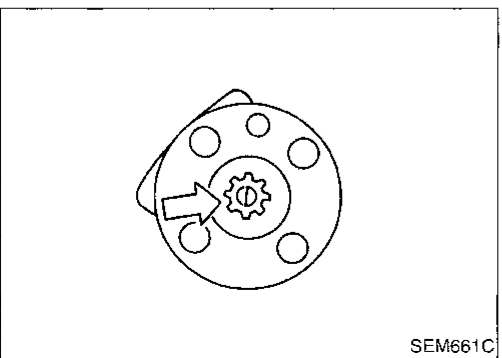


- To facilitate installation of collet, apply a small amount of grease to a suitable rod and attach collet to it.



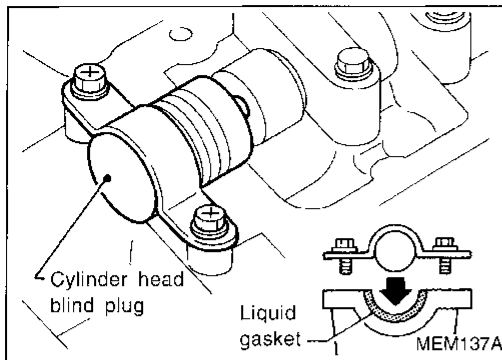
2. Install camshafts as shown.

- Exhaust camshaft (left bank) has spline for camshaft position sensor.

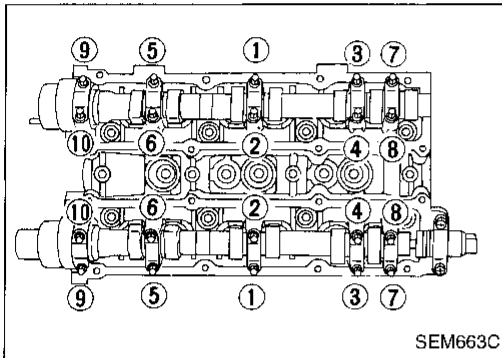


## CYLINDER HEAD

### Assembly (Cont'd)

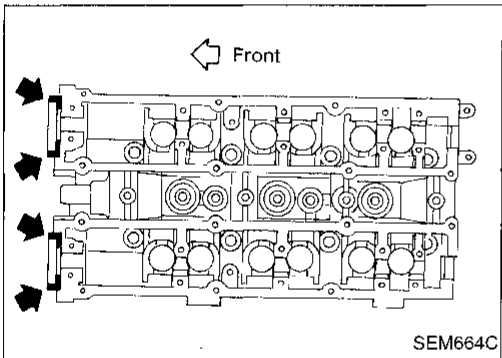


- Apply liquid gasket to cylinder head blind plugs when installing.



3. Install camshaft brackets.

**Tighten camshaft bracket bolts gradually in two or three stages.**



**When installing front side camshaft brackets, apply liquid gasket as shown.**

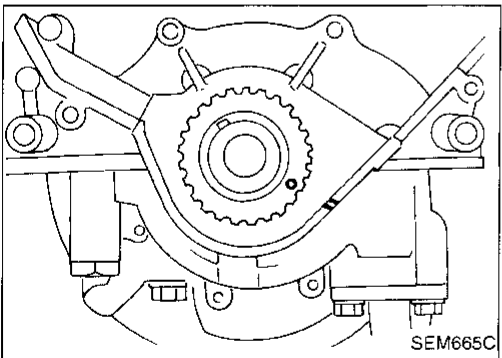
4. Apply engine oil to camshaft oil seal lip and install it in place.

**Always use new camshaft oil seal.**

5. Install rear timing belt cover.

6. Install camshaft sprockets.

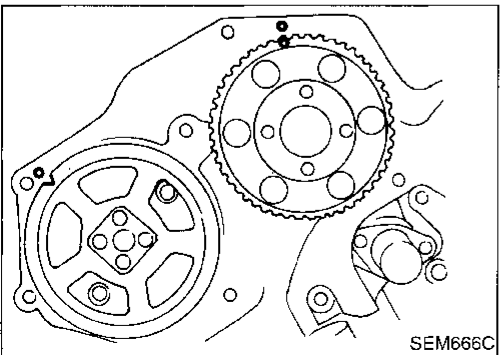
**When tightening bolts, fix camshaft to prevent it from rotating.**



### Installation

1. Set No. 1 piston at TDC on its compression stroke as follows:

(1) Align crankshaft sprocket aligning mark with mark on oil pump body.

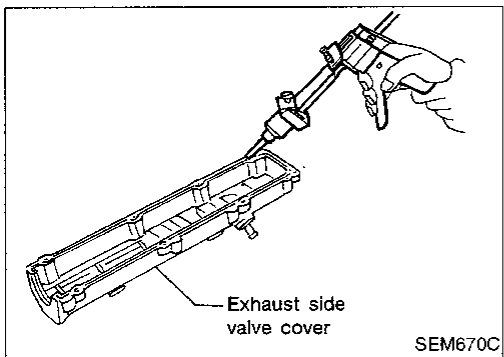
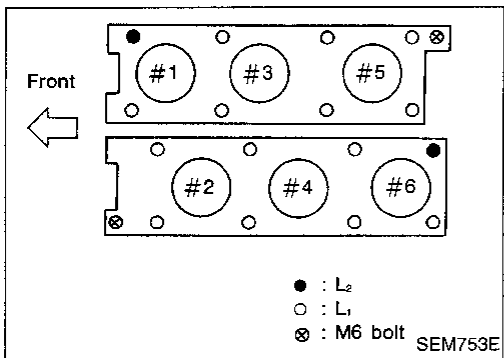
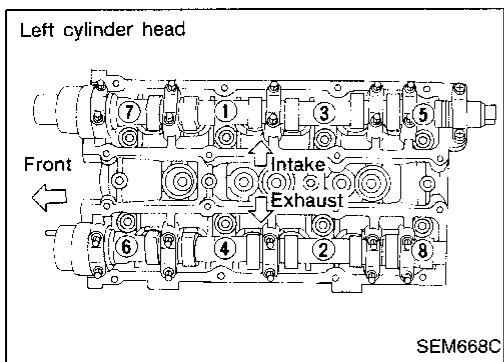
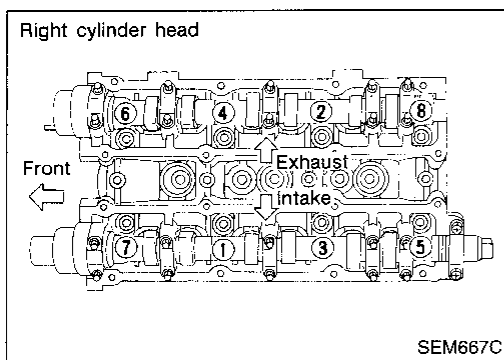
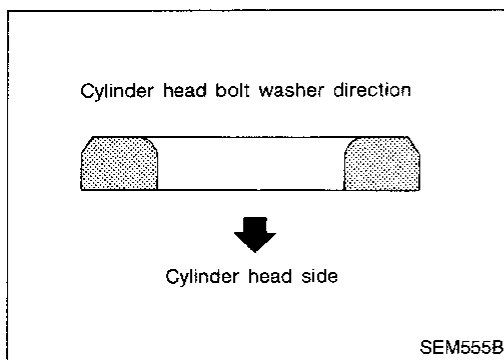


(2) Align camshaft sprocket aligning mark with mark on timing belt rear cover.



# CYLINDER HEAD

## Installation (Cont'd)



2. Install cylinder head with new gasket.
  - Be sure to install washers between bolts and cylinder head.
  - Do not rotate crankshaft and camshaft separately, or valves will hit piston heads.
3. Install cylinder head bolts.
  - Install short bolts (L<sub>2</sub>) into the correct holes of cylinders #1 and #6 as shown in figure of step (6).
  - Apply engine oil to threads and seating surfaces of cylinder head bolts before installing them.

4. Tighten cylinder head bolts in numerical order.
  - Tightening procedure
  - (1) Tighten all bolts to 39 N·m (4.0 kg·m, 29 ft·lb).
  - (2) Tighten all bolts to 123 N·m (12.5 kg·m, 90 ft·lb).
  - (3) Loosen all bolts completely.
  - (4) Tighten all bolts to 34 to 44 N·m (3.5 to 4.5 kg·m, 25 to 33 ft·lb).
  - (5) Tighten all bolts to 123 N·m (12.5 kg·m, 90 ft·lb) or if an angle wrench is available, tighten bolts 70 to 75 degrees (L<sub>1</sub>), 65 to 70 degrees (L<sub>2</sub>) clockwise.

- (6) Tighten bolts (⊗) as shown to 10 to 12 N·m (1.0 to 1.2 kg·m, 7 to 9 ft·lb).

5. Install valve covers. When installing exhaust side valve cover, apply liquid gasket as shown.

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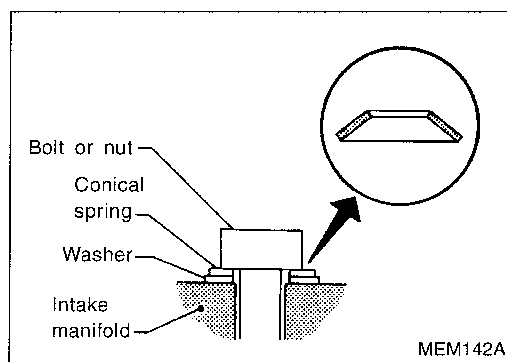
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## CYLINDER HEAD

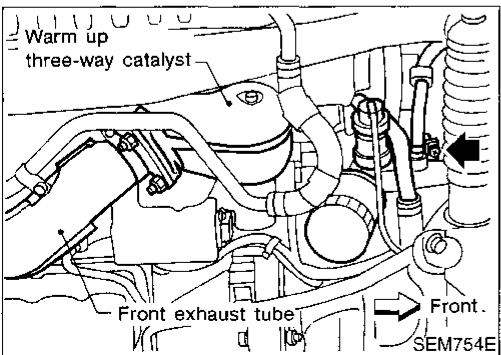
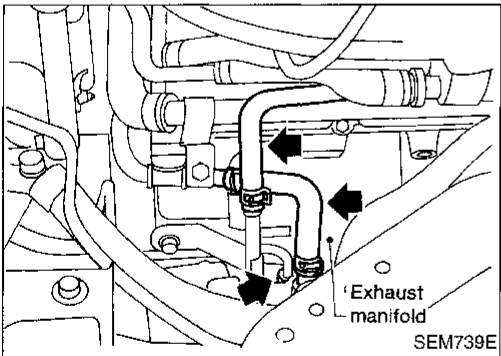
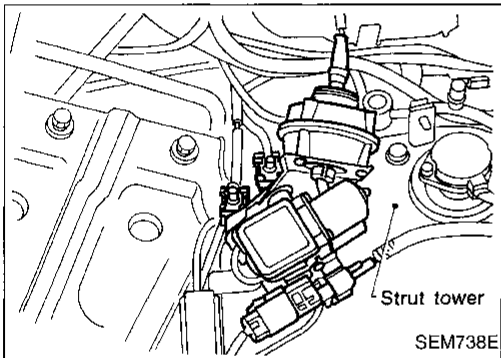
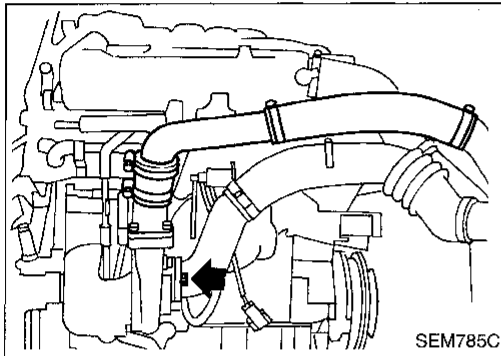
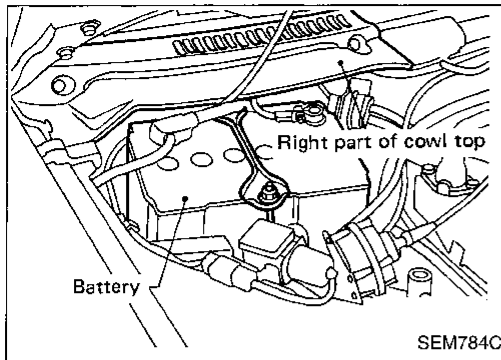
### Installation (Cont'd)

6. Install intake manifold.

**Pay attention to direction of conical spring.**



7. Install remaining parts.



## Removal

### RIGHT SIDE UNIT

1. Remove right part of cowl top.
2. Remove battery.
3. Remove air inlet hose and pipe.
4. Disconnect lower pipe from turbocharger unit.
5. Remove ASCD bracket with wiper motor and solenoid valves.
6. Disconnect front heated oxygen sensor (right bank) harness connector.
7. Remove turbocharger water hoses, and disconnect turbocharger oil inlet tube.
8. Remove two bolts fastening warm up three-way catalyst to turbocharger unit.
9. Remove the following parts;
  - oil pressure switch
  - oil filter
  - turbocharger oil return tube
  - front exhaust tube
  - warm up three-way catalyst
10. Disconnect oil hose from oil filter bracket, and turbocharger water tubes from turbocharger unit.

