

WSM

WORKSHOP MANUAL GASOLINE,LPG ENGINE

**WG1605-G-E3, WG1605-L-E3,
WG1605-GL-E3**

Kubota

TO THE READER

This Workshop Manual tells the servicing personnel about the mechanism, servicing and maintenance of the WG1605-G-E3, WG1605-L-E3 and WG1605-GL-E3. It contains 4 parts: "**Information**", "**General**", "**Mechanism**" and "**Servicing**".

■ **Information**

This section contains information below.

- Safety First
- Specification
- Important Items of Exhaust Emission Regulation
- Performance Curve
- Dimension
- Wiring Diagram

■ **General**

This section contains information below.

- Engine Identification
- General Precautions
- Maintenance Check List
- Check and Maintenance
- Special Tools

■ **Mechanism**

This section contains information on the structure and the function of the unit. Before you continue with the subsequent sections, make sure that you read this section.

■ **Servicing**

This section contains information below.

- Troubleshooting
- Servicing Specifications
- Tightening Torques
- Checking, Disassembling and Servicing

All illustrations, photographs and specifications contained in this manual are of the newest information available at the time of publication.

KUBOTA reserves the right to change all information at any time without notice.

Since this manual includes many models, information or illustrations and photographs can show more than one model.

January, 2012

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I INFORMATION

INFORMATION

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1. SAFETY FIRST

SAFETY FIRST

- This symbol, the industry's "Safety Alert Symbol", is used throughout this manual and on labels on the machine itself to warn of the possibility of personal injury. Read these instructions carefully.
- It is essential that you read the instructions and safety regulations before you attempt to repair or use this unit.

DANGER

- Indicates an imminently hazardous situation which, if not avoided, will result in death or serious injury.

WARNING

- Indicates a potentially hazardous situation which, if not avoided, could result in death or serious injury.

CAUTION

- Indicates a potentially hazardous situation which, if not avoided, may result in minor or moderate injury.

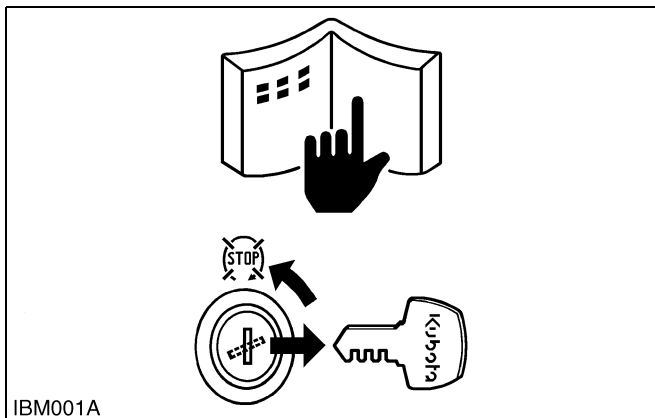
■ IMPORTANT

- Indicates that equipment or property damage could result if instructions are not followed.

■ NOTE

- Gives helpful information.

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BEFORE YOU START SERVICE

- Read all instructions and safety instructions in this manual and on your engine safety decals.
- Clean the work area and engine.
- Park the machine on a stable and level ground.
- Let the temperature of the engine decrease before you start a job.
- Stop the engine, then remove the key.
- Disconnect the battery negative cable.
- Hang a "DO NOT OPERATE" tag in the operator station.

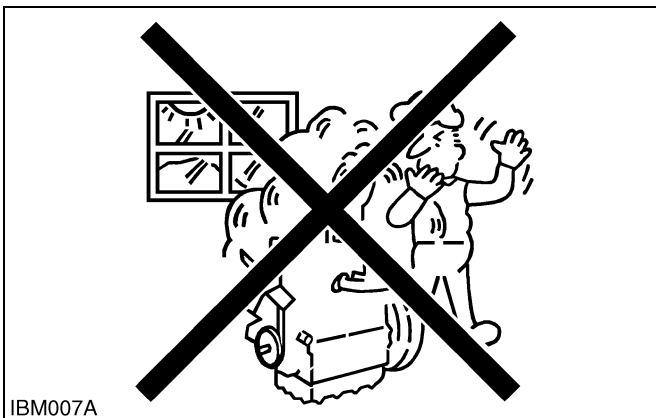
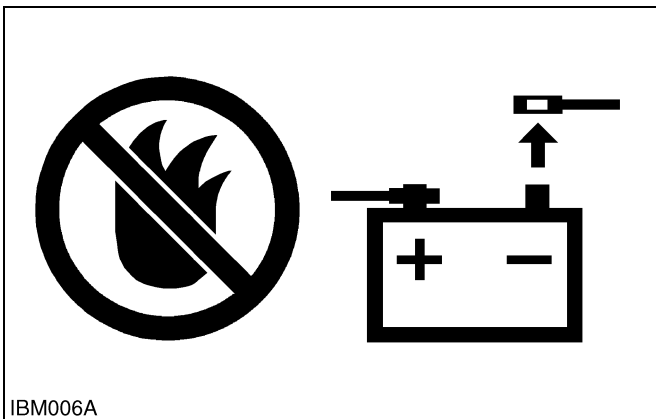
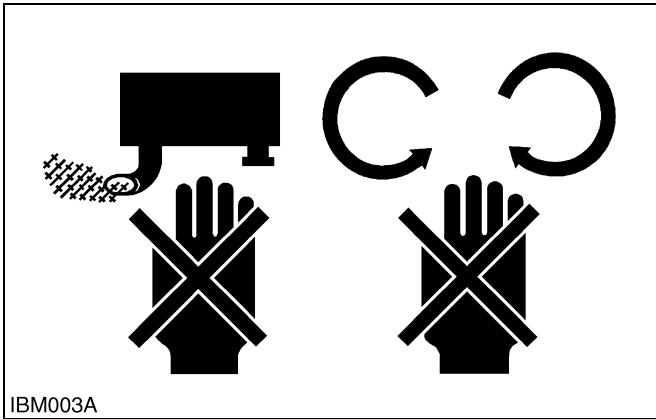
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START SAFELY

- Do not do the procedures below when you start the engine.
 - short across starter terminals
 - bypass the safety start switch
- Do not make unauthorized modifications to the engine. This can cause damage and decrease the engine life.

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OPERATE SAFELY

- Do not use the machine after you consume alcohol or medication or when you are tired.
- Put on applicable clothing and safety equipment.
- Use applicable tools only. Do not use alternative tools or parts.
- When 2 or more persons do servicing, make sure that you do it safely.
- Do not touch the hot parts or parts that turn when the engine operates.
- Do not remove the radiator cap when the engine operates, or immediately after it stops. If not, hot water can spout out from the radiator. Only remove the radiator cap when it is at a sufficiently low temperature to touch with bare hands. Slowly loosen the cap to release the pressure before you remove it fully.
- Released fluid (fuel or hydraulic oil) under pressure can cause damage to the skin and cause serious injury. Release the pressure before you disconnect hydraulic or fuel lines. Tighten all connections before you apply the pressure.
- Do not open a fuel system under high pressure. The fluid under high pressure that stays in fuel lines can cause serious injury. Do not disconnect or repair the fuel lines, sensors, or any other components between the fuel pump and injectors on engines with a common rail fuel system under high pressure.
- Put on an applicable ear protective device (earmuffs or earplugs) to prevent injury against loud noises.

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PREVENT A FIRE

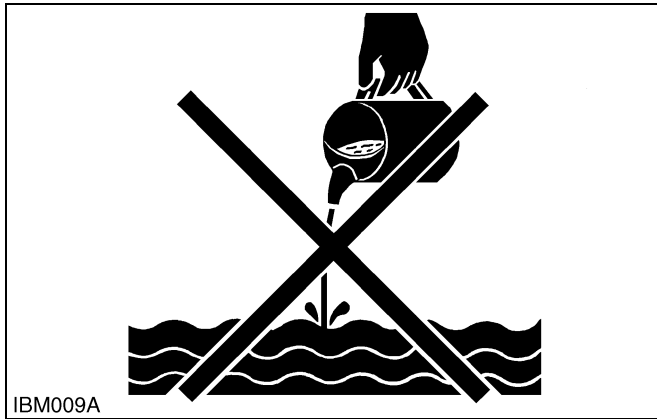
- Fuel is very flammable and explosive under some conditions. Do not smoke or let flames or sparks in your work area.
- To prevent sparks from an accidental short circuit, always disconnect the battery negative cable first and connect it last.
- The battery gas can cause an explosion. Keep the sparks and open flame away from the top of battery, especially when you charge the battery.
- Make sure that you do not spill fuel on the engine.

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KEEP A GOOD AIRFLOW IN THE WORK AREA

- If the engine is in operation, make sure that the area has good airflow. Do not operate the engine in a closed area. The exhaust gas contains poisonous carbon monoxide.