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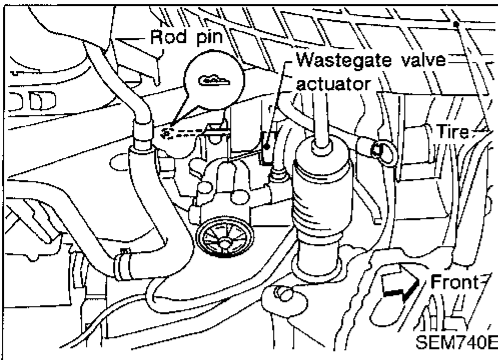
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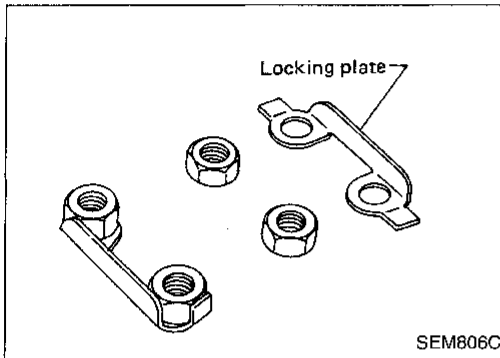
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# TURBOCHARGERS

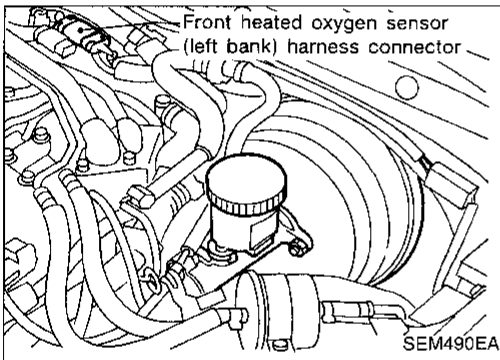
## Removal (Cont'd)



11. Remove rod pin of wastegate valve actuator.
12. Remove oil filter bracket.

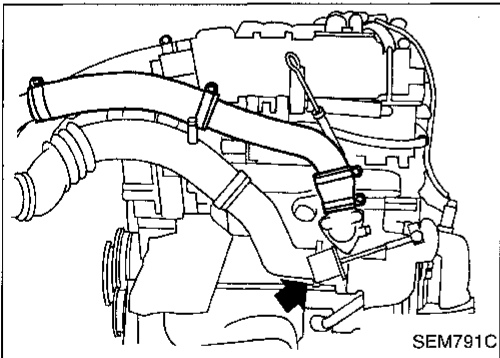


13. Unbend locking plates for fastening nuts of turbocharger unit.
14. Remove turbocharger unit.

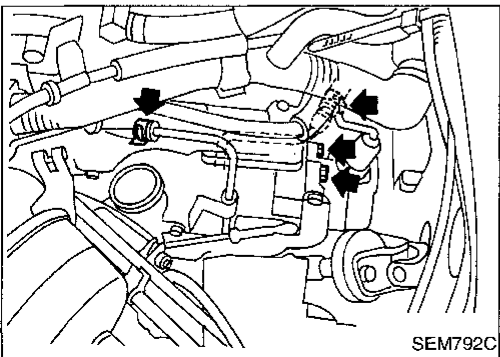


## LEFT SIDE UNIT

1. Remove brake master cylinder and brake booster.
2. Disconnect front heated oxygen sensor (left bank) harness connector.



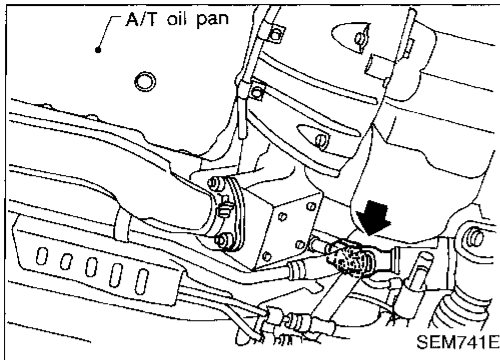
3. Remove air inlet hose and pipe.
4. Disconnect lower pipe from turbocharger unit.



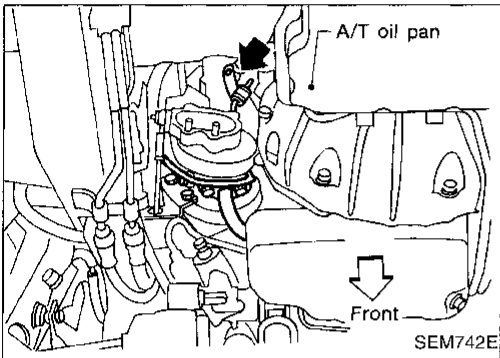
5. Disconnect water tubes.
6. Remove two bolts fastening warm up three-way catalyst to turbocharger unit.

# TURBOCHARGERS

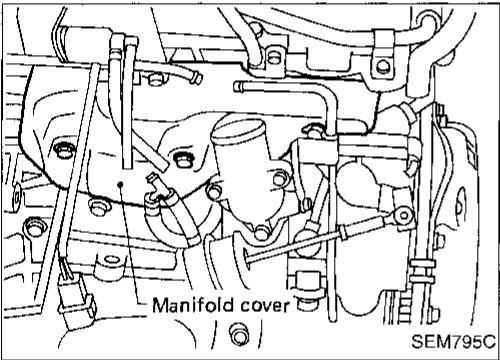
## Removal (Cont'd)



7. Remove front exhaust tube and warm up three-way catalyst.
8. Disconnect steering lower joint.

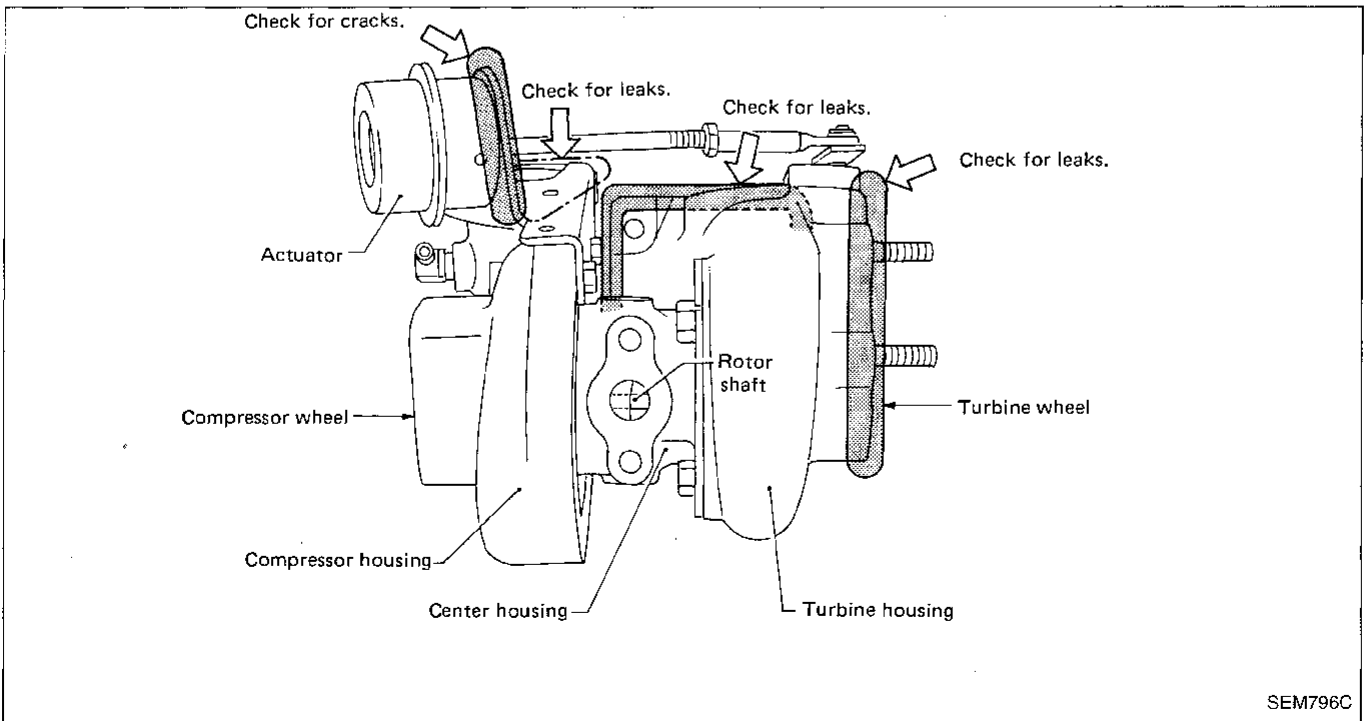


9. Remove turbocharger oil return tube and water tubes.
10. Disconnect EGR tube and actuator bracket of turbocharger wastegate valve.



11. Remove manifold cover and fastening nuts.
12. Remove turbocharger unit with exhaust manifold.

## Inspection



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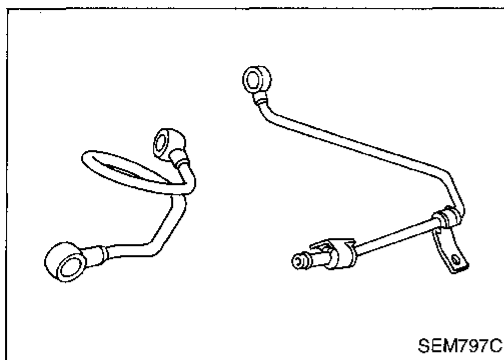
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# TURBOCHARGERS

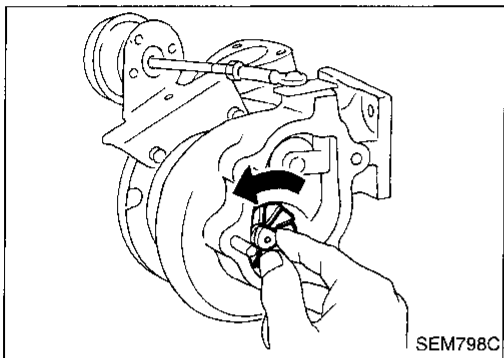
## Inspection (Cont'd) OIL AND WATER TUBES

Check tubes for clogging.

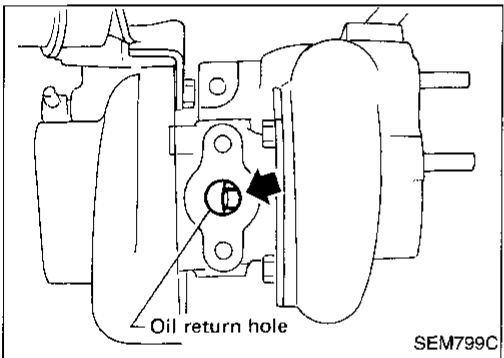


## ROTOR SHAFT

1. Check rotor shaft for smooth rotating.

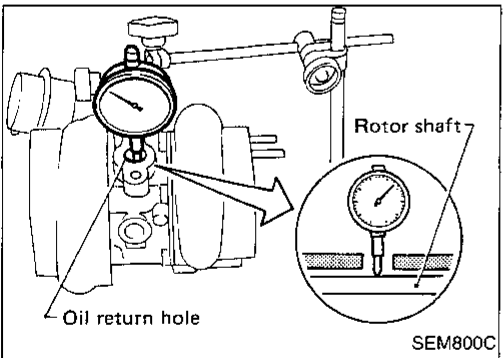


2. Check rotor shaft for carbon deposits.



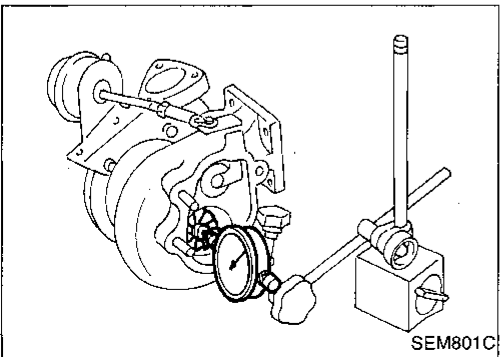
3. Measure runout of rotor shaft.

**Runout (Total indicator reading):**  
0.056 - 0.127 mm (0.0022 - 0.0050 in)



4. Measure end play of rotor shaft.

**End play:**  
0.013 - 0.096 mm (0.0005 - 0.0038 in)



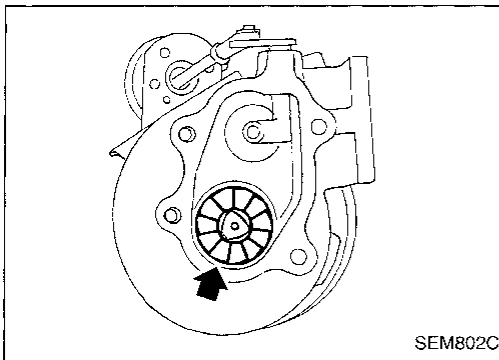
# TURBOCHARGERS

## Inspection (Cont'd)

### TURBINE WHEEL

Check turbine wheel for the following:

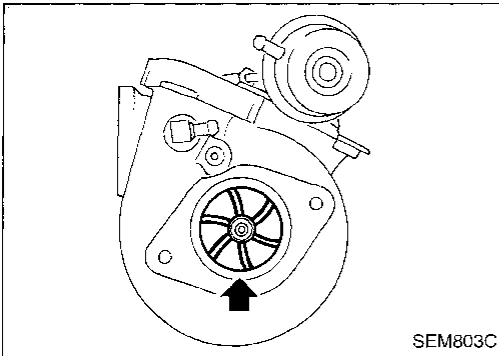
- Oil
- Carbon deposits
- Deformed fins
- Contact with turbine housing



### COMPRESSOR WHEEL

Check compressor wheel for the following:

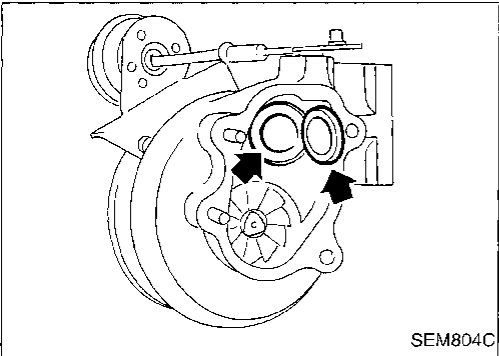
- Oil
- Deformed fins
- Contact with compressor housing



### WASTEGATE VALVE

Remove rod pin and check wastegate valve for cracks, deformation and smooth movement.