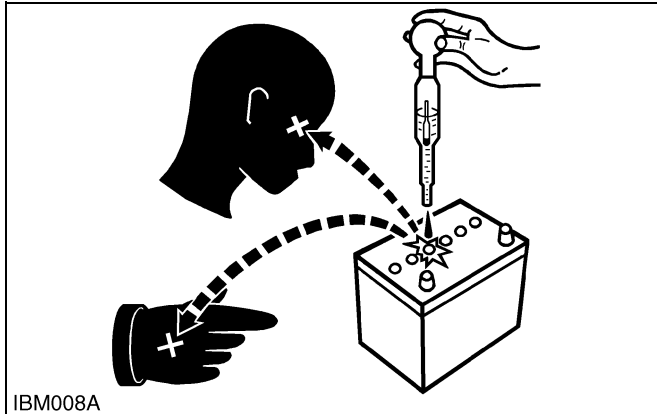
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DISCARD FLUIDS CORRECTLY

- Do not discard fluids on the ground, down the drain, into a stream, pond, or lake. Obey related environmental protection regulations when you discard oil, fuel, coolant, electrolyte and other dangerous waste.

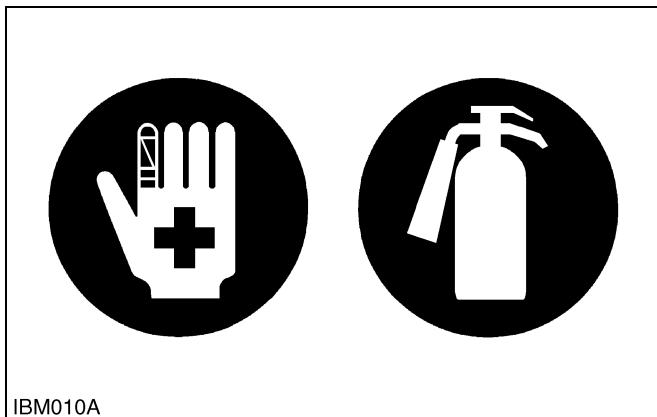
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PREVENT ACID BURNS

- Keep electrolyte away from your eyes, hands and clothing. Sulfuric acid in battery electrolyte is poisonous and it can burn your skin and clothing and cause blindness. If you spill electrolyte on yourself, clean yourself with water, and get medical aid immediately.

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PREPARE FOR EMERGENCIES

- Keep a first aid kit and fire extinguisher ready at all times.
- Keep the emergency contact telephone numbers near your telephone at all times.

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2. SPECIFICATIONS

Model	WG1605-G-E3	WG1605-L-E3
	Gasoline fuel	LPG fuel
Number of Cylinder	4	
Type	Vertical, water cooled, 4-cycle Gasoline engine	Vertical, water cooled, 4-cycle LPG engine
Bore × Stroke	79.0 × 78.4 mm (3.11 × 3.09 in.)	
Total Displacement	1.537 L (93.79 cu.in.)	
SAE Gross Intermittent	42.5 kW (57.0 HP) / 3600 min ⁻¹ (rpm) 37.0 kW (49.6 HP) / 3000 min ⁻¹ (rpm)	41.0 kW (55.0 HP) / 3600 min ⁻¹ (rpm) 36.0 kW (48.3 HP) / 3000 min ⁻¹ (rpm)
ISO / SAE Net Intermittent	38.5 kW (51.6 HP) / 3600 min ⁻¹ (rpm) 33.5 kW (44.9 HP) / 3000 min ⁻¹ (rpm)	37.1 kW (49.8 HP) / 3600 min ⁻¹ (rpm) 32.5 kW (43.6 HP) / 3000 min ⁻¹ (rpm)
ISO Net Continuous	30.8 kW (41.3 HP) / 3600 min ⁻¹ (rpm) 26.8 kW (35.9 HP) / 3000 min ⁻¹ (rpm)	29.7 kW (39.8 HP) / 3600 min ⁻¹ (rpm) 26.1 kW (35.0 HP) / 3000 min ⁻¹ (rpm)
Maximum Bare Speed	3575 to 3625 min ⁻¹ (rpm) 2975 to 3025 min ⁻¹ (rpm)	
Minimum Bare Idling Speed	725 to 775 min ⁻¹ (rpm)	
Cylinder Head	Overhead-Valve	
Ignition System	Full Transistor Battery Ignition Type	
Governor	Electronic Governor	
Direction of Rotation	Counter-Clockwise (Viewed from Flywheel Side)	
Spark Plug Type / Spark Plug Gap	NGK IFR6F8DN 0.70 to 0.80 mm (0.028 to 0.031 in.)	
Ignition Timing	0.45 rad (26 °) before T.D.C. / 3000 min ⁻¹ (rpm), 3600 min ⁻¹ (rpm) 0.17 rad (10 °) before T.D.C. / 750 min ⁻¹ (rpm), 800 min ⁻¹ (rpm)	0.35 rad (20 °) before T.D.C. / 3000 min ⁻¹ (rpm), 3600 min ⁻¹ (rpm) 0.17 rad (10 °) before T.D.C. / 750 min ⁻¹ (rpm), 800 min ⁻¹ (rpm)
Firing Order	1-3-4-2	
Compression Ratio	9.1: 1	
Lubricating System	Forced Lubrication by Trochoid Pump	
Oil Pressure Indication	Electrical Type Switch	
Lubricating Filter	Full Flow Paper Filter (Cartridge Type)	
Cooling System	Pressurized Radiator, Forced Circulation with Water Pump	
Starting System	Electric Starting with Starter	
Starting Motor	12 V, 1.0 kW	
Battery	12 V, 52 AH or Equivalent	
Charging Alternator	12 V, 480 W, 720 W	
Fuel	*Unleaded Automobile Gasoline	Commercial LPG
Lubricating Oil	Better than SL Class (API) SAE 10W-30	
Lubricating Oil Capacity	6.0 L (1.6 U.S.gals)	
Catalytic Muffler / Converter	Three Way Catalyst	
Weight (Dry)	119 kg (262 lbs)	120 kg (265 lbs)
Application	General Power Source	

*The specification described above is of the standard engine of each model.

*Conversion Formula: HP = 0.746 kW, PS = 0.7355 kW

*KUBOTA RECOMMENDED LPG FUEL SPECIFICATIONS

- Commercial Propane gas only.
- Equivalent to Propanes H-D-5 of GPA* standards.

(vol %)

C ₃ H ₈	C ₃ H ₆	C ₄ H ₁₀	Others
≥ 90 %	≤ 5 %	≤ 2.5 %	–

*GPA means Gas Processors Association (U.S.A.)

Model	WG1605-GL-E3	
	Gasoline fuel	LPG fuel
Number of Cylinder	4	
Type	Vertical, water cooled, 4-cycle Dual Fuel (Gasoline / LPG) engine	
Bore × Stroke	79.0 × 78.4 mm (3.11 × 3.09 in.)	
Total Displacement	1.537 L (93.79 cu.in.)	
SAE Gross Intermittent	42.5 kW (57.0 HP) / 3600 min ⁻¹ (rpm) 37.0 kW (49.6 HP) / 3000 min ⁻¹ (rpm)	41.0 kW (55.0 HP) / 3600 min ⁻¹ (rpm) 36.0 kW (48.3 HP) / 3000 min ⁻¹ (rpm)
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Maximum Bare Speed	3575 to 3625 min ⁻¹ (rpm) 2975 to 3025 min ⁻¹ (rpm)	
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Cylinder Head	Overhead-Valve	
Ignition System	Full Transistor Battery Ignition Type	
Governor	Electronic Governor	
Direction of Rotation	Counter-Clockwise (Viewed from Flywheel Side)	
Spark Plug Type / Spark Plug Gap	NGK IFR6F8DN 0.70 to 0.80 mm (0.028 to 0.031 in.)	
Ignition Timing	0.45 rad (26 °) before T.D.C. / 3000 min ⁻¹ (rpm), 3600 min ⁻¹ (rpm) 0.17 rad (10 °) before T.D.C. / 750 min ⁻¹ (rpm), 800 min ⁻¹ (rpm)	0.35 rad (20 °) before T.D.C. / 3000 min ⁻¹ (rpm), 3600 min ⁻¹ (rpm) 0.17 rad (10 °) before T.D.C. / 750 min ⁻¹ (rpm), 800 min ⁻¹ (rpm)
Firing Order	1-3-4-2	
Compression Ratio	9.1: 1	
Lubricating System	Forced Lubrication by Trochoid Pump	
Oil Pressure Indication	Electrical Type Switch	
Lubricating Filter	Full Flow Paper Filter (Cartridge Type)	
Cooling System	Pressurized Radiator, Forced Circulation with Water Pump	
Starting System	Electric Starting with Starter	
Starting Motor	12 V, 1.0 kW	
Battery	12 V, 52 AH or Equivalent	
Charging Alternator	12 V, 480 W, 720 W	
Fuel	*Unleaded Automobile Gasoline	Commercial LPG
Lubricating Oil	Better than SL Class (API) SAE 10W-30	
Lubricating Oil Capacity	6.0 L (1.6 U.S.gals)	
Catalytic Muffler / Converter	Three Way Catalyst	
Weight (Dry)	121 kg (267 lbs)	
Application	General Power Source	

*The specification described above is of the standard engine of each model.