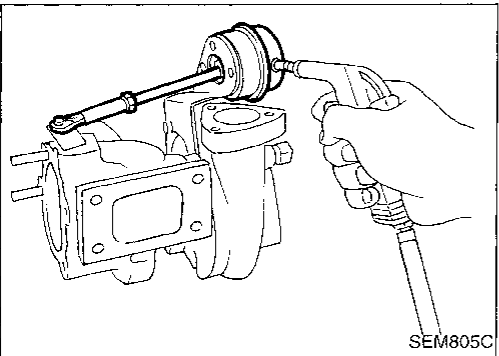
Check valve seat surface for smoothness.



### WASTEGATE VALVE ACTUATOR

Apply air pressure to wastegate valve actuator and check it for smooth movement.

- Do not keep applying air pressure to the actuator.
- The air pressure should be in the range of 78 to 88 kPa (0.8 to 0.9 kg/cm<sup>2</sup>, 11 to 13 psi).



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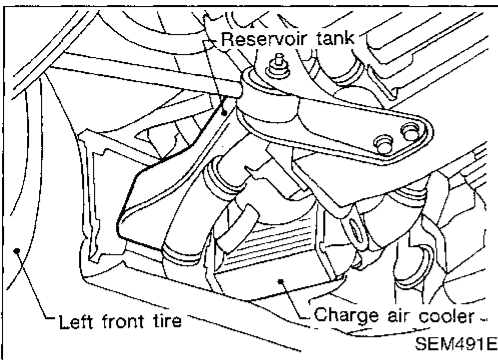
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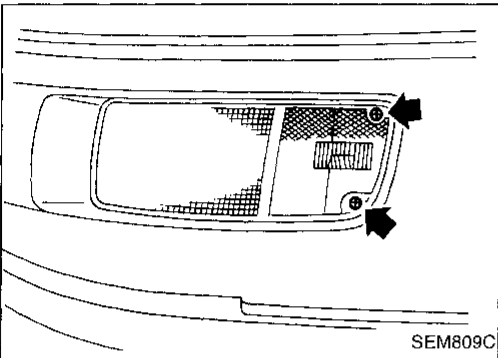
IX

# CHARGE AIR COOLERS

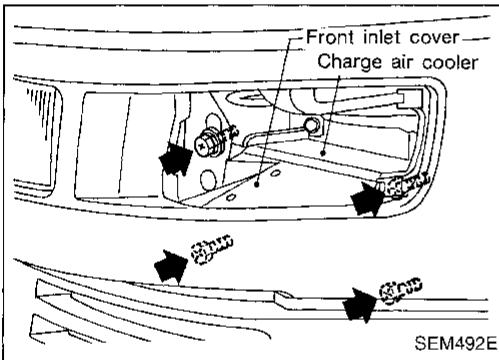


## Removal

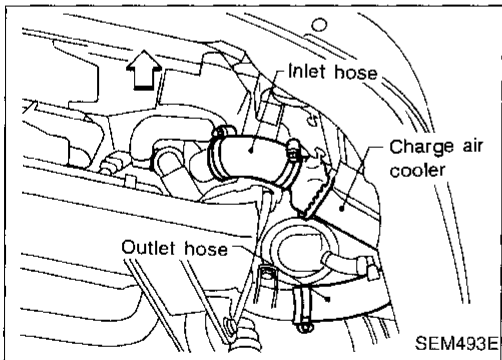
1. Remove front part of front fender protector.
2. Remove reservoir tank when servicing left side charge air cooler.



3. Remove front combination lamp.



4. Remove bolts fastening charge air cooler and front inlet cover.

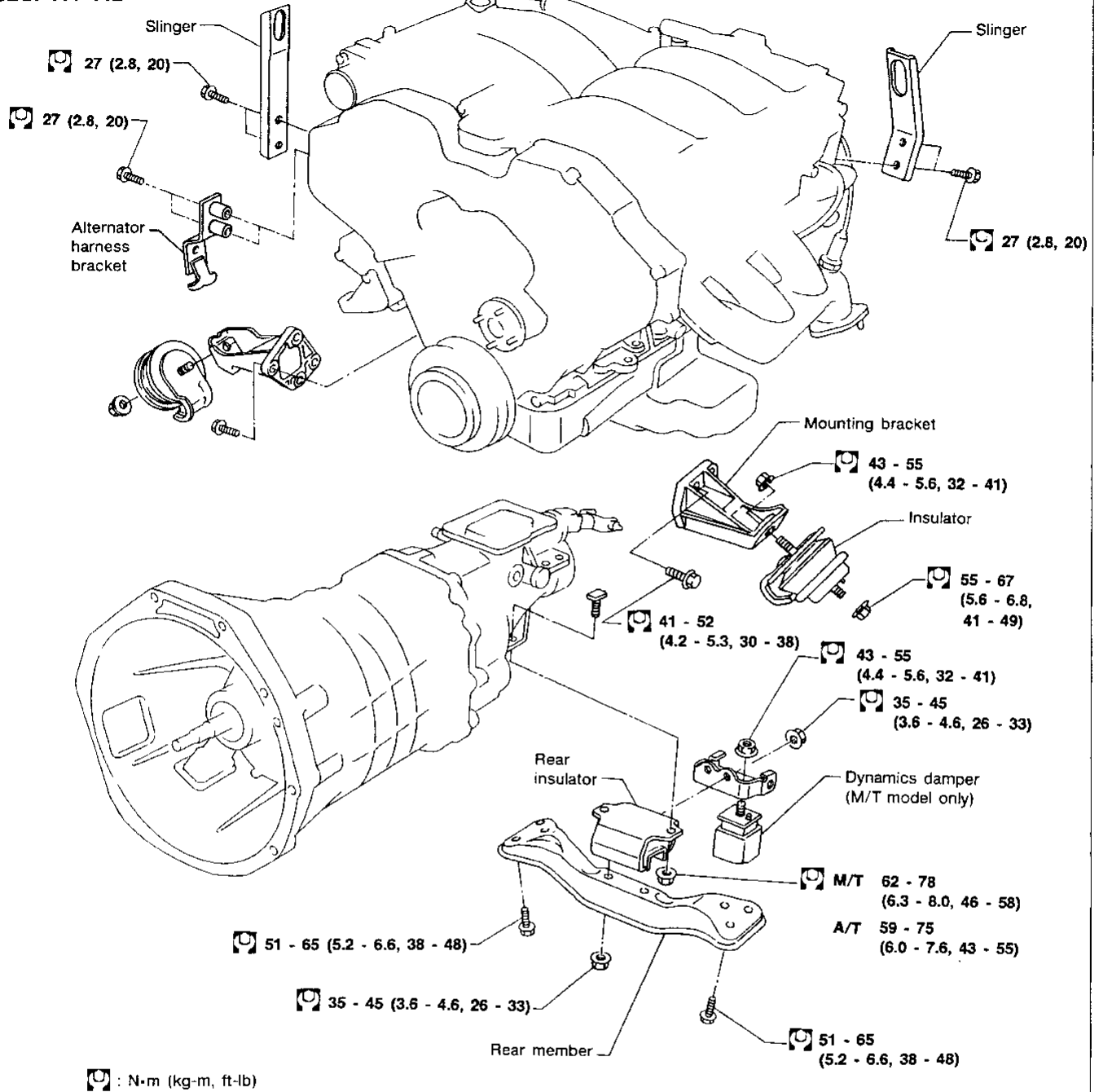


5. Remove inlet and outlet hoses.
6. Remove charge air cooler unit.



# ENGINE REMOVAL

SEC. 111-112



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# ENGINE REMOVAL

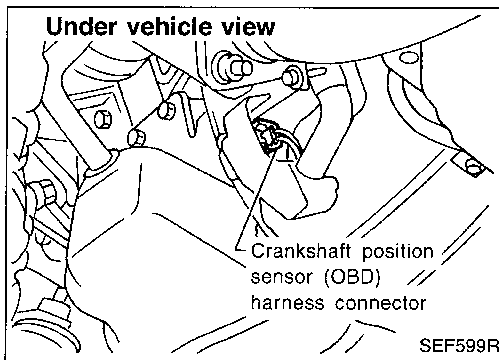
## WARNING:

- Situate vehicle on a flat and solid surface.
- Place chocks at front and back of rear wheels.
- Do not remove engine until exhaust system has completely cooled off. Otherwise, you may burn yourself and/or fire may break out in fuel line.
- For safety during subsequent steps, the tension of wires should be slackened against the engine.
- Before disconnecting fuel hose, release fuel pressure from fuel line.  
Refer to EC section ("Fuel Pressure Release", "BASIC SERVICE PROCEDURE").

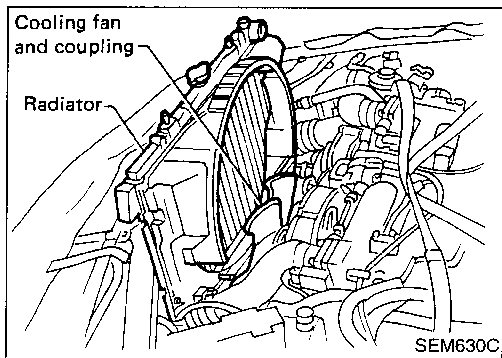
- Be sure to hoist engine and transmission in a safe manner.
- For engines not equipped with engine slingers, attach proper slingers and bolts described in PARTS CATALOG.

## CAUTION:

- When lifting engine, be careful not to strike adjacent parts, especially the following: Accelerator wire casing, brake lines, and brake master cylinder.
- In hoisting the engine, always use engine slingers in a safe manner.

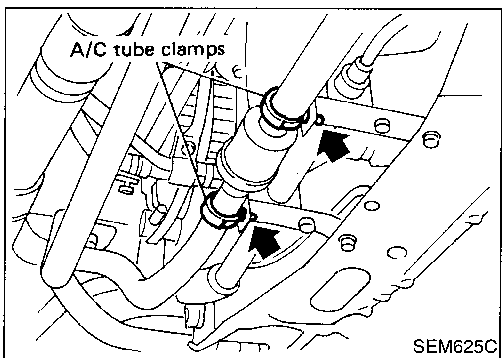


- Before separating engine and transmission, remove crankshaft position sensor (OBD) from the assembly.
- Always take extra care not to damage edge of crankshaft position sensor (OBD), or ring gear teeth.



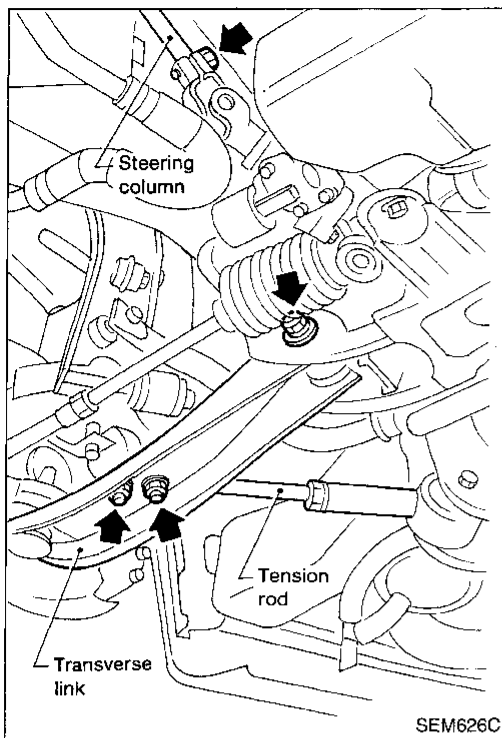
## M/T Model

1. Remove engine under cover and hood.
2. Drain coolant from both cylinder block drain plugs, and radiator drain cock.
3. Drain engine oil from drain plug of oil pan.
4. Remove vacuum hoses, fuel tubes, wires, harnesses and connectors and so on.
5. Remove front exhaust tubes and propeller shaft.
6. Remove radiator.
7. Remove drive belts, cooling fan and coupling.
8. Remove P/S oil pump, alternator, A/C compressor, starter motor, and clutch operating cylinder.
9. Disconnect A/C tube clamps as shown.

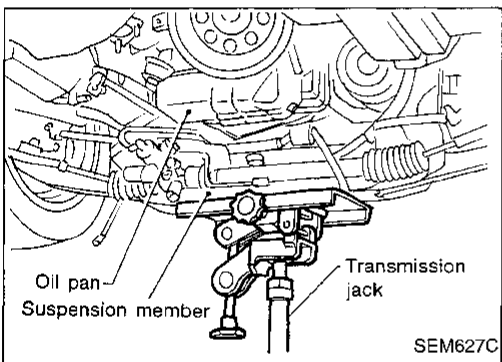


## ENGINE REMOVAL

### M/T Model (Cont'd)



10. Disconnect steering column lower joint.
11. Remove tension rod fixing bolts from both sides.
12. Loosen transverse link bolts on both sides.



13. Set a suitable transmission jack under suspension member.
  - At this time, hoist engine with engine slinger.
14. Remove suspension member fixing bolts.
15. Remove engine mounting bolts from both sides and then slowly lower transmission jack.
16. Remove engine with transmission as shown in following figure.

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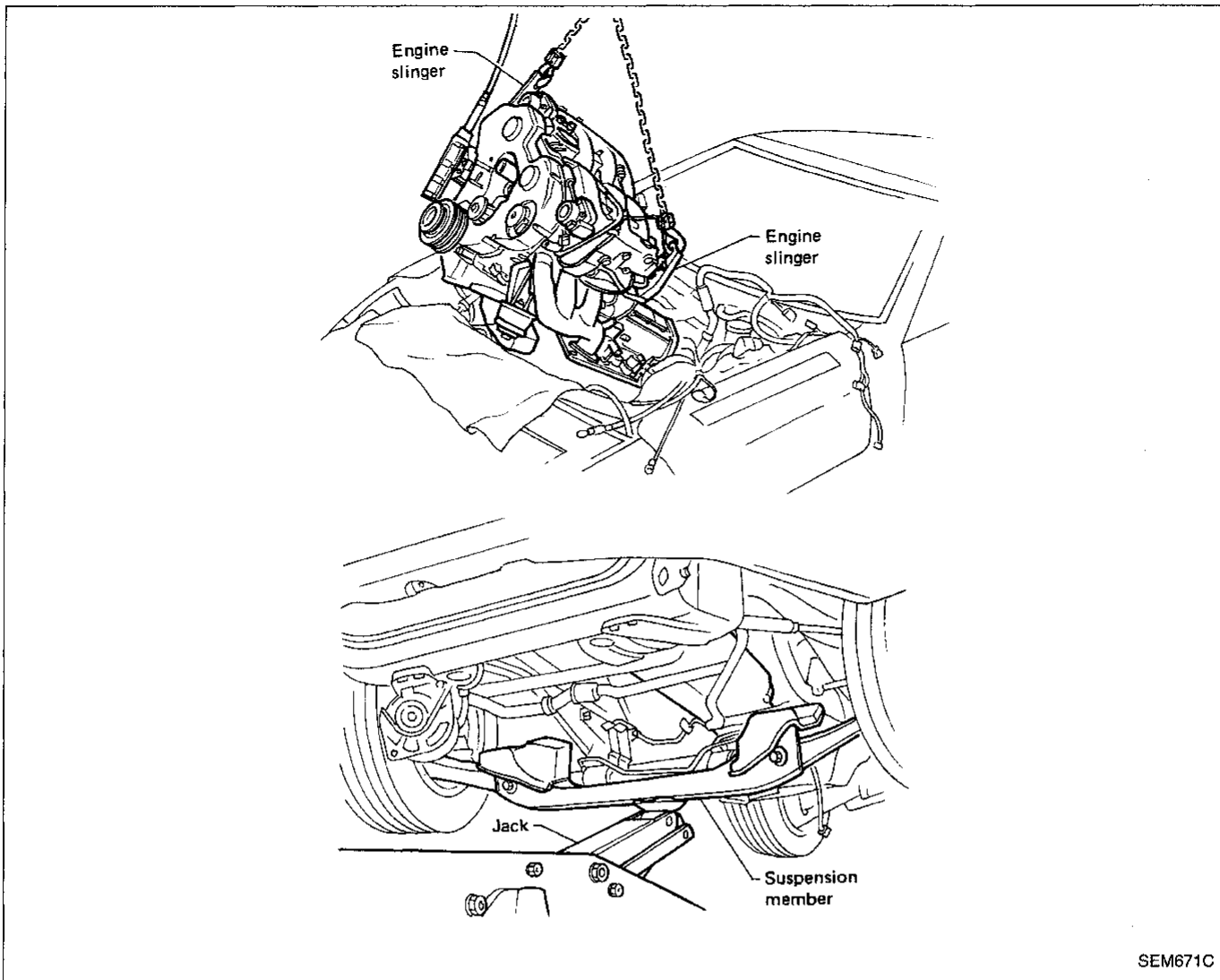
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## ENGINE REMOVAL M/T Model (Cont'd)



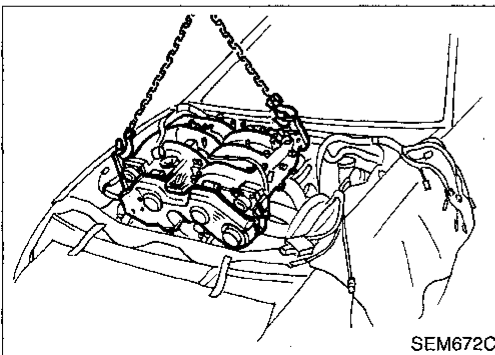
### A/T Model

1. Perform the same procedures (1 to 8) as for M/T model.
2. Remove transmission from vehicle.

**Refer to "REMOVAL AND INSTALLATION" in AT section.**

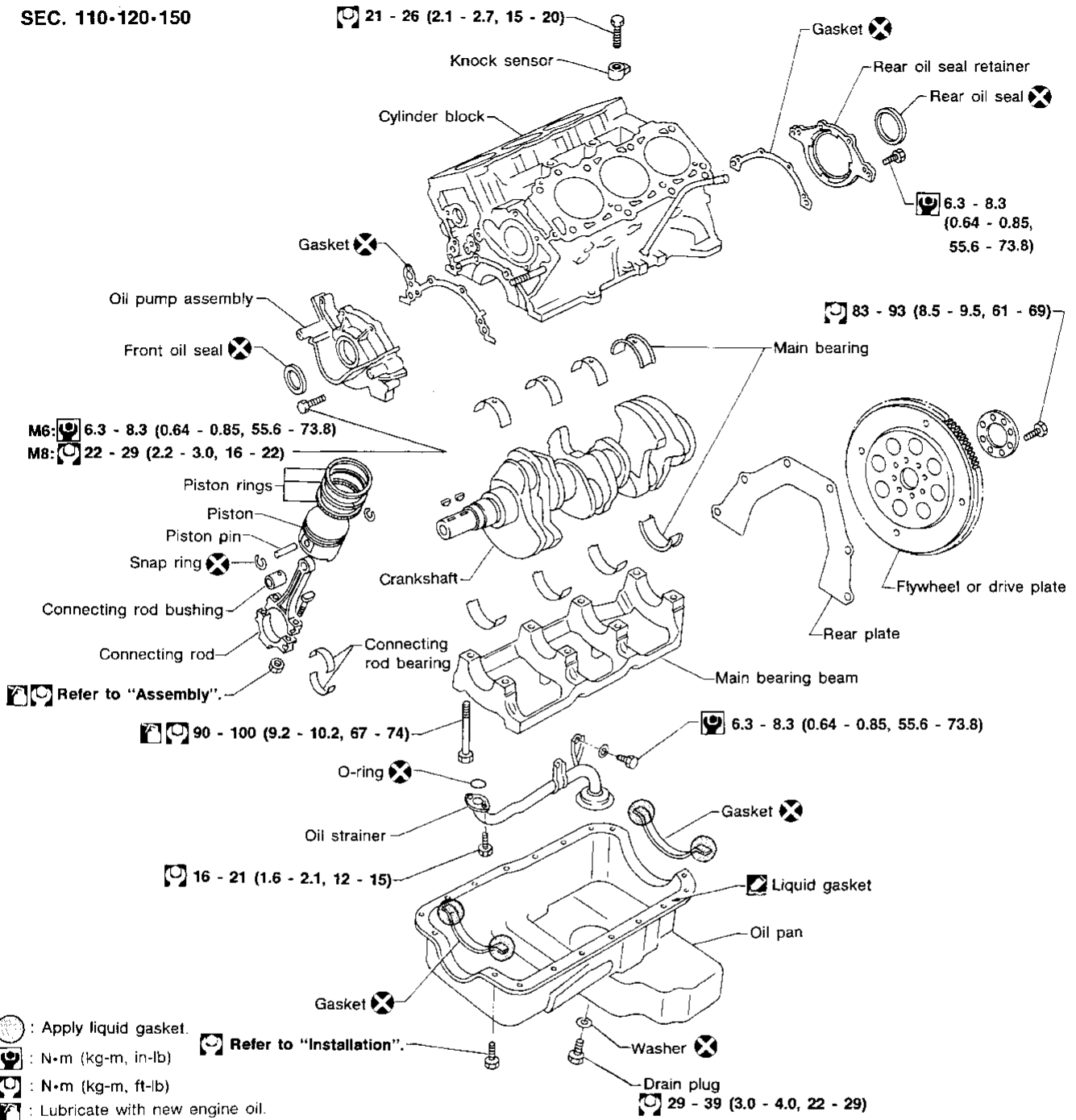
3. Hoist engine with engine slingers and remove engine mounting bolts from both sides.

4. Remove engine from vehicle as shown.



# CYLINDER BLOCK

SEC. 110-120-150

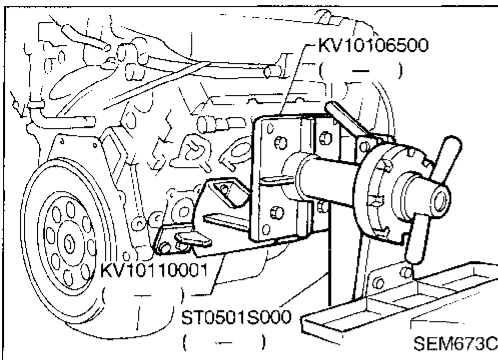


SEM355EB

## CAUTION:

- When installing bearings, pistons, or other sliding parts, lubricate contacting surfaces with new engine oil.
- Place removed parts such as bearings and bearing caps in their proper order and direction.
- When installing connecting rod nuts, and main bearing cap bolts, apply new engine oil to threads and seating surfaces.
- Do not allow any magnetic materials to contact the ring gear teeth on flywheel or drive plate and rear plate.

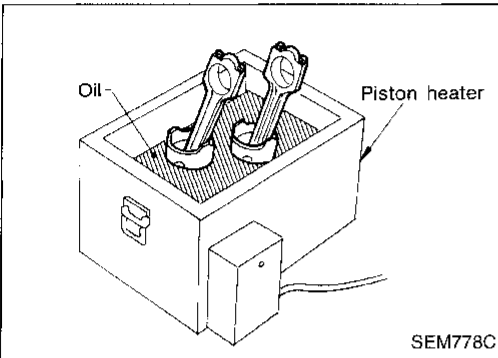
# CYLINDER BLOCK



## Disassembly

### PISTON AND CRANKSHAFT

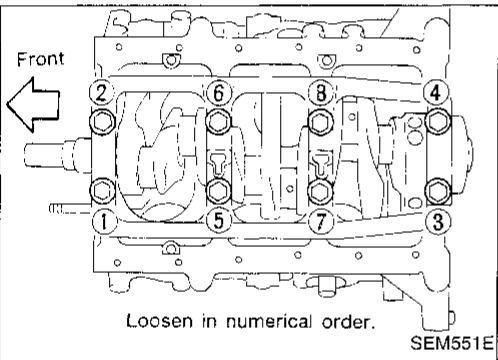
1. Place engine on a work stand.
2. Remove timing belt.
3. Drain coolant and remove water pump.
4. Drain oil.
5. Remove oil pan, oil pump and rear oil seal retainer.
6. Remove intake manifold collector, intake manifold and cylinder head.



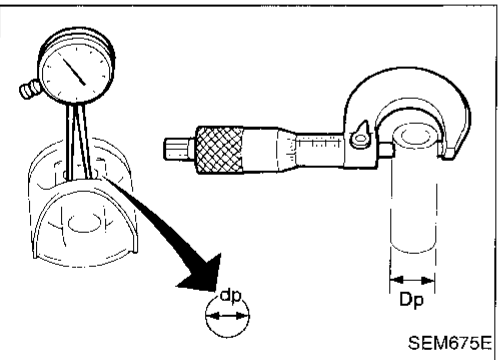
7. Remove pistons.
  - When disassembling piston and connecting rod, remove snap ring first, then heat piston to 60 to 70°C (140 to 158°F).

### CAUTION:

- When piston rings are not replaced, make sure that piston rings are mounted in their original positions.
- When replacing piston rings, if there is no punchmark, install with either side up.



8. Remove bearing cap and crankshaft.
  - Before removing bearing cap, measure crankshaft end play.
  - Bolts should be loosened in two or three steps.



## Inspection

### PISTON AND PISTON PIN CLEARANCE

1. Measure inner diameter of piston pin hole "dp".  
**Standard diameter "dp":**  
21.987 - 21.999 mm (0.8656 - 0.8661 in)
2. Measure outer diameter of piston pin "Dp".  
**Standard diameter "Dp":**  
21.989 - 22.001 mm (0.8657 - 0.8662 in)
3. Calculate piston pin clearance.  
**dp - Dp = -0.004 to 0 mm (-0.0002 to 0 in)**

If it exceeds the above value, replace piston assembly with pin.

# CYLINDER BLOCK

## Inspection (Cont'd)

### PISTON RING SIDE CLEARANCE

Side clearance:

Top ring  
0.040 - 0.073 mm (0.0016 - 0.0029 in)

2nd ring  
0.030 - 0.063 mm (0.0012 - 0.0025 in)

Oil ring  
0.015 - 0.185 mm (0.0006 - 0.0073 in)

Max. limit of side clearance:

Top and 2nd ring  
0.1 mm (0.004 in)

Oil ring  
0.2 mm (0.008 in)

If out of specification, replace piston and/or piston ring. If clearance exceeds maximum limit with new ring, replace piston.

### PISTON RING END GAP

End gap:

Top ring 0.21 - 0.40 mm (0.0083 - 0.0157 in)

2nd ring 0.50 - 0.76 mm (0.0197 - 0.0299 in)

Oil ring 0.20 - 0.76 mm (0.0079 - 0.0299 in)

Max. limit of end gap:

1.0 mm (0.039 in)

If out of specification, replace piston ring. If gap still exceeds the limit even with a new ring, do the following. Rebore cylinder and use oversized piston and piston rings.

Refer to SDS (EM-59).

- When replacing the piston, check the cylinder block surface for scratches or seizure. If scratches or seizure is found, hone or replace the cylinder block.

### CONNECTING ROD BEND AND TORSION

Bend:

Limit 0.15 mm (0.0059 in) per 100 mm (3.94 in) length

Torsion:

Limit 0.3 mm (0.012 in) per 100 mm (3.94 in) length

If it exceeds the limit, replace connecting rod assembly.