*Conversion Formula: HP = 0.746 kW, PS = 0.7355 kW

*KUBOTA RECOMMENDED LPG FUEL SPECIFICATIONS

- Commercial Propane gas only.
- Equivalent to Propanes H-D-5 of GPA* standards.

(vol %)

C ₃ H ₈	C ₃ H ₆	C ₄ H ₁₀	Others
≥ 90 %	≤ 5 %	≤ 2.5 %	—

*GPA means Gas Processors Association (U.S.A.)

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3. IMPORTANT ITEMS OF EXHAUST EMISSION REGULATION

WG1605 is available and unavailable in those countries.

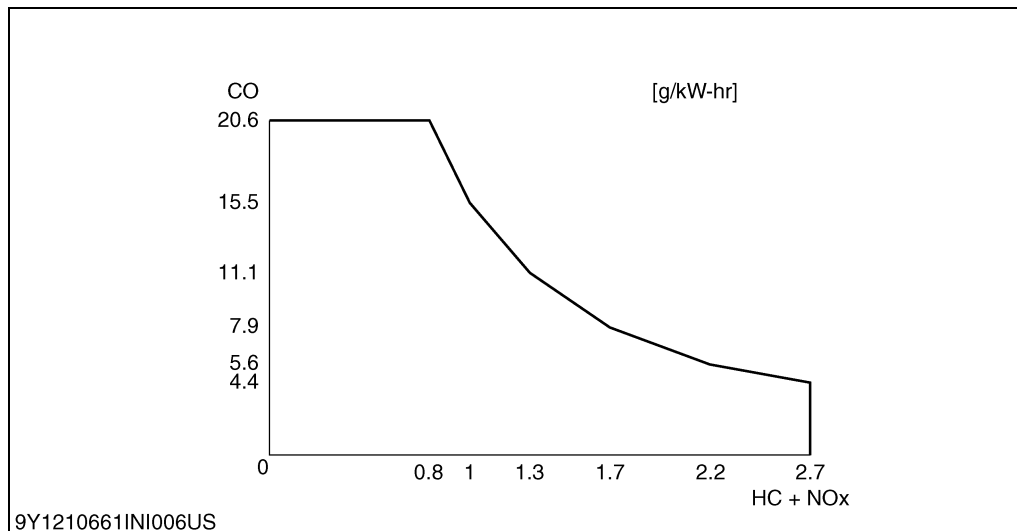
kW, Disp.	Model	Type	North America	Europe	Japan
19 < P, 1.0 < L	WG1605-G-E3, WG1605-L-E3, WG1605-GL-E3	E3	Available	Available	Non-available

Current and future emission regulations.

Countries		kW, disp.	HC+NO _x /CO (g/kWh)							
			2009	2010	2011	2012	2013	2014	2015	2016
USA	CARB	19 < P < 560 1.0 < L	2.7/4.4* **	0.8/20.6*						
	EPA	19 ≤ P ≤ 560 1.0 < L	2.7/4.4* **							
Canada		19 < P	None							
Japan		19 ≤ P < 560	HC/0.6 g/kWh, NO _x /0.6 g/kWh, CO/20 g/kWh							
EU		19 < P	None							

- *: with evaporative emission regulation
- **: See figure below

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9Y1210661INI006US

9Y1210661INI0017US0

[1] THREE-WAY CATALYST

A three-way catalyst is a catalyst that oxidizes HC to CO₂ and H₂O and also CO to CO₂ respectively and at the same time reduces NO_x to N₂ near the stoichiometric ratio.

The main basic component of an exhaust gas purification system that uses a three-way catalyst is feedback control of air-fuel ratio by means of an O₂ sensor for the purpose of maximizing the emission purification efficiency characteristic with reference to the intake air-fuel ratio of the three-way catalyst.

9Y1210661INI0004US0

[2] VAPORIZER AND LOCK OFF VALVE (WG1605-L-E3, WG1605-GL-E3)

Vaporizer requires a normally-closed electrically controlled fuel lock off valve that is close coupled to the vaporizer and off when ignition switch is off or when the engine is not running normally (supplied from Kubota). In operation without a lock off upstream the vaporizer will flow fuel with the engine off. The vaporizer is not a fuel shut-off safety device.

9Y1210661INI0016US0

[3] LENGTH OF THE VAPOR HOSE (WG1605-L-E3, WG1605-GL-E3)

Vapor hose length must not exceed 700 mm (27.6 in), shorter is generally considered better. Care should be taken with hose routing and length to minimize the affect on vaporizer vibration isolation. The metal reinforced hose should not be used.

9Y1210661INI0007US0

[4] IMPORTANT NOTICE

These instructions are provided to the Final Engine Assemblers (FEA) who must ensure the engine, exhaust system (catalyst), fuel system etc, are installed correctly in the engine's certified configuration.

Please confirm whether emission-related items are certain on application review.

(for EPA only)

Failing to follow these instructions when installing a certified engine in a piece of nonroad equipment violates federal law (40 CFR 1068.105(b)), subject to fines or other penalties as described in the Clean Air Act.

The contractual agreement contract is necessary before mass-production.

9Y1210661INI0018US0

[5] EMISSION-RELATED INSTALLATION INSTRUCTIONS

(1) Exhaust System

Kubota supplies a certified catalyst. FEA must use a Kubota certified catalyst and assemble the exhaust system parts according to the instructions.

No other catalyst is certified for use with WG1605 Engine. No Other Catalyst can be used.

FEA may only install the exhaust system parts confirmed at application review.

9Y1210661INI0019US0

(2) Intake System

To prevent decreases of engine output performance, intake resistance must be kept below a certain point.

9Y1210661INI0020US0

(3) Crankcase Ventilation Connections

Crankcase emissions may not be discharged directly into the ambient atmosphere throughout its useful life.

(40 CFR 1048.115 (a))

9Y1210661INI0021US0

(4) Gasoline Fuel System

If your equipment uses a volatile liquid fuel (such as gasoline), they must meet the evaporative emission standards of 40 CFR 1048.

9Y1210661INI0022US0

(5) Gaseous Fuel System

FEA must use only the vaporizer and the lock off valve Kubota offers and assemble the LPG fuel system parts according to the instructions.

9Y1210661INI0023US0

(6) Engine Control Unit (ECU)

Installation must utilize all 4 of the vibration mounts.
ECU header pins must be horizontal or point downward.

9Y1210661INI0024US0

(7) Vehicle Interface Connectors

Vehicle interface connectors shall be connected with your wire harness.

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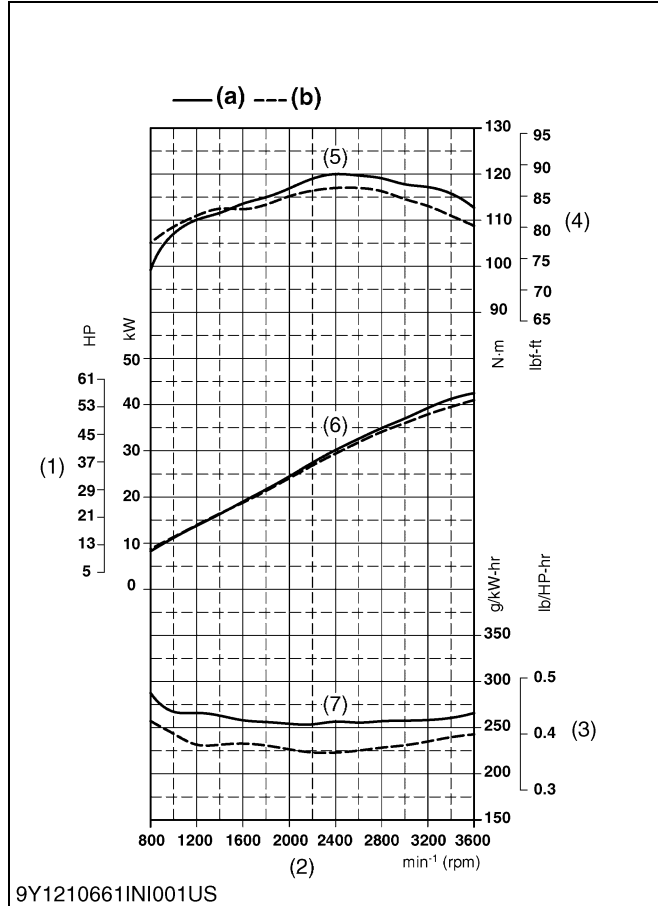
(8) Malfunction Indicator Light (MIL)

When the MIL goes on, it must display "Check Engine", "Service Engine Soon", or a similar message that EPA approve. (40 CFR 1048.110 (b))