### CYLINDER BLOCK DISTORTION AND WEAR

- Clean upper surface of cylinder block. Use a reliable straightedge and feeler gauge to check the flatness of cylinder block surface.

**Distortion limit: 0.10 mm (0.0039 in)**

- If out of specification, resurface it. The limit for cylinder block resurfacing is determined by cylinder head resurfacing in engine.

### Resurfacing limit:

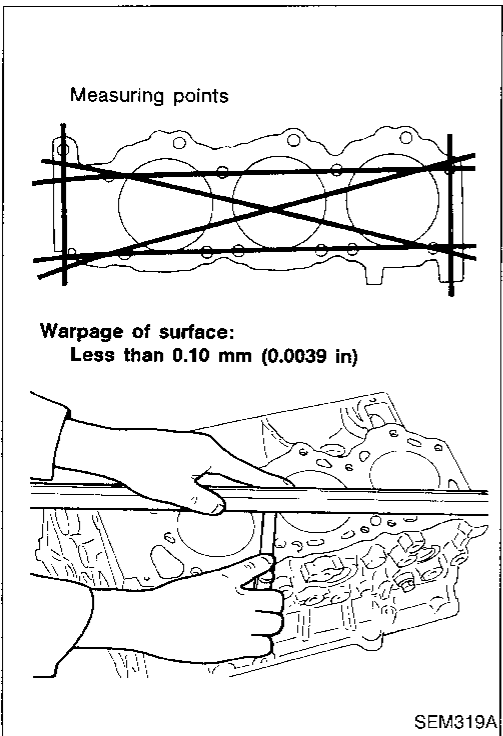
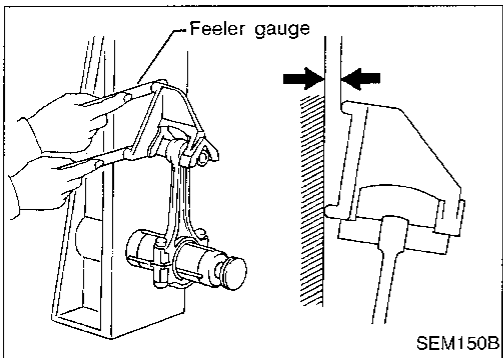
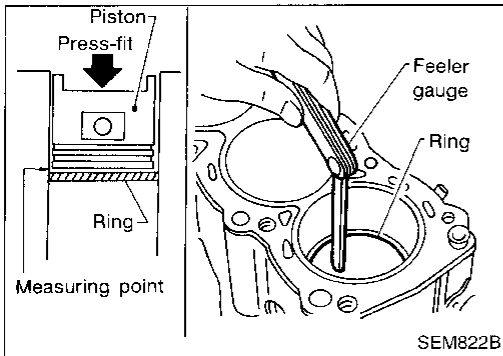
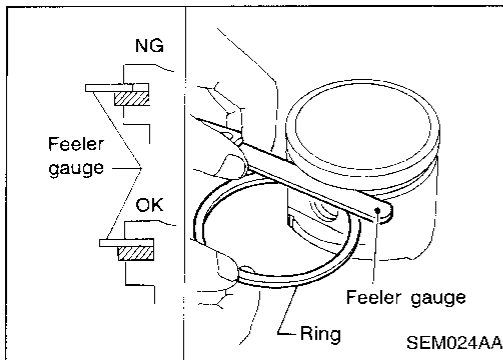
Amount of cylinder head resurfacing is "A".

Amount of cylinder block resurfacing is "B".

The maximum limit is as follows:

$A + B = 0.2 \text{ mm (0.008 in)}$

- If necessary, replace cylinder block.



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# CYLINDER BLOCK

## Inspection (Cont'd)

### PISTON-TO-BORE CLEARANCE

- Using a bore gauge, measure cylinder bore for wear, out-of-round and taper.

**Standard inner diameter:**

**Refer to SDS (EM-61).**

**Wear limit: 0.20 mm (0.0079 in)**

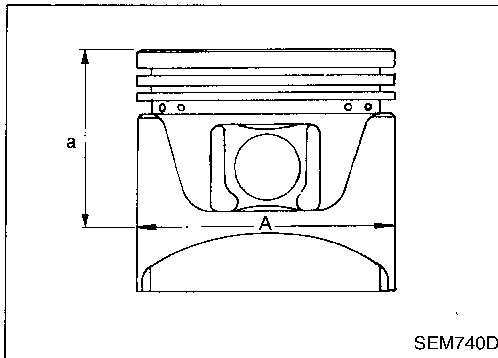
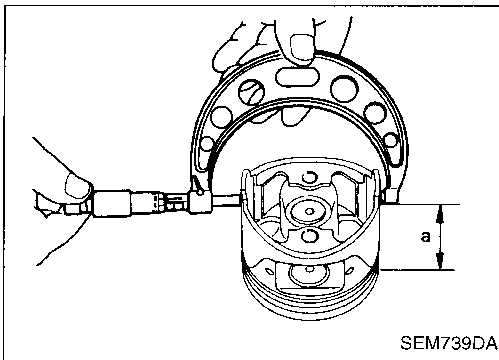
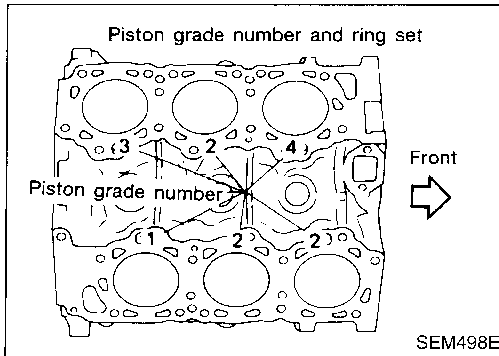
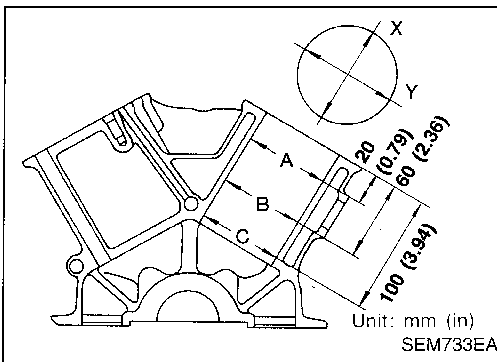
**Out-of-round (X – Y) standard: 0.015 mm (0.0006 in)**

**Taper (A – B – C) standard: 0.015 mm (0.0006 in)**

If it exceeds the limit, rebore all cylinders. Replace cylinder block if necessary.

- Check for scratches and seizure. If seizure is found, hone it.

- If cylinder block or piston is replaced, match piston grade with grade number on cylinder block upper surface.**



- Measure piston skirt diameter.

**Piston diameter "A":**

**Refer to SDS (EM-59).**

**Measuring point "a" (Distance from the top):**

**48.0 mm (1.890 in)**

- Check that piston-to-bore clearance is within specification.

**Piston-to-bore clearance "B":**

**Non-turbocharger**

**0.015 - 0.035 mm (0.0006 - 0.0014 in)**

**Turbocharger**

**0.025 - 0.045 mm (0.0010 - 0.0018 in)**

- Determine piston oversize according to amount of wear.

**Oversize pistons are available for service. Refer to SDS (EM-59).**

- Cylinder bore size is determined by adding piston-to-bore clearance to piston diameter "A".

**Rebored size calculation:**

**D = A + B - C**

**D: Bored diameter**

**A: Piston diameter as measured**

**B: Piston-to-bore clearance**

**C: Honing allowance 0.02 mm (0.0008 in)**

- Install main bearing caps, and tighten to the specified torque. Otherwise, cylinder bores may be distorted in final assembly.

- Cut cylinder bores.

- When any cylinder needs boring, all other cylinders must also be bored.**

- Do not cut too much out of cylinder bore at a time. Cut only 0.05 mm (0.0020 in) or so in diameter at a time.**

- Hone cylinders to obtain specified piston-to-bore clearance.

- Measure finished cylinder bore for out-of-round and taper.

- Measurement should be done after cylinder bore cools down.**



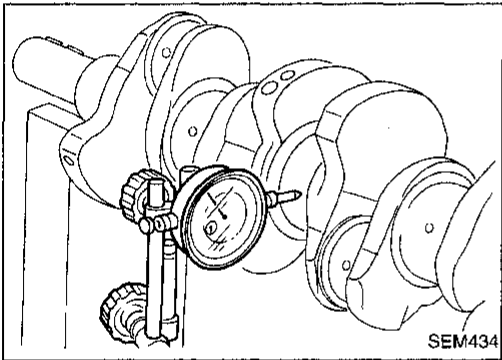
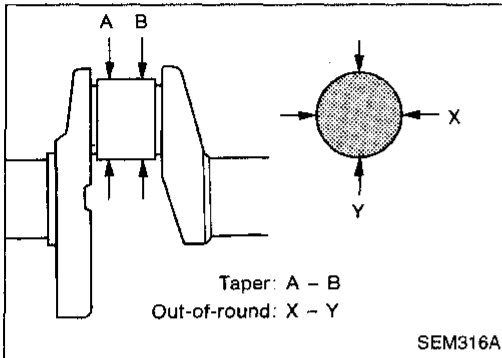
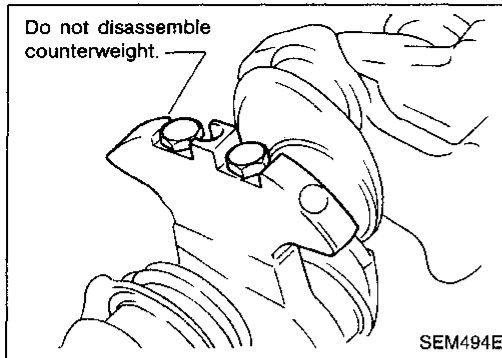
# CYLINDER BLOCK

## Inspection (Cont'd)

### CRANKSHAFT

#### CAUTION:

Never attempt to disassemble crankshaft counter weight.



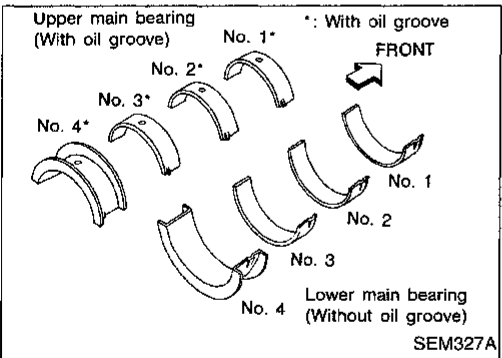
1. Check crankshaft main and pin journals for score, wear or cracks.
2. With a micrometer, measure journals for taper and out-of-round.

**Out-of-round (X - Y):**  
Less than 0.005 mm (0.0002 in)

**Taper (A - B):**  
Less than 0.005 mm (0.0002 in)

**Limit:**  
0.02 mm (0.0008 in)

3. Measure crankshaft runout.  
**Runout (Total indicator reading):**  
Less than 0.10 mm (0.0039 in)

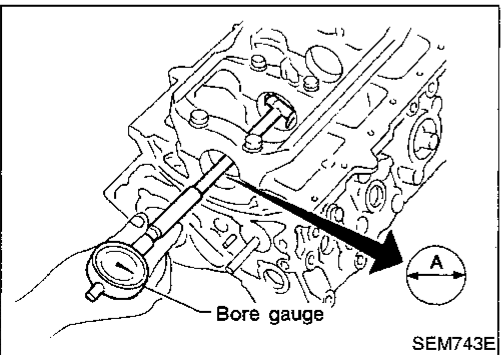


### BEARING CLEARANCE

- Use either of the following two methods, however, method "A" gives more reliable results and is preferable.

#### Method A (Using bore gauge & micrometer) Main bearing

1. Set main bearings in their proper positions on cylinder block and main bearing cap.
2. Install main bearing cap to cylinder block.
3. Measure inner diameter "A" of each main bearing.



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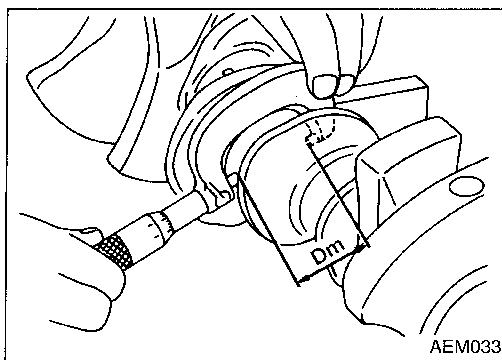
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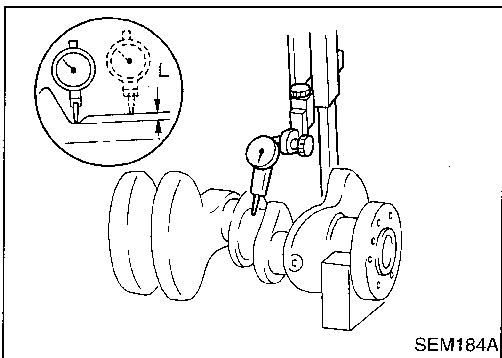
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# CYLINDER BLOCK

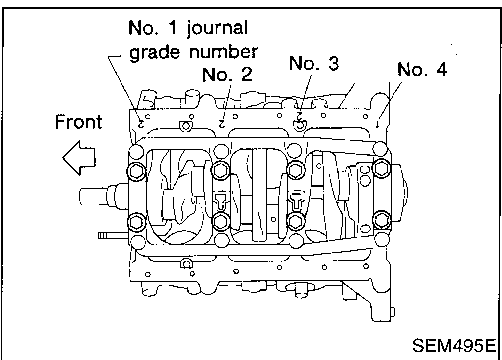
## Inspection (Cont'd)



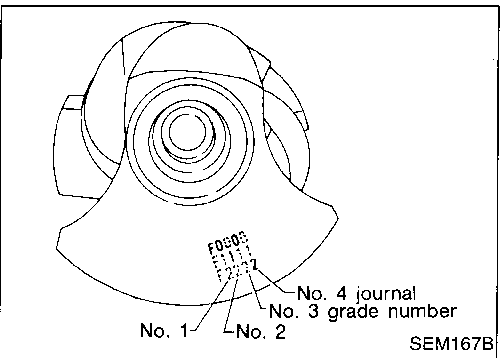
AEM033



SEM184A



SEM495E



SEM167B

4. Measure outer diameter "Dm" of each crankshaft main journal.  
**Main journal diameter "Dm":**  
**Refer to SDS (EM-61).**
5. Calculate main bearing clearance.  
**Main bearing clearance = A - Dm**  
**Standard**  
**0.028 - 0.055 mm (0.0011 - 0.0022 in)**  
**Limit**  
**0.090 mm (0.0035 in)**
  - If it exceeds the limit, replace bearing.

- If clearance cannot be adjusted using any standard bearing grade, grind crankshaft journal and use undersized bearing.
  - a. When grinding crankshaft journal, confirm that "L" dimension in fillet roll is more than the specified limit.  
**"L": 0.1 mm (0.004 in)**
  - b. Refer to SDS (EM-61) for grinding crankshaft and available service parts.

6. If crankshaft is reused, measure main bearing clearances and select thickness of main bearings.  
 If crankshaft is replaced with a new one, select thickness of main bearings as follows:
  - a. Grade number of each cylinder block main journal is punched on the respective cylinder block.

- b. Grade number of each crankshaft main journal is punched on the No. 1 counter weight of crankshaft.
- c. Select main bearing with suitable thickness according to the following table.

For example:

Cylinder block journal grade number: 1  
 Crankshaft journal grade number: 2  
 Main bearing grade number = 1 + 2  
 = 3

### Main bearing grade number:

		Cylinder block journal grade number		
		0	1 (I)	2 (II)
Crankshaft journal grade number	0	0	1	2
	1 (I)	1	2	3
	2 (II)	2	3	4

Grade numbers are punched in either Arabic or Roman numerals.

# CYLINDER BLOCK

## Inspection (Cont'd)

### Connecting rod bearing (Big end)

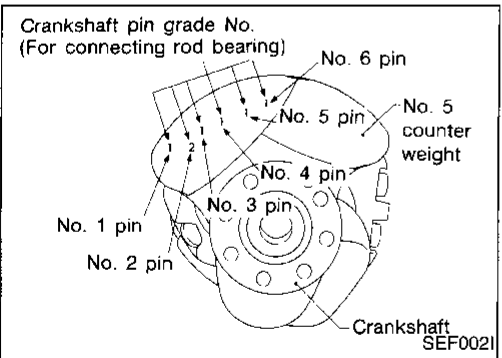
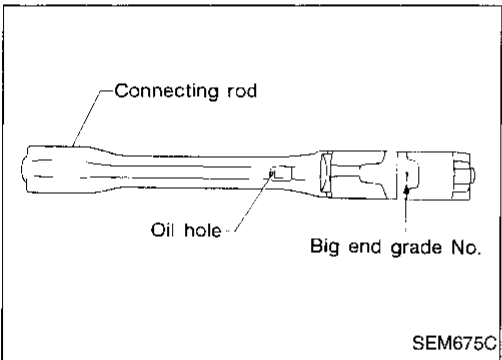
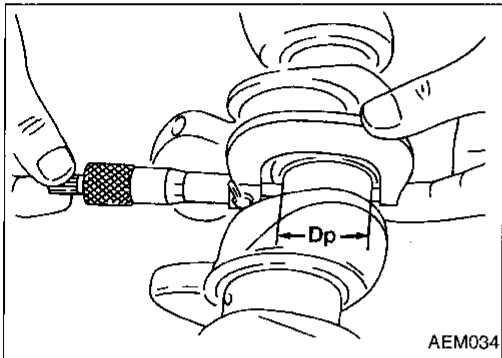
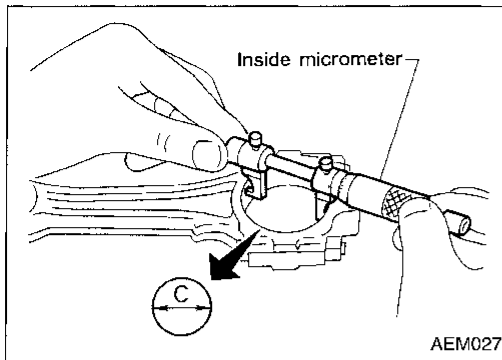
1. Install connecting rod bearing to connecting rod and cap.
2. Install connecting rod cap to connecting rod.

#### Tighten bolts to the specified torque.

3. Measure inner diameter "C" of each bearing.

#### Big end inner diameter "C":

53.000 - 53.013 mm (2.0866 - 2.0871 in)



4. Measure outer diameter "Dp" of each crankshaft pin journal.

#### Pin journal diameter "Dp":

Refer to SDS (EM-61).

5. Calculate connecting rod bearing clearance.

#### Connecting rod bearing clearance = C - Dp

##### Standard

0.028 - 0.048 mm (0.0011 - 0.0019 in)

##### Limit

0.090 mm (0.0035 in)

6. If it exceeds the limit, replace bearing.
7. If clearance cannot be adjusted within the standard of any bearing, grind crankshaft journal and use undersized bearing. Refer to step 5 of "BEARING CLEARANCE — Main bearing" (EM-50).
8. If crankshaft is replaced with a new one, select connecting rod bearing as follows:
  - a. Grade number of each connecting rod big end is punched on the respective connecting rod.

- b. Grade number of each crankshaft pin journal is punched on the No. 5 counter weight of crankshaft.

- c. Select connecting rod bearing with suitable thickness according to the following table.

#### For example:

Connecting rod big end grade number: 1

Crankshaft pin grade number: 2

Connecting rod bearing grade number = 1 + 2

= 3

### Connecting rod bearing grade number:

		Connecting rod big end grade number	
		0	1 (I)
Crankshaft pin grade number	0	0	1
	1 (I)	1	2
	2 (II)	2	3

Grade numbers are punched in either Arabic or Roman numerals.

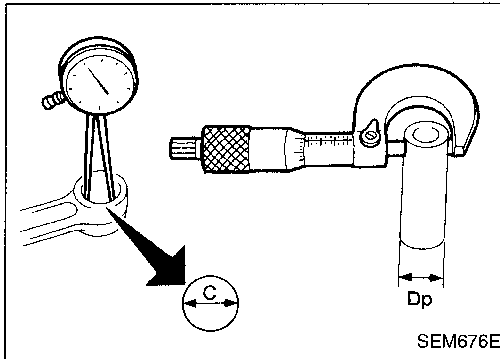
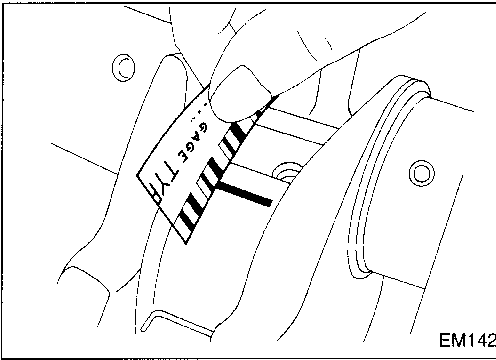
## CYLINDER BLOCK

### Inspection (Cont'd)

#### Method B (Using plastigage)

##### CAUTION:

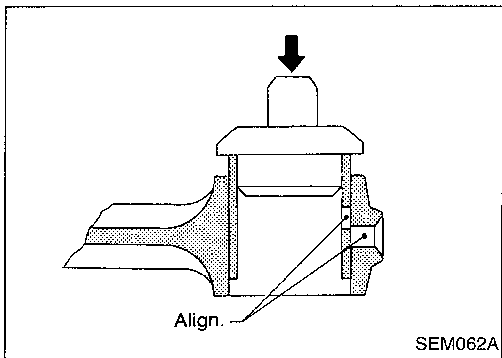
- Do not turn crankshaft or connecting rod while plastigage is being inserted.
- When bearing clearance exceeds the specified limit, ensure that the proper bearing has been installed. If incorrect bearing clearance exists, use a thicker or undersized main bearing to ensure specified clearance.



#### CONNECTING ROD BUSHING CLEARANCE (Small end)

1. Measure inner diameter "C" of bushing.  
**Small end bushing inner diameter "C":**  
22.000 - 22.012 mm (0.8661 - 0.8666 in)
2. Measure outer diameter "Dp" of piston pin.  
**Piston pin outer diameter "Dp":**  
21.989 - 22.001 mm (0.8657 - 0.8662 in)
3. Calculate connecting rod bushing clearance.  
Connecting rod bushing clearance = C - Dp  
**Standard: 0.005 - 0.017 mm (0.0002 - 0.0007 in)**  
**Limit: 0.023 mm (0.0009 in)**

If it exceeds the limit, replace connecting rod assembly or connecting rod bushing and/or piston set with pin.



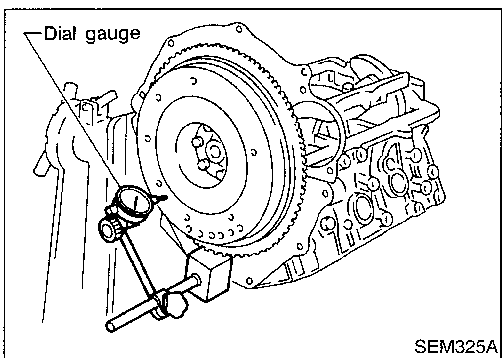
#### REPLACEMENT OF CONNECTING ROD BUSHING (Small end)

1. Drive in small end bushing until it is flush with end surface of rod.

##### Be sure to align the oil holes.

2. After driving in small end bushing, ream the bushing. This is to ensure the clearance between connecting rod bushing and piston pin is the specified value.

**Clearance between connecting rod bushing and piston pin: 0.005 - 0.017 mm (0.0002 - 0.0007 in)**



#### FLYWHEEL/DRIVE PLATE RUNOUT

##### Runout (Total indicator reading):

##### Flywheel (M/T model)

Less than 0.15 mm (0.0059 in)

##### Drive plate (A/T model)

Less than 0.15 mm (0.0059 in)

##### CAUTION:

- Be careful not to damage the ring gear teeth.
- Check the drive plate for deformation or cracks.

# CYLINDER BLOCK

## Inspection (Cont'd)

- Do not allow any magnetic materials to contact the ring gear teeth.
- Do not surface flywheel. Replace as necessary.

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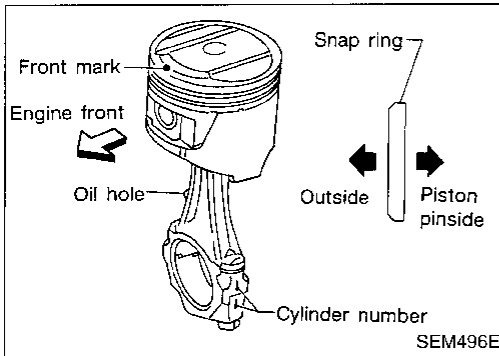
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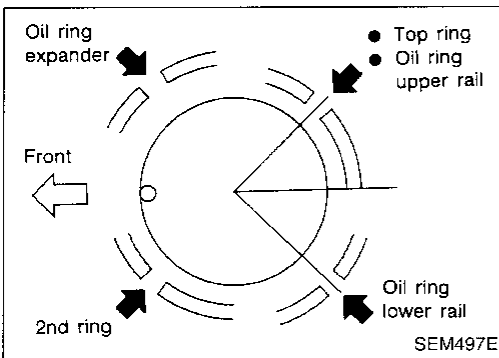
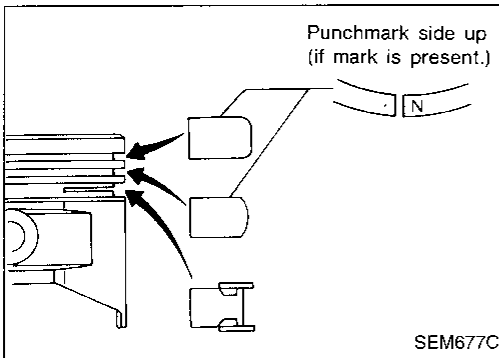
## Assembly

### PISTON

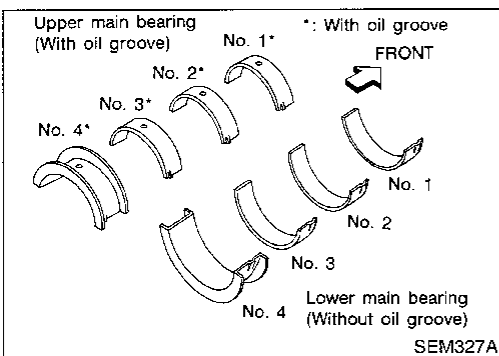
1. Install new snap ring on one side of piston pin hole.
2. Heat piston to 60 to 70°C (140 to 158°F) and assemble piston, piston pin, connecting rod and new snap ring.
  - Align the direction of piston and connecting rod.
  - Numbers stamped on connecting rod and cap correspond to each cylinder.
  - After assembly, make sure connecting rod swings smoothly.
3. Set piston rings as shown.

### CAUTION:

- When piston rings are not replaced, make sure that piston rings are mounted in their original positions.
- When replacing piston rings, if there is no punchmark, install with either side up.



- Align piston rings so that end gaps are positioned as shown in the figure.