9Y1210661INI0026US0

4. PERFORMANCE CURVES

WG1605-G/L/GL-E3



- (1) Brake Horsepower
- (2) Engine Speed
- (3) Specific Fuel Consumption
- (4) Torque
- (5) Gross Intermittent Torque
- (6) Gross Intermittent Brake Horsepower
- (7) Gross Intermittent Specific Fuel Consumption

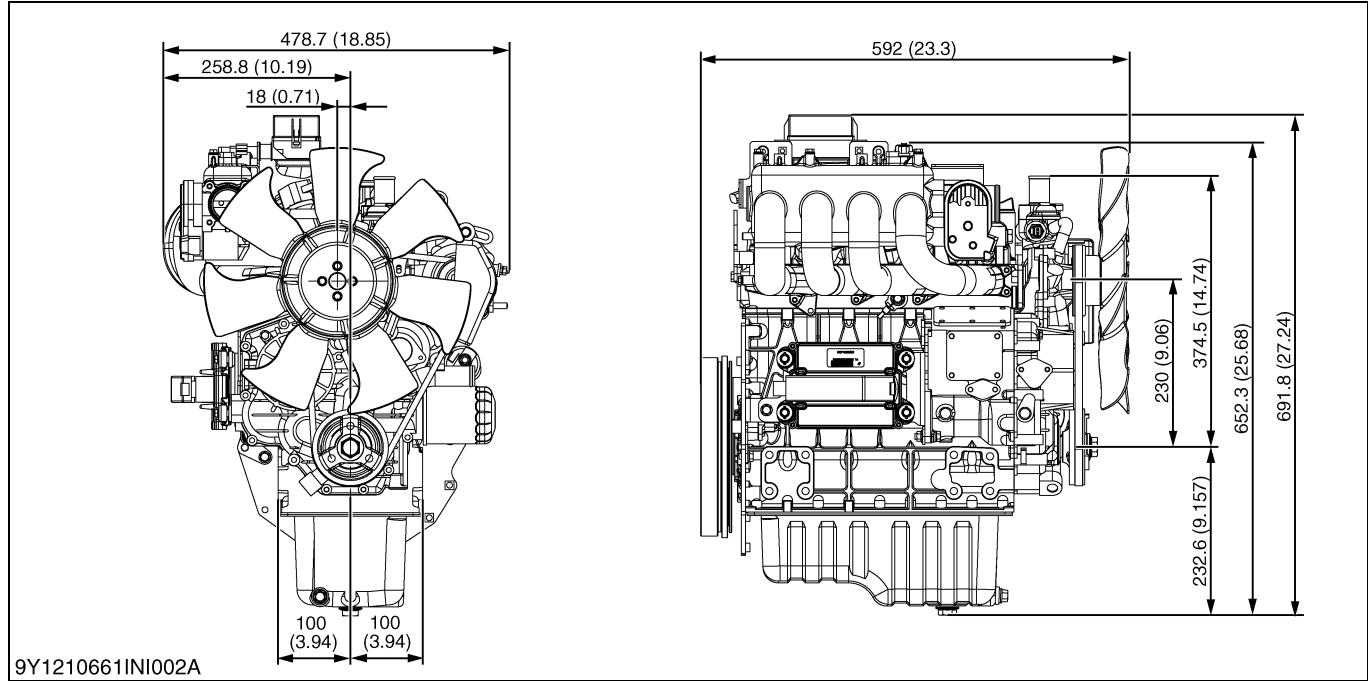
a: Gasoline Use
b: LP Gas Use

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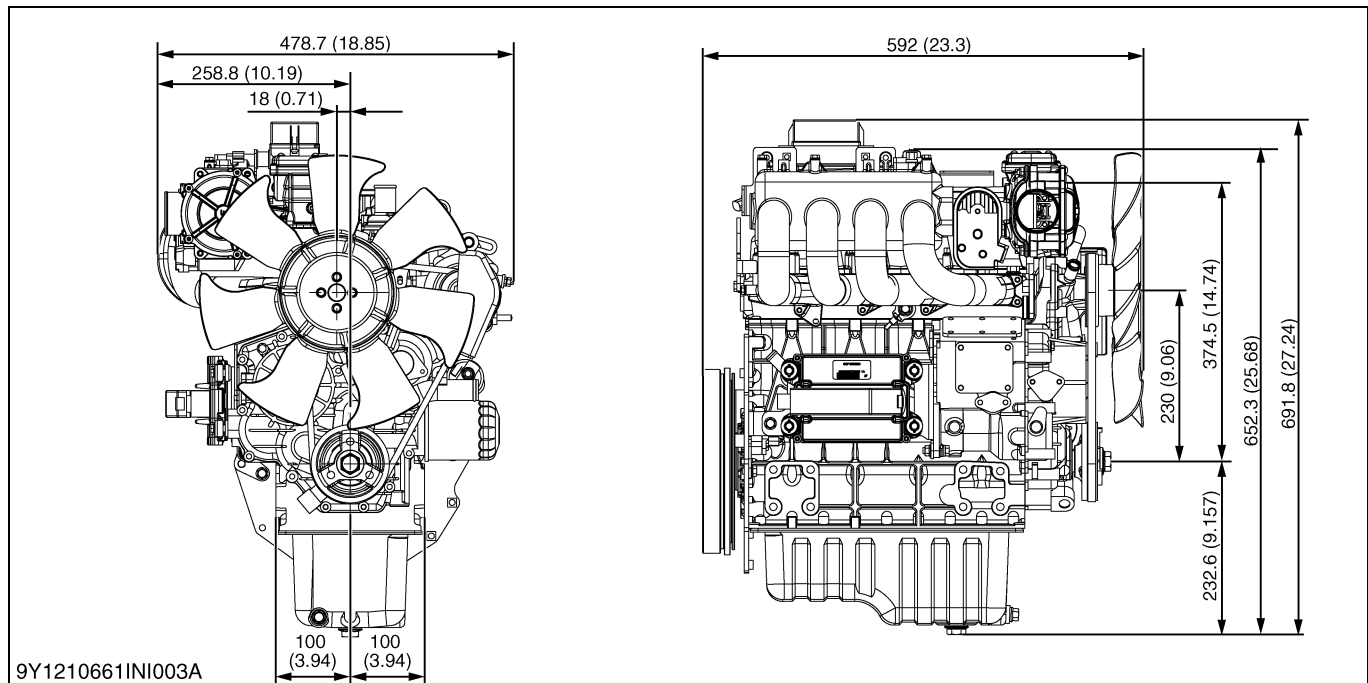
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WG1605-G-E3



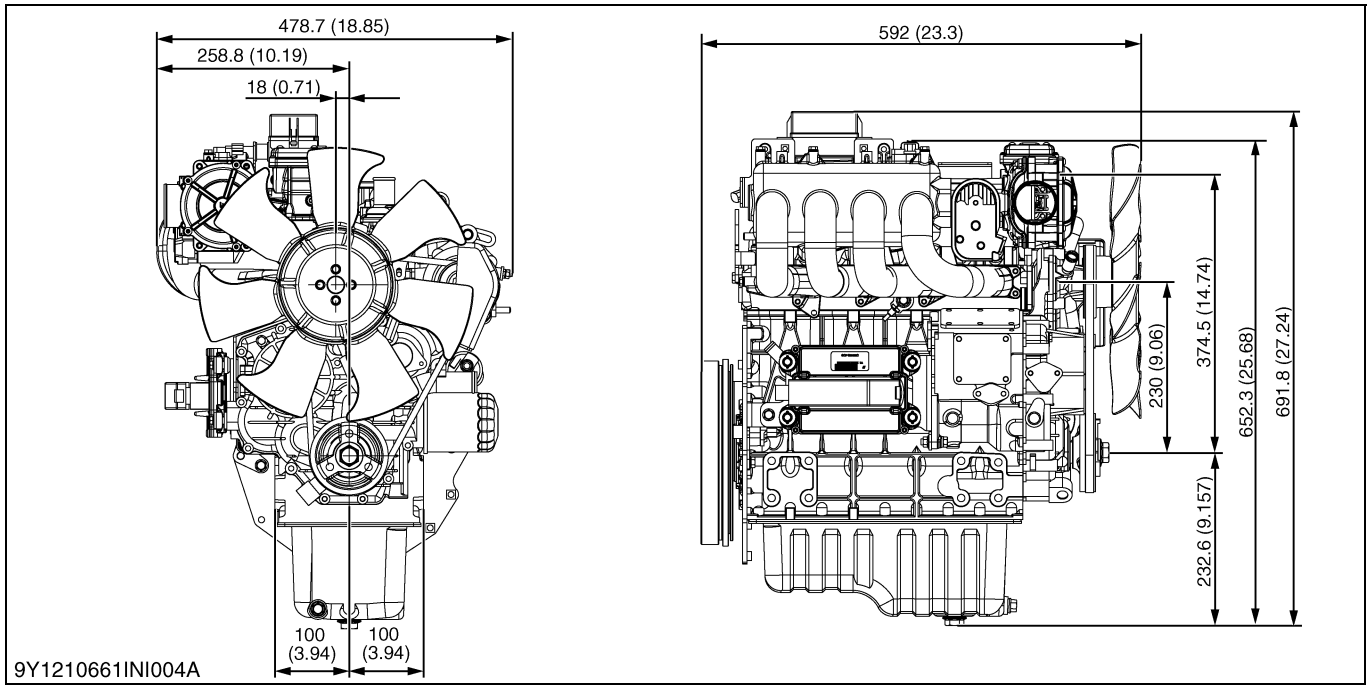
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WG1605-L-E3