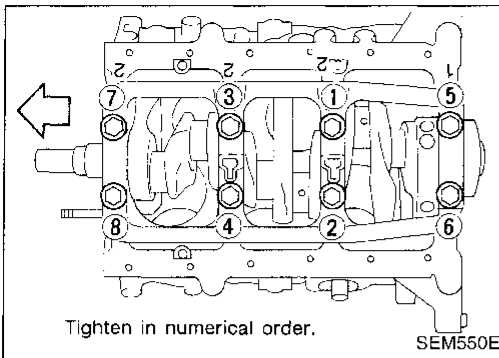


### CRANKSHAFT

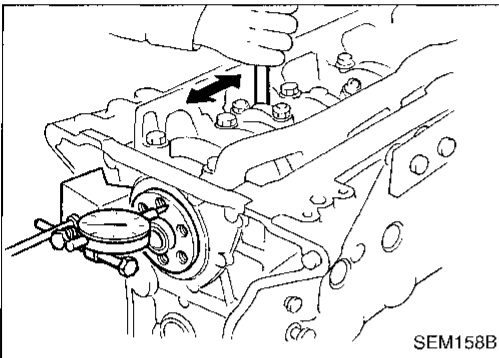
1. Set main bearings in their proper positions on cylinder block and main bearing cap.
  - Confirm that correct main bearings are used. Refer to "Inspection" (EM-49).
  - Apply engine oil to bearing surfaces.

## CYLINDER BLOCK

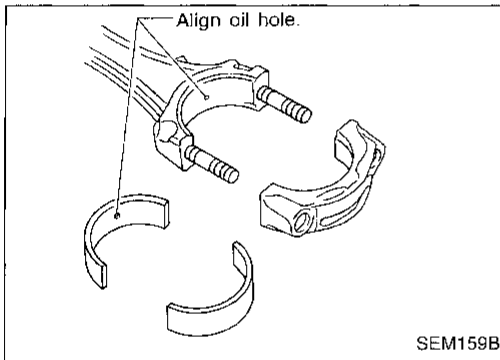
### Assembly (Cont'd)



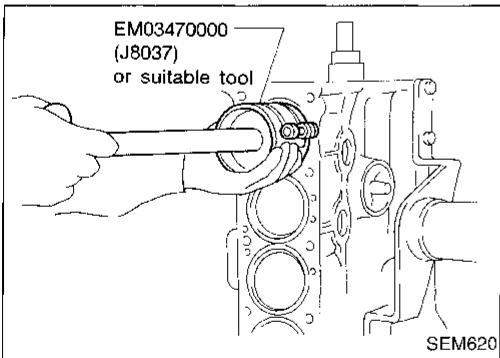
2. Install crankshaft and main bearing caps and tighten bolts to the specified torque.
  - Prior to tightening bearing cap bolts, shift crankshaft back and forth to properly seat the bearing cap.
  - Tighten bearing cap bolts gradually in two or three stages. Start with center bearing and move outward sequentially.
  - After securing bearing cap bolts, make sure crankshaft turns smoothly by hand.



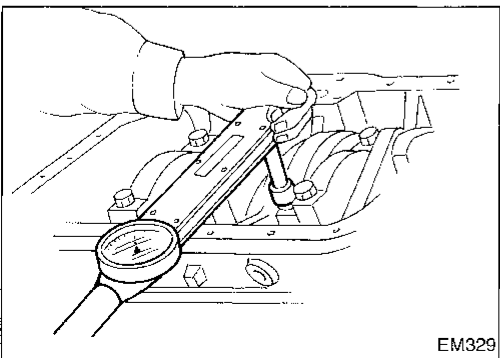
3. Measure crankshaft end play.  
**Crankshaft end play:**
  - Standard**  
0.05 - 0.18 mm (0.0020 - 0.0071 in)
  - Limit**  
0.30 mm (0.0118 in)If beyond the limit, replace bearing with a new one.



4. Install connecting rod bearings in connecting rods and connecting rod caps.
  - Confirm that correct bearings are used.**Refer to "Inspection" (EM-51).**
  - Install bearings so that oil hole in connecting rod aligns with oil hole of bearing.
  - Apply engine oil to bolt threads and bearing surfaces.



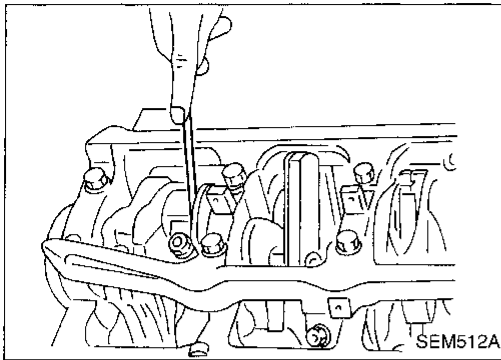
5. Install pistons with connecting rods.
  - a. Install them into corresponding cylinders with Tool.
    - Be careful not to scratch cylinder wall by connecting rod.
    - Arrange so that front mark on piston head faces toward front of engine.



- b. Install connecting rod bearing caps.
  - Lubricate threads and seat surfaces with new engine oil. Tighten connecting rod bearing cap nuts to the specified torque.
    - ☑: **Connecting rod bearing nut**
      - (1) Tighten to 14 to 16 N·m (1.4 to 1.6 kg-m, 10 to 12 ft-lb).
      - (2) Tighten to 59 to 65 N·m (6.0 to 6.6 kg-m, 43 to 48 ft-lb) or if you have an angle wrench, tighten bolts 60 to 65 degrees clockwise.

# CYLINDER BLOCK

## Assembly (Cont'd)



6. Measure connecting rod side clearance.

**Connecting rod side clearance:**

**Standard**

**0.20 - 0.35 mm (0.0079 - 0.0138 in)**

**Limit**

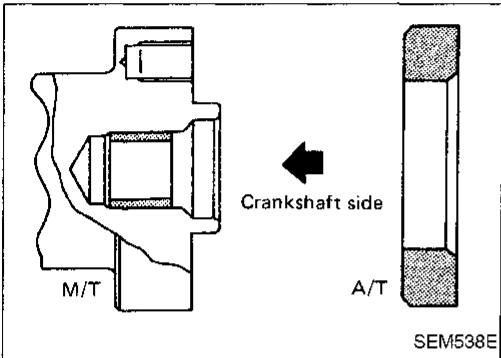
**0.40 mm (0.0157 in)**

If beyond the limit, replace connecting rod and/or crankshaft.

GI

MA

**EM**



## REPLACING PILOT BUSHING

1. Remove pilot bushing (M/T)/pilot converter (A/T) with suitable tool.
2. Install pilot bushing (M/T)/pilot converter (A/T).

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# SERVICE DATA AND SPECIFICATIONS (SDS)

## General Specifications

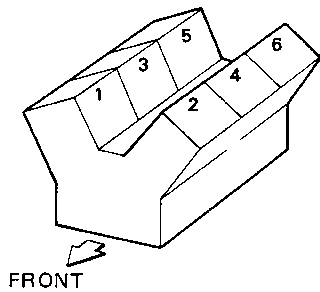
Cylinder arrangement	V-6	
Displacement	cm <sup>3</sup> (cu in)	2,960 (180.62)
Bore and stroke	mm (in)	87 x 83 (3.43 x 3.27)
Valve arrangement	DOHC	
Firing order	1-2-3-4-5-6	
Number of piston rings		
Compression	2	
Oil	1	
Number of main bearings	4	
Compression ratio (Non-turbocharger/Turbocharger)	10.5/8.5	

## COMPRESSION PRESSURE

Unit: kPa (kg/cm<sup>2</sup>, psi)/300 rpm

	Non-Turbocharger	Turbocharger
Compression pressure		
Standard	1,285 (13.1, 186)	1,177 (12.0, 171)
Minimum	981 (10.0, 142)	883 (9.0, 128)
Differential limit between cylinders	98 (1.0, 14)	

Cylinder number



SEM713A

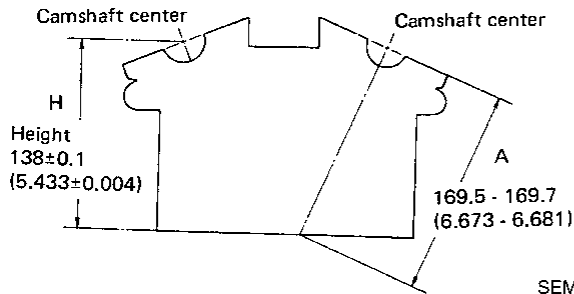


# SERVICE DATA AND SPECIFICATIONS (SDS)

## Inspection and Adjustment

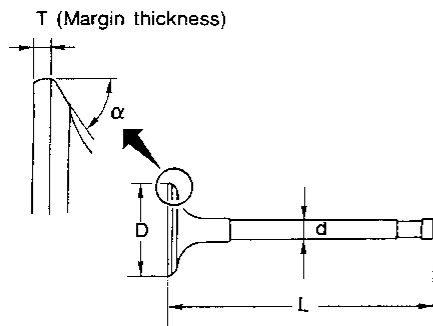
### CYLINDER HEAD

Unit: mm (in)		
	Standard	Limit
Head surface distortion	Less than 0.05 (0.0020)	0.1 (0.004)



### VALVE

Unit: mm (in)



Valve head diameter "D"	
Intake	33.95 - 34.25 (1.3366 - 1.3484)
Exhaust	29.45 - 29.75 (1.1594 - 1.1713)
Valve length "L"	
Intake	103.1 - 103.3 (4.059 - 4.067)
Exhaust	103.6 - 103.8 (4.079 - 4.087)
Valve stem diameter "d"	
Intake	5.965 - 5.980 (0.2348 - 0.2354)
Exhaust	5.945 - 5.960 (0.2341 - 0.2346)
Valve seat angle " $\alpha$ "	
Intake	45°15' - 45°45'
Exhaust	
Valve margin "T"	
Intake	1.15 - 1.45 (0.0453 - 0.0571)
Exhaust	1.35 - 1.65 (0.0531 - 0.0650)
Valve margin "T" limit	More than 0.5 (0.020)
Valve stem end surface grinding limit	Less than 0.2 (0.008)
Valve clearance	
Intake	0 (0)
Exhaust	0 (0)

### Valve spring

Free height	mm (in)	43.1 (1.697)
Pressure N (kg, lb) at height mm (in)	Standard	536.4 (54.7, 120.6) at 26.5 (1.043)
	Limit	452.79 (46.17, 101.80) at 26.5 (1.043)
Out-of-square	mm (in)	Less than 1.8 (0.071)

### Hydraulic lash adjuster (HLA)

Unit: mm (in)		
HLA outer diameter	30.955 - 30.965 (1.2187 - 1.2191)	
HLA guide inner diameter	31.000 - 31.020 (1.2205 - 1.2213)	
Clearance between HLA and HLA guide	0.035 - 0.065 (0.0014 - 0.0026)	

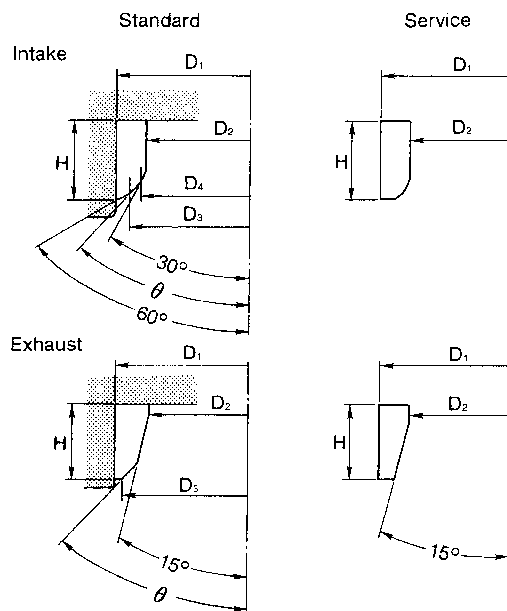
### Valve guide

Unit: mm (in)		
	Standard	Service
Valve guide		
Outer diameter	10.023 - 10.034 (0.3946 - 0.3950)	10.223 - 10.234 (0.4025 - 0.4029)
Valve guide		
Inner diameter (Finished size)	6.000 - 6.018 (0.2362 - 0.2369)	
Cylinder head valve guide hole diameter	9.975 - 9.996 (0.3927 - 0.3935)	10.175 - 10.196 (0.4006 - 0.4014)
Interference fit of valve guide	0.027 - 0.059 (0.0011 - 0.0023)	
	Standard	Max. tolerance
Stem to guide clearance	Intake	0.10 (0.0039)
	Exhaust	
Valve deflection limit	—	0.20 (0.0079)

# SERVICE DATA AND SPECIFICATIONS (SDS)

## Inspection and Adjustment (Cont'd)

### VALVE SEAT



SEM529C

Unit: mm (in)

		Standard	Service*
Cylinder head seat recess diameter ( $D_1$ )	In.	36.000 - 36.016 (1.4173 - 1.4179)	36.500 - 36.516 (1.4370 - 1.4376)
	Ex.	31.500 - 31.516 (1.2402 - 1.2408)	32.000 - 32.016 (1.2598 - 1.2605)
Valve seat interference fit	In.	0.081 - 0.113 (0.0032 - 0.0044)	
	Ex.	0.064 - 0.096 (0.0025 - 0.0038)	
Valve seat outer diameter ( $D_1$ )	In.	36.097 - 36.113 (1.4211 - 1.4218)	36.597 - 36.613 (1.4408 - 1.4415)
	Ex.	31.580 - 31.596 (1.2433 - 1.2439)	32.080 - 32.096 (1.2630 - 1.2636)
Valve seat inner diameter ( $D_2$ )	In.	29.85 - 30.15 (1.1752 - 1.1870)	
	Ex.	24.35 - 24.65 (0.9587 - 0.9705)	
Height (H)	In.	5.9 - 6.0 (0.232 - 0.236)	5.35 - 5.45 (0.2106 - 0.2146)
	Ex.	5.9 - 6.0 (0.232 - 0.236)	5.9 - 6.0 (0.232 - 0.236)
Face angle ( $\theta$ )	In.	45°	
	Ex.	45°	
Face inner diameter ( $D_4$ )	In.	31.5 (1.240)	*: Valve seat surface must be corrected to specified value.
Face outer diameter ( $D_3$ )	In.	33.6 - 33.8 (1.323 - 1.331)	
	Ex.	28.9 - 29.1 (1.138 - 1.146)	

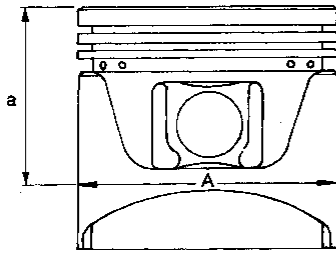
# SERVICE DATA AND SPECIFICATIONS (SDS)

## Inspection and Adjustment (Cont'd)

### PISTON, PISTON RING AND PISTON PIN

#### Available piston

Unit: mm (in)



SEM740D

	Non-turbocharger	Turbocharger
<b>Piston skirt diameter "A"</b>		
Standard		
Grade No. 1	86.975 - 86.985 (3.4242 - 3.4246)	86.965 - 86.975 (3.4238 - 3.4242)
Grade No. 2	86.985 - 86.995 (3.4246 - 3.4250)	86.975 - 86.985 (3.4242 - 3.4246)
Grade No. 3	86.995 - 87.005 (3.4250 - 3.4254)	86.985 - 86.995 (3.4246 - 3.4234)
0.25 (0.0098) oversize (Service)	87.225 - 87.275 (3.4340 - 3.4360)	87.215 - 87.265 (3.4337 - 3.4356)
0.50 (0.0197) oversize (Service)	87.475 - 87.525 (3.4439 - 3.4459)	87.465 - 87.515 (3.4435 - 3.4455)
"a" dimension	48.0 (1.890)	
Piston pin hole diameter	21.987 - 21.999 (0.8656 - 0.8661)	
Piston clearance to cylinder block	0.015 - 0.035 (0.0006 - 0.0014)	0.025 - 0.045 (0.0010 - 0.0018)

### Piston ring

Unit: mm (in)

	Standard	Limit
<b>Side clearance</b>		
Top	0.040 - 0.073 (0.0016 - 0.0029)	0.1 (0.004)
2nd	0.030 - 0.063 (0.0012 - 0.0025)	
Oil	0.015 - 0.185 (0.0006 - 0.0073)	0.2 (0.008)
<b>End gap</b>		
Top	0.21 - 0.40 (0.0083 - 0.0157)	1.0 (0.039)
2nd	0.50 - 0.76 (0.0197 - 0.0299)	
Oil (rail ring)	0.20 - 0.76 (0.0079 - 0.0299)	

### Piston pin

Unit: mm (in)

Piston pin outer diameter "Dp"	21.989 - 22.001 (0.8657 - 0.8662)
Interference fit of piston pin to piston	-0.004 to 0 (-0.0002 to 0)
Piston pin to connecting rod bushing clearance	0.005 - 0.017 (0.0002 - 0.0007)

\* Values measured at ambient temperature of 20°C (68°F)

### CONNECTING ROD

Unit: mm (in)

Center distance	154.1 - 154.2 (6.067 - 6.071)
Bend [per 100 (3.94)]	
Limit	0.15 (0.0059)
Torsion [per 100 (3.94)]	
Limit	0.3 (0.012)
Piston pin bushing inner diameter* "C"	22.000 - 22.012 (0.8661 - 0.8666)
Connecting rod big end inner diameter "C"	53.000 - 53.013 (2.0866 - 2.0871)
Side clearance	
Standard	0.20 - 0.35 (0.0079 - 0.0138)
Limit	0.40 (0.0157)

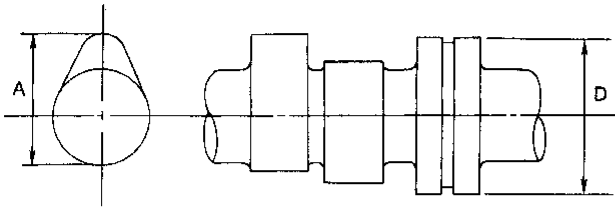
\* After installing in connecting rod

# SERVICE DATA AND SPECIFICATIONS (SDS)

## Inspection and Adjustment (Cont'd)

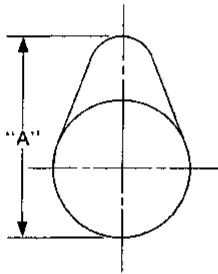
### CAMSHAFT AND CAMSHAFT BEARING

Unit: mm (in)



SEM568A

	Standard	Max. tolerance
Camshaft journal to bearing clearance	0.045 - 0.086 (0.0018 - 0.0034)	0.15 (0.0059)
Inner diameter of camshaft bearing	28.000 - 28.021 (1.1024 - 1.1032)	—
Outer diameter of camshaft journal	27.935 - 27.955 (1.0998 - 1.1006)	—
Camshaft runout [TIR*]	Less than 0.04 (0.0016)	0.1 (0.004)
Camshaft end play	0.03 - 0.08 (0.0012 - 0.0031)	—

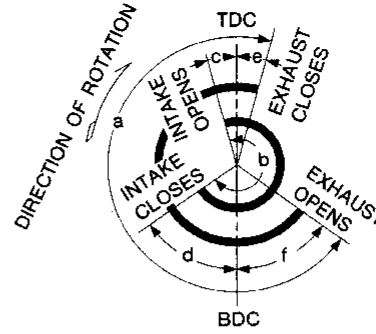


EM671

Cam height "A"	
Intake	39.605 - 39.795 (1.5592 - 1.5667)
Exhaust	40.405 - 40.595 (1.5907 - 1.5982)
Wear limit of cam height	0.15 (0.0059)

\*Total indicator reading

Valve timing



EM120A  
Unit: degree

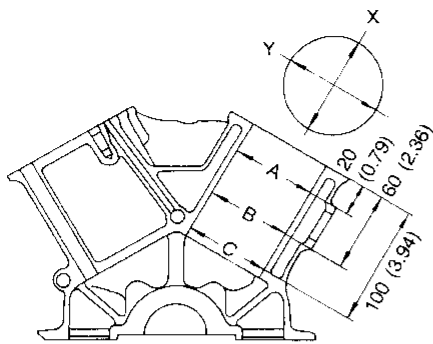
	a	b	c	d	e	f
Non-turbocharger	240	232	3	49	5	55
Turbocharger	240	232	3	49	1	59

# SERVICE DATA AND SPECIFICATIONS (SDS)

## Inspection and Adjustment (Cont'd)

### CYLINDER BLOCK

Unit: mm (in)



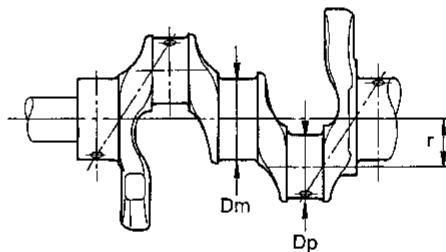
SEM733E

Surface flatness	
Standard	Less than 0.03 (0.0012)
Limit	0.10 (0.0039)
Cylinder bore	
Inner diameter	
Standard	
Grade No. 1	87.000 - 87.010 (3.4252 - 3.4256)
Grade No. 2	87.010 - 87.020 (3.4256 - 3.4260)
Grade No. 3	87.020 - 87.030 (3.4260 - 3.4264)
Wear limit	0.20 (0.0079)
Out-of-round (X - Y)	Less than 0.015 (0.0006)
Taper (A - B - C)	Less than 0.015 (0.0006)
Main journal inner diameter	
Grade No. 0	66.645 - 66.654 (2.6238 - 2.6242)
Grade No. 1	66.654 - 66.663 (2.6242 - 2.6245)
Grade No. 2	66.663 - 66.672 (2.6245 - 2.6249)
Difference in inner diameter between cylinders	
Standard	Less than 0.05 (0.0020)

### CRANKSHAFT

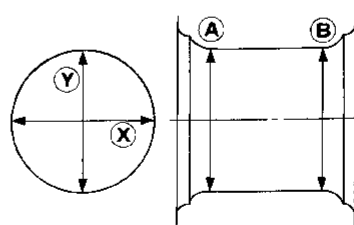
Unit: mm (in)

Main journal dia. "Dm"	
Grade No. 0	62.967 - 62.975 (2.4790 - 2.4793)
Grade No. 1	62.959 - 62.967 (2.4787 - 2.4790)
Grade No. 2	62.951 - 62.959 (2.4784 - 2.4787)
Pin journal dia. "Dp"	
Grade No. 0	49.968 - 49.974 (1.9672 - 1.9675)
Grade No. 1	49.962 - 49.968 (1.9670 - 1.9672)
Grade No. 2	49.955 - 49.962 (1.9667 - 1.9670)
Center distance "r"	41.47 - 41.53 (1.6327 - 1.6350)
Out-of-round (X - Y)	
Standard	Less than 0.005 (0.0002)
Limit	0.02 (0.0008)
Taper (A - B)	
Standard	Less than 0.005 (0.0002)
Limit	0.02 (0.0008)
Runout [TIR]	
Standard	Less than 0.10 (0.0039)
Free end play	
Standard	0.05 - 0.18 (0.0020 - 0.0071)
Limit	0.30 (0.0118)



SEM645

Out-of-round (X - Y)  
Taper (A - B)

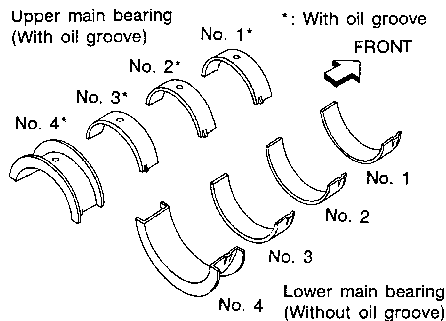


EM715

# SERVICE DATA AND SPECIFICATIONS (SDS)

## Inspection and Adjustment (Cont'd)

### AVAILABLE MAIN BEARING



SEM327A

### No. 4 main bearing

Grade number	Thickness "T" mm (in)	Identification color
0	1.817 - 1.821 (0.0715 - 0.0717)	Black
1	1.821 - 1.825 (0.0717 - 0.0719)	Brown
2	1.825 - 1.829 (0.0719 - 0.0720)	Green
3	1.829 - 1.833 (0.0720 - 0.0722)	Yellow
4	1.833 - 1.837 (0.0722 - 0.0723)	Blue

### No. 1 main bearing

Grade number	Thickness "T" mm (in)	Width "W" mm (in)	Identification color
0	1.817 - 1.821 (0.0715 - 0.0717)		Black
1	1.821 - 1.825 (0.0717 - 0.0719)		Brown
2	1.825 - 1.829 (0.0719 - 0.0720)	22.4 - 22.6 (0.882 - 0.890)	Green
3	1.829 - 1.833 (0.0720 - 0.0722)		Yellow
4	1.833 - 1.837 (0.0722 - 0.0723)		Blue

### No. 2 and 3 main bearing

Grade number	Thickness "T" mm (in)	Width "W" mm (in)	Identification color
0	1.817 - 1.821 (0.0715 - 0.0717)		Black
1	1.821 - 1.825 (0.0717 - 0.0719)		Brown
2	1.825 - 1.829 (0.0719 - 0.0720)	18.9 - 19.1 (0.744 - 0.752)	Green
3	1.829 - 1.833 (0.0720 - 0.0722)		Yellow
4	1.833 - 1.837 (0.0722 - 0.0723)		Blue

### Undersize

Unit: mm (in)

	Thickness	Main journal diameter "Dm"
0.25 (0.0098)	1.948 - 1.956 (0.0767 - 0.0770)	Grind so that bearing clearance is the specified value.

### AVAILABLE CONNECTING ROD BEARING

#### Connecting rod bearing

Grade number	Thickness "T" mm (in)	Identification color
0	1.496 - 1.499 (0.0589 - 0.0590)	No color
1	1.499 - 1.502 (0.0590 - 0.0591)	Brown
2	1.502 - 1.505 (0.0591 - 0.0593)	Green
3	1.505 - 1.508 (0.0593 - 0.0594)	Yellow

### Undersize

Unit: mm (in)

	Thickness	Crank pin journal diameter "Dp"
0.08 (0.0031)	1.540 - 1.548 (0.0606 - 0.0609)	Grind so that bearing clearance is the specified value.
0.12 (0.0047)	1.560 - 1.568 (0.0614 - 0.0617)	
0.25 (0.0098)	1.625 - 1.633 (0.0640 - 0.0643)	

# SERVICE DATA AND SPECIFICATIONS (SDS)

## Inspection and Adjustment (Cont'd)

### TURBOCHARGER

	Unit: mm (in)
<hr/>	
Rotor shaft	
Runout [TIR]*	0.056 - 0.127 (0.0022 - 0.0050)
End play	0.013 - 0.096 (0.0005 - 0.0038)
<hr/>	
*Total indicator reading	

### MISCELLANEOUS COMPONENTS

	Unit: mm (in)
<hr/>	
Flywheel or Drive plate	
Runout [TIR]*	Less than 0.15 (0.0059)
<hr/>	
*Total indicator reading	

### Bearing clearance

	Unit: mm (in)
<hr/>	
Main bearing clearance	
Standard	0.028 - 0.055 (0.0011 - 0.0022)
Limit	0.090 (0.0035)
<hr/>	
Connecting rod bearing clearance	
Standard	0.028 - 0.048 (0.0011 - 0.0019)
Limit	0.090 (0.0035)
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