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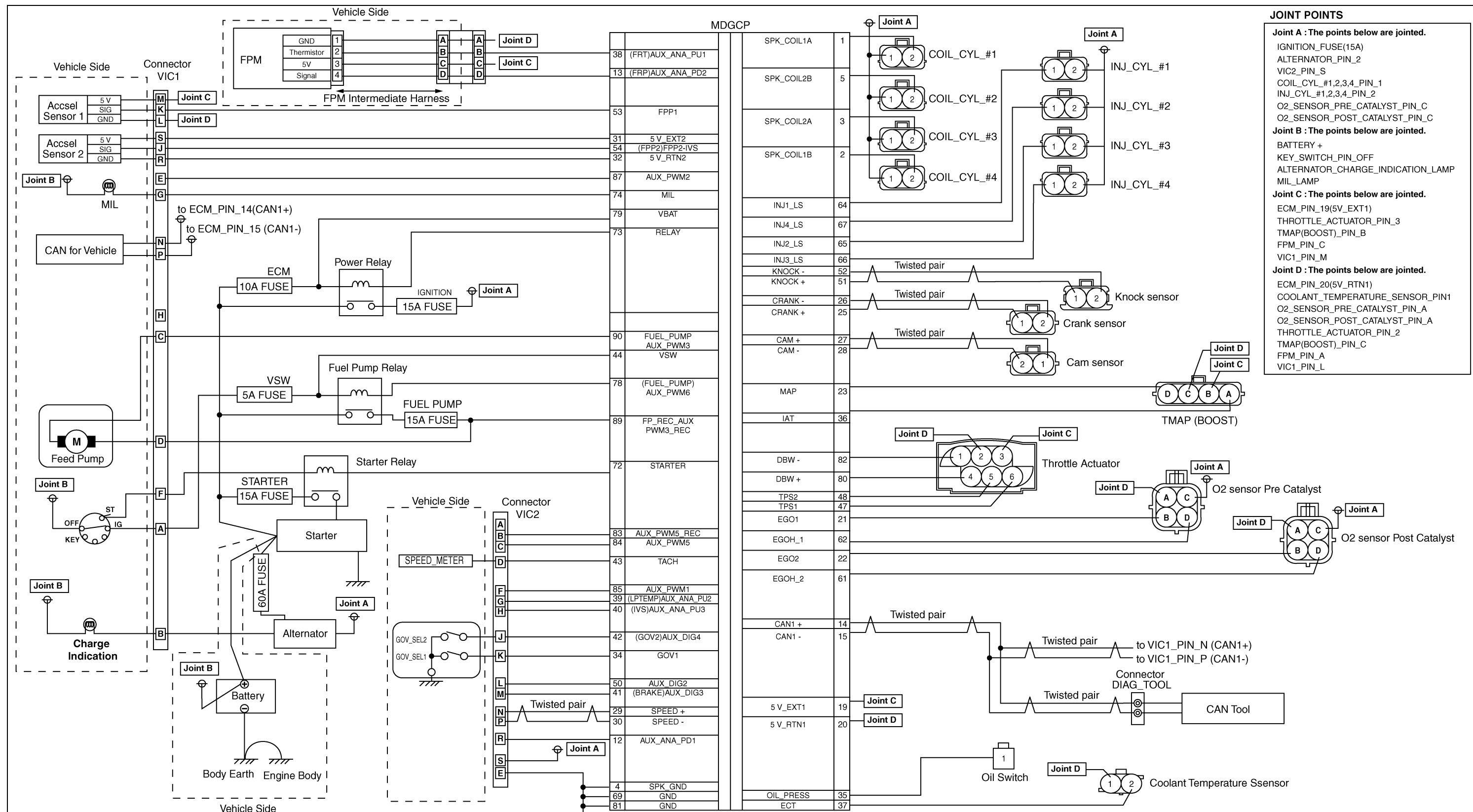
WG1605-GL-E3



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6. WIRING DIAGRAM

WG1605-G-E3



JOINT POINTS

Joint A : The points below are joined.
 IGNITION_FUSE(15A)
 ALTERNATOR_PIN_2
 VIC2_PIN_S
 COIL_CYL_#1,2,3,4_PIN_1
 INJ_CYL_#1,2,3,4_PIN_2
 O2_SENSOR_PRE_CATALYST_PIN_C
 O2_SENSOR_POST_CATALYST_PIN_C

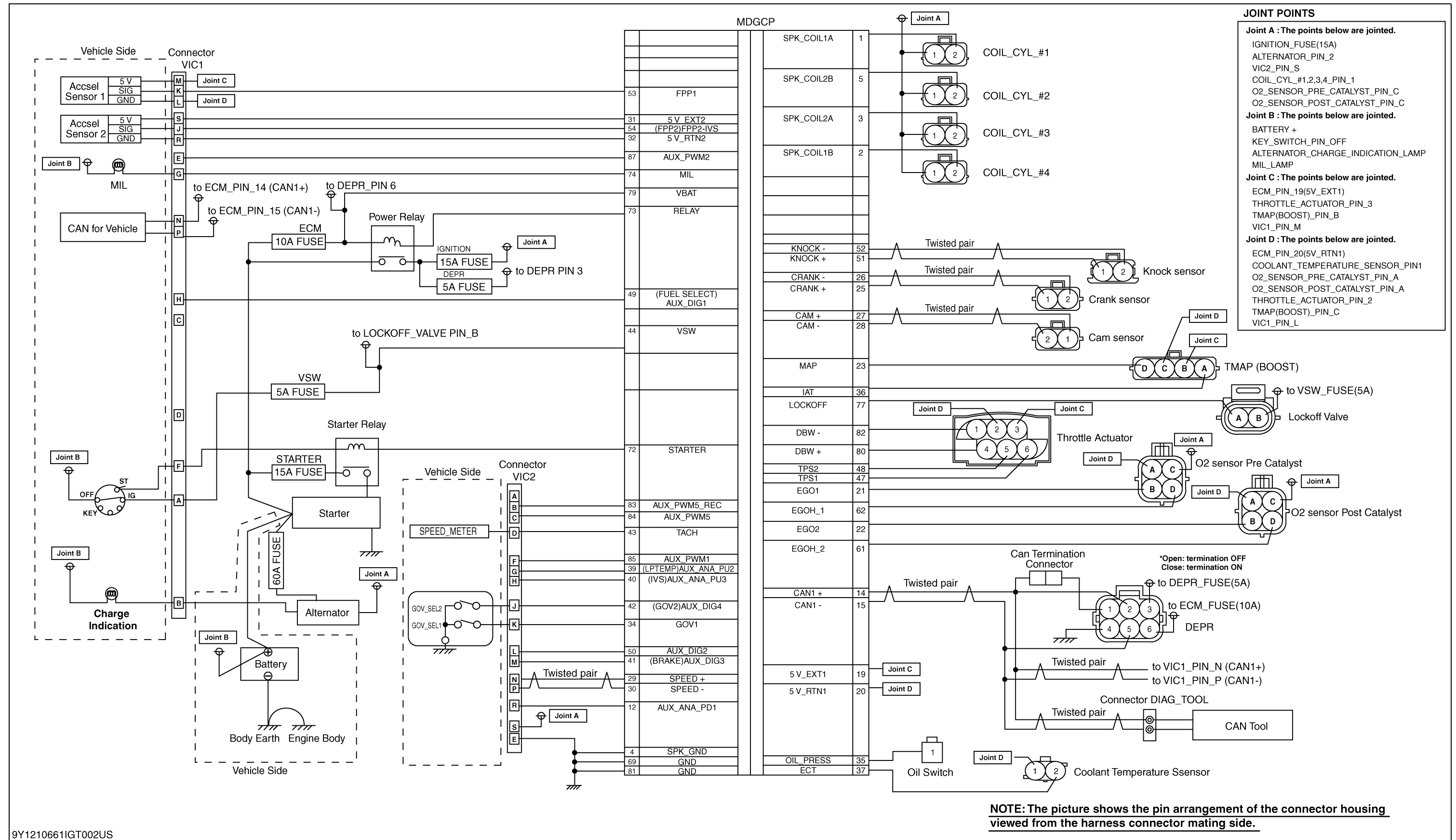
Joint B : The points below are joined.
 BATTERY +
 KEY_SWITCH_PIN_OFF
 ALTERNATOR_CHARGE_INDICATION_LAMP
 MIL_LAMP

Joint C : The points below are joined.
 ECM_PIN_19(5V_EXT1)
 THROTTLE_ACTUATOR_PIN_3
 TMAP(BOOST)_PIN_B
 FPM_PIN_C
 VIC1_PIN_M

Joint D : The points below are joined.
 ECM_PIN_20(5V_RTN1)
 COOLANT_TEMPERATURE_SENSOR_PIN1
 O2_SENSOR_PRE_CATALYST_PIN_A
 O2_SENSOR_POST_CATALYST_PIN_A
 THROTTLE_ACTUATOR_PIN_2
 TMAP(BOOST)_PIN_C
 FPM_PIN_A
 VIC1_PIN_L

NOTE: The picture shows the pin arrangement of the connector housing viewed from the harness connector mating side.

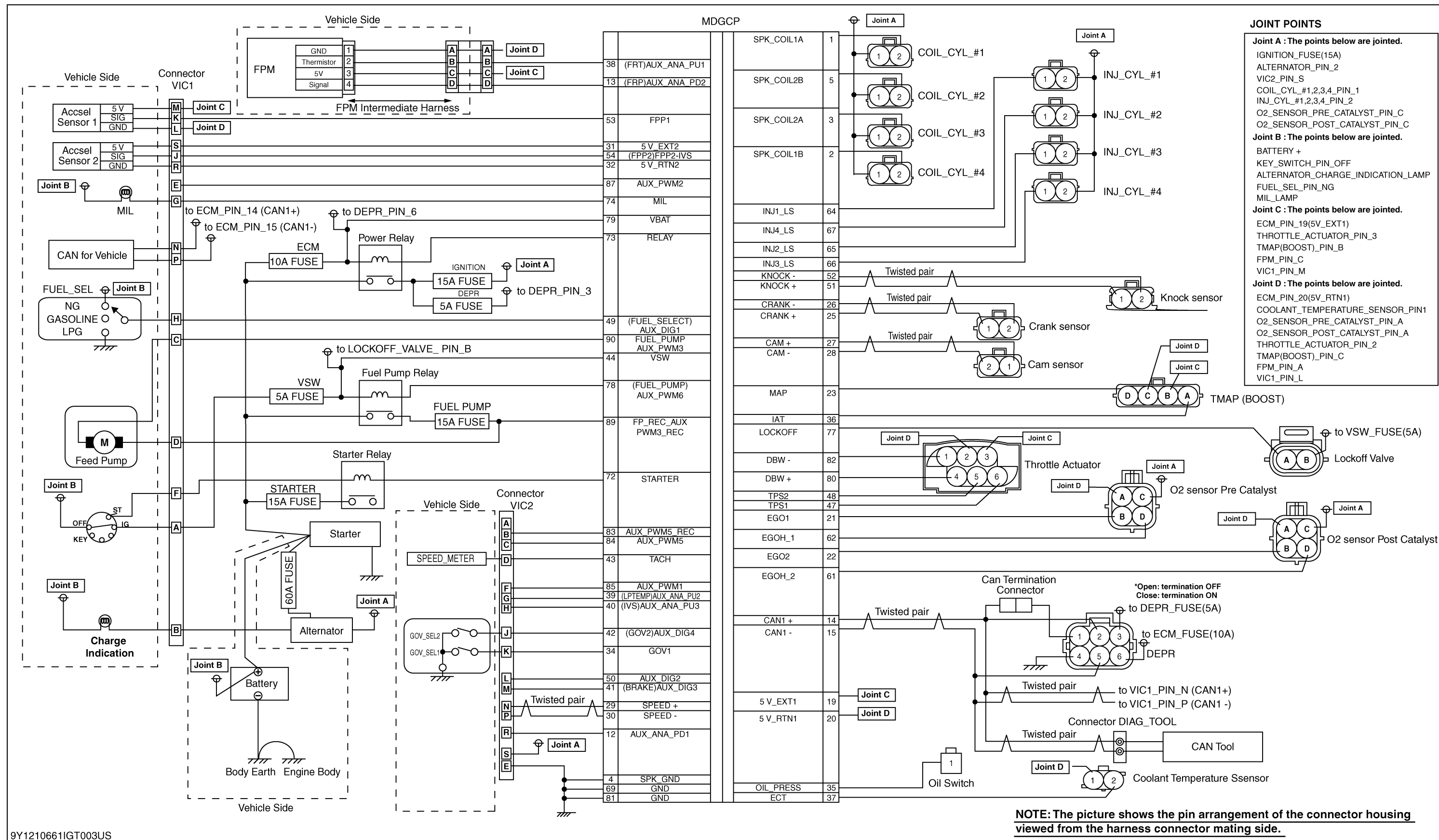
WG1605-L-E3



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NOTE: The picture shows the pin arrangement of the connector housing viewed from the harness connector mating side.

WG1605-GL-E3



9Y1210661IGT003US

G GENERAL

GENERAL

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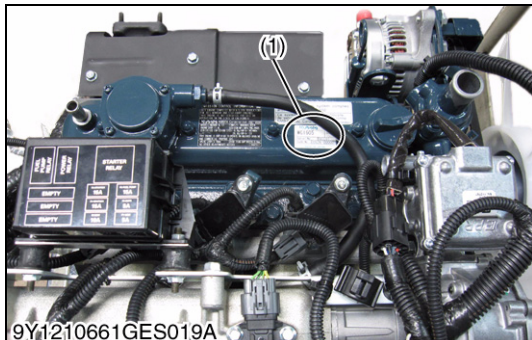
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1. Engine IDENTIFICATION

[1] ENGINE MODEL NAME, CODE NUMBER AND ENGINE SERIAL NUMBER

When contacting the manufacture, always specify your engine model name, code number and serial number. They are necessary to be identified before the engine can be serviced or parts replaced.

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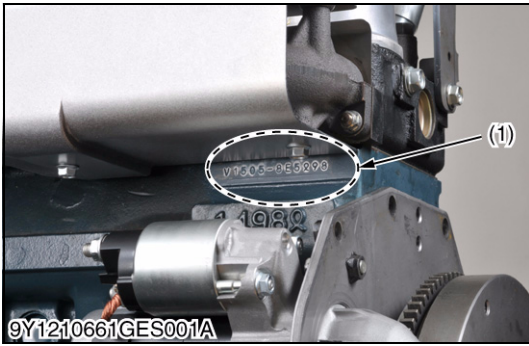


Engine Model Name and Number Label

The engine model number, the engine serial number and engine code number are written in this label.

- (1) Engine Model Name and Number Label

9Y1210661GEG0002US0



Engine Serial Number

The engine serial number is an identified number for the engine. It is marked after the engine model name.

It indicates month and year of manufacture as follows.

Year of manufacture

Alphabet or Number	Year	Alphabet or Number	Year
1	2001	F	2015
2	2002	G	2016
3	2003	H	2017
4	2004	J	2018
5	2005	K	2019
6	2006	L	2020
7	2007	M	2021
8	2008	N	2022
9	2009	P	2023
A	2010	R	2024
B	2011	S	2025
C	2012	T	2026
D	2013	V	2027
E	2014		

(1) Engine Serial Number

Month of manufacture

Month	Engine Lot Number	
January	A0001 ~ A9999	B0001 ~ BZ999
February	C0001 ~ C9999	D0001 ~ DZ999
March	E0001 ~ E9999	F0001 ~ FZ999
April	G0001 ~ G9999	H0001 ~ HZ999
May	J0001 ~ J9999	K0001 ~ KZ999
June	L0001 ~ L9999	M0001 ~ MZ999
July	N0001 ~ N9999	P0001 ~ PZ999
August	Q0001 ~ Q9999	R0001 ~ RZ999
September	S0001 ~ S9999	T0001 ~ TZ999
October	U0001 ~ U9999	V0001 ~ VZ999
November	W0001 ~ W9999	X0001 ~ XZ999
December	Y0001 ~ Y9999	Z0001 ~ ZZ999

* Alphabetical letters "I" and "O" are not used.

e.g.

- WG1605 - B B A001

- (a) Engine Model Name: **WG1605**
- (b) Year: **B** indicates **2011**
- (c) Month: **A** or **B** indicates **January**
- (d) Lot Number: (**0001 ~ 9999** or **A001 ~ Z999**)

9Y1210661GEG0003US0

[2] E3 ENGINE

[A]

EMISSION CONTROL INFORMATION

THIS ENGINE COMPLIES WITH U.S. EPA REGULATIONS FOR 2011 NONROAD AND STATIONARY ENGINES.

#####

Kubota KUBOTA Corporation DEL ASSY

MODEL: WG###-G-(ET) FAMILY: #####
ENGINE DISP.: ##L ECS: ECM, MFI, TWC, HO2S (1)
CERTIFIED EMISSION STD: ###g/kW-hr HC+NOx
###g/kW-hr CO
THIS ENGINE IS CERTIFIED TO OPERATE ON UNLEADED GASOLINE.

VALVE LASH: ##mm SPARK PLUG GAP WIDTH: ##mm
NO OTHER ADJUSTMENTS NEEDED #####

9Y1210661GES012A

[B]

EMISSION CONTROL INFORMATION

THIS ENGINE COMPLIES WITH U.S. EPA REGULATIONS FOR 2011 NONROAD AND STATIONARY ENGINES.

#####

Kubota KUBOTA Corporation DEL ASSY

MODEL: WG###-L-(ET) FAMILY: #####
ENGINE DISP.: ##L ECS: ECM, MIX, TWC, HO2S (1)
CERTIFIED EMISSION STD: ###g/kW-hr HC+NOx
###g/kW-hr CO
THIS ENGINE IS CERTIFIED TO OPERATE ON COMMERCIAL PROPANE GAS.

VALVE LASH: ##mm SPARK PLUG GAP WIDTH: ##mm
NO OTHER ADJUSTMENTS NEEDED #####

9Y1210661GES013A

[C]

EMISSION CONTROL INFORMATION

THIS ENGINE COMPLIES WITH U.S. EPA REGULATIONS FOR 2011 NONROAD AND STATIONARY ENGINES.

#####

Kubota KUBOTA Corporation DEL ASSY

MODEL: WG###-GL-(ET) FAMILY: #####
ENGINE DISP.: ##L ECS: ECM, MFI, MIX, TWC, HO2S (1)
CERTIFIED EMISSION STD: ###g/kW-hr HC+NOx
###g/kW-hr CO
THIS ENGINE IS CERTIFIED TO OPERATE ON UNLEADED GASOLINE AND COMMERCIAL PROPANE GAS.

VALVE LASH: ##mm SPARK PLUG GAP WIDTH: ##mm
NO OTHER ADJUSTMENTS NEEDED #####

9Y1210661GES014A

[Example: Engine Model Name WG1605-G/L/GL-E3-XXXX]
The emission controls previously implemented in various countries to prevent air pollution will be stepped up as Non-Road Emission Standards continue to change. The timing or applicable date of the specific Non-Road Emission regulations depends on the engine displacement and output classification.

Over the past several years, KUBOTA has been supplying SI engines that comply with regulations in the respective countries affected by Non-Road Emission regulations. For KUBOTA Engines, E3 will be the designation that identifies engine models affected by the next emission phase (See the table below).

When servicing or repairing ###-E3 series engines, use only replacement parts for that specific E3 engine, designated by the appropriate E3 KUBOTA Parts List and perform all maintenance services listed in the appropriate KUBOTA Operator's Manual or in the appropriate E3 KUBOTA Workshop Manual. Use of incorrect replacement parts or replacement parts from other emission level engines (for example: E2 engines), may result in emission levels out of compliance with the original E3 design and EPA or other applicable regulations. Please refer to the emission label located on the engine head cover to identify Engine Displacement and Output classification and Emission Control Information. E3 engines are identified with "ET" at the end of the Model designation, on the US EPA label. Please note: E3 is not marked on the engine.

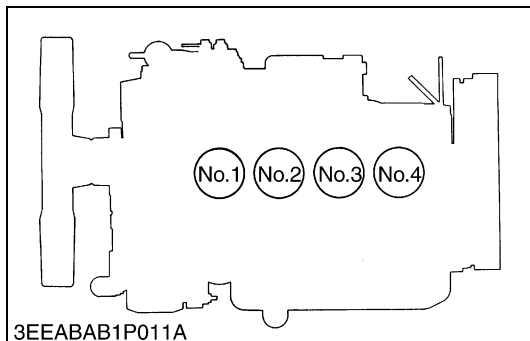
Category (1)	EPA Regulation
ET	Phase 3

- (1) "E3" engines are identified with "ET" at the end of the Model designation, on the US EPA label.
"E3" designates Phase 3 / Tier 3 models, depending on engine displacement and output classification.

- [A] WG1605-G-E3**
[B] WG1605-L-E3
[C] WG1605-GL-E3

9Y1210661GEG0037US0

[3] CYLINDER NUMBER

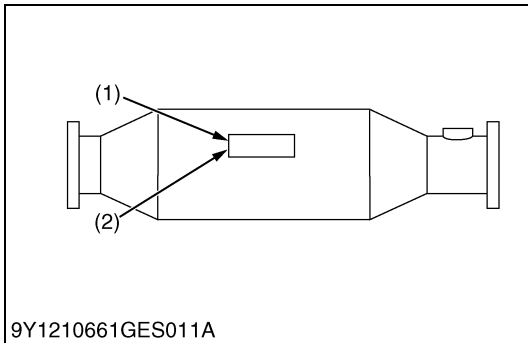


The cylinder numbers of KUBOTA gasoline, gasoline / LPG and natural gas engine are designated as shown in the figure.

The sequence of cylinder numbers is given as No.1, No.2, No.3 and No.4 starting from the gear case side.

9Y1210661GEG0006US0

[4] CATALYTIC CONVERTER



KUBOTA provides the catalytic converter as the catalyst parts.
The parts number, the manufacturing date and the catalyst lot number are marked on surfaces of the catalyst parts as the catalyst identification.

■ **IMPORTANT**

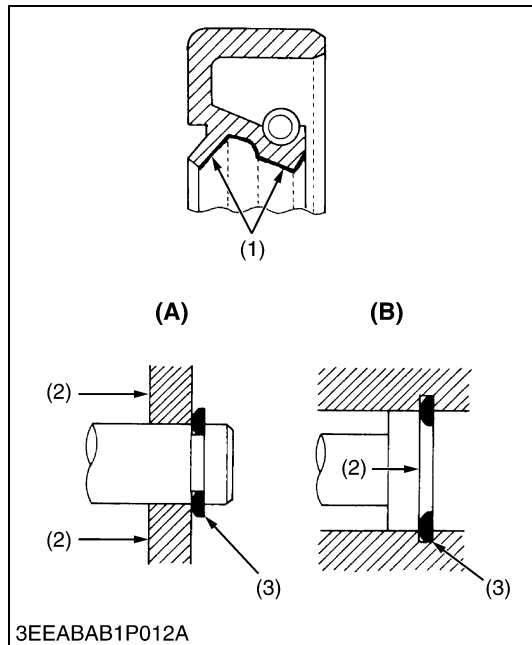
- **To trace of the catalytic converter, put down the catalyst identification and engine identification when new service catalytic converter is installed.**

(1) Part Number

(2) Date / Serial Number

9Y1210661GEG0038US0

2. GENERAL PRECAUTIONS



- During disassembly, carefully arrange removed parts in a clean area to prevent confusion later. Screws, bolts and nuts should be replaced in their original position to prevent reassembly errors.
- When special tools are required, use KUBOTA genuine special tools. Special tools which are not frequently used should be made according to the drawings provided.
- Before disassembling or servicing live wires, make sure to always disconnect the grounding cable from the battery first.
- Remove oil and dirt from parts before measuring.
- Use only KUBOTA genuine parts for parts replacement to maintain engine performance and to ensure safety.
- Gaskets and O-rings must be replaced during reassembly. Apply grease to new O-rings or oil seals before assembling.
- When reassembling external or internal snap rings, position them so that sharp edge faces against the direction from which a force is applied.
- Be sure to perform run-in the serviced or reassemble engine. Do not attempt to give heavy load at once, or serious damage may result to the engine.

(1) Grease

(2) Force

(3) Place the Sharp Edge the Direction of Force

(A) External Snap Ring

(B) Internal Snap Ring

9Y1210318GEG0007US0

3. MAINTENANCE CHECK LIST

To maintain long-lasting and safe engine performance, make it a rule to carry out regular inspections by following the table below. (The schedule applies to an engine in use under normal conditions.)

[WG1605-G-E3,WG1605-L-E3,WG1605-GL-E3]

Item	Service Interval							
	Every 8 hrs (Daily)	Every 50 hrs (Weekly)	Every 100 hrs	Every 200 hrs	Every 1000 hrs	Every 2000 hrs	Every 1 year	Every 2 years
Checking engine oil level	☆							
Checking and replenish coolant	☆							
Checking air cleaner element	if necessary							
Cleaning air cleaner element	if necessary		☆					
Checking LPG tank setting condition	if necessary							
Checking LPG fuel connector	☆							
Changing engine oil		★		☆				
Replacing oil filter cartridge		★		☆				
Checking gasoline fuel hose and clamp bands		☆						
Checking LPG fuel hose and clamp bands		☆						
Cleaning spark plug			☆					
Checking fuel filter			☆					
Check fan belt tension and damage			☆					
Checking battery electrolyte level			☆					
Replacing fuel filter			if necessary					
Checking LPG tank setting condition				☆				
Checking radiator hoses and clamp bands				☆				
Checking PCV valve					☆			
Checking coolant hose of LPG vaporizer					☆			
Checking LPG Lock off valve					☆			
Checking valve clearance					☆			
Replacing spark plug						☆		
* Replacing air cleaner element							☆	
Replacing gasoline fuel hose, clamp bands and fuel filter							☆	
Cleaning fuel tank inside (for gasoline fuel)							☆	
Cleaning water jacket and radiator interior							☆	
Replacing intake air line								☆
Replacing breather hose								☆
Replacing LPG fuel hose and clamp bands								☆
Replacing coolant hose of LPG vaporizer								☆
** Checking LPG vaporizer								☆
Replacing radiator hoses and clamp bands								☆
Changing radiator coolant								☆
Replacing battery								☆

★ Change engine oil and replace oil filter cartridge after the first 50 hours of operation.

*: Change more often when operating under dusty conditions.

** : If you do not have the proper tools and / or are not mechanically proficient, contact your local KUBOTA dealer.



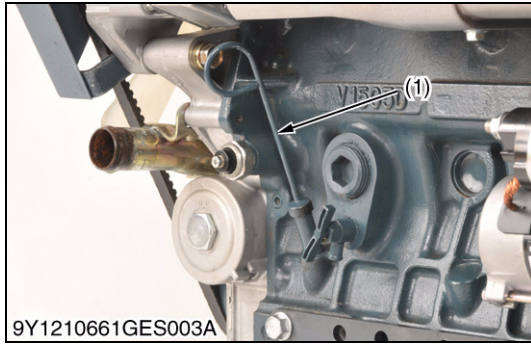
CAUTION

- When changing or inspecting, be sure to level and stop the engine.

9Y1210661GEG0008US0

4. CHECK AND MAINTENANCE

[1] DAILY CHECK POINTS



Checking Engine Oil Level

1. Level the engine.
2. To check the oil level, draw out the dipstick (1), wipe it clean, reinsert it, and draw it out again.
Check to see that the oil level lies between the two notches.
3. If the level is too low, add new oil to the specified level.

■ IMPORTANT

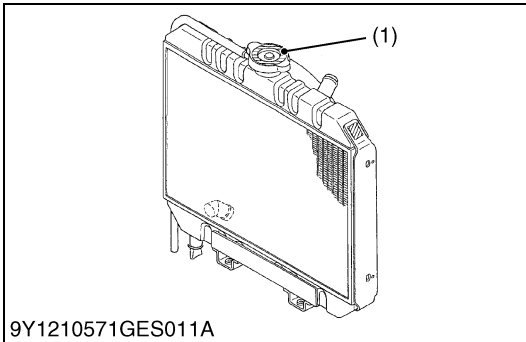
- When using an oil of different maker or viscosity from the previous one, drain old oil. Never mix two different types of oil.
- Use the proper SAE Engine oil according to ambient temperatures.

■ NOTE

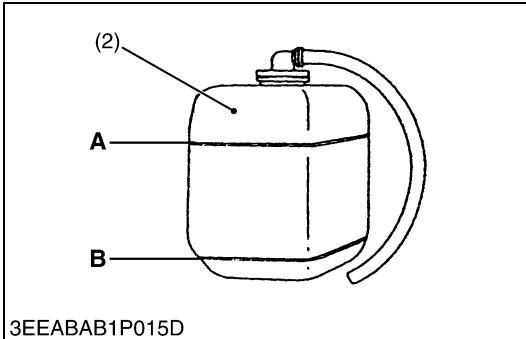
- Be sure to inspect the engine, locating it on a horizontal place. If placed on gradients, accurately, oil quantity may not be measured.
- Be sure to keep the oil level between upper and lower limits of the dipstick. Too much oil may cause a drop in output or excessive blow-by gas. On the closed breather type engine in which mist is sucked through port, too much oil may caused oil hammer. While too little oil, may seize the engine's rotating and sliding parts.

(1) Dipstick

9Y1210661GEG0009US0



9Y1210571GES011A



3EEABAB1P015D

Checking and Replenish Coolant

1. Without recovery tank:
Remove the radiator cap (1) and check to see that the coolant level is just below the port.
- With recovery tank (2):
Check to see that the coolant level lies between **FULL "A"** and **LOW "B"**.
2. If coolant level is too low, check the reason for decreasing coolant.
 - (Case 1)
If coolant is decreasing by evaporation, replenish only fresh, soft water.
 - (Case 2)
If coolant is decreasing by leak, replenish coolant of the same manufacture and type in the specified mixture ratio (fresh, soft water and L.L.C.). If the coolant brand cannot be identified, drain out all of the remaining coolant and refill with a totally new brand of coolant mix.

⚠ CAUTION

- Do not remove the radiator cap until coolant temperature is below its boiling point. Then loosen the cap slightly to relieve any excess pressure before removing the cap completely.

■ IMPORTANT

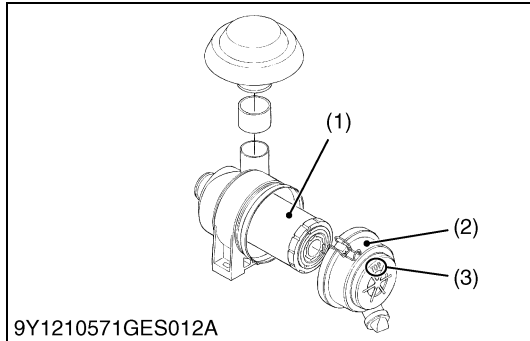
- During filling the coolant, air must be vented from the engine coolant passages. The air vents by jiggling the radiator upper and lower hoses.
- Be sure to close the radiator cap securely. If the cap is loose or improperly closed, coolant may leak out and the engine could overheat.
- Do not use an antifreeze and scale inhibitor at the same time.
- Never mix the different type or brand of L.L.C..

- (1) Radiator Cap
(2) Recovery Tank

A: FULL

B: LOW

9Y1210571GEG0037US0

**Checking Air Cleaner Element (If necessary)**

1. Remove the dust cup in the air cleaner.
2. Check the dust in the dust cup and the element.

(When reassembling)

- Install the air cleaner dust cup with "TOP" indicated on the rear of the cup.

(1) Element
(2) Dust Cap

(3) "TOP" Mark

9Y1210571GEG0038US0

**Cleaning Air Cleaner Element (If necessary)**

1. Remove the air cleaner element.
2. Use clean dry compressed air on the inside of the element. Pressure of compressed air must be under 205 kPa (2.1 kgf/cm², 30 psi). Maintain reasonable distance between the nozzle and the filter

NOTE

- The air cleaner uses a dry element. Never apply oil to it.
- Do not run the engine with filter element removed.
- Change the element once a year or every 6th cleaning

9Y1210661GEG0050US0

Checking LPG Tank Setting Condition (If necessary) (WG1605-L-E3, WG1605-GL-E3)

1. Check the setting condition of LPG fuel tank.

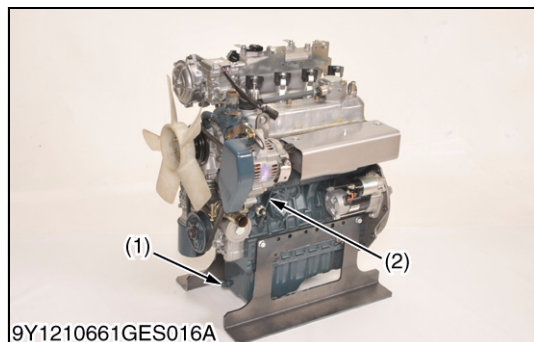
9Y1210661GEG0010US0

Checking LPG Fuel Connector (WG1605-L-E3, WG1605-GL-E3)

1. Check the connector of LPG line (hoses and clamps).

9Y1210661GEG0011US0

[2] CHECK POINTS OF INTIAL 50 HOURS



Changing Engine Oil

⚠ CAUTION

- **Be sure to stop engine before changing engine oil.**
1. Start and warm up the engine for approx. 5 minutes.
 2. Place an oil pan underneath the engine.
 3. To drain the used oil, remove the drain plug (1) at the bottom of the engine and drain the oil completely.
 4. Screw the drain plug (1).
 5. Fill new oil up to upper line on the dipstick (2).

■ IMPORTANT

- **When using an oil of different maker or viscosity from the previous one, remove all of the old oil.**
- **Never mix two different types of oil.**
- **Engine oil should have properties of API classification better than SH.**
- **Use the proper SAE Engine Oil according to ambient temperature.**

Above 25 °C (77 °F)	SAE30 or SAE10W-30 or SAE15W-40
0 °C to 25 °C (32 °F to 77 °F)	SAE20 or SAE10W-30
0 °C to -20 °C (32 °F to -4 °F)	SAE10W or SAE10W-30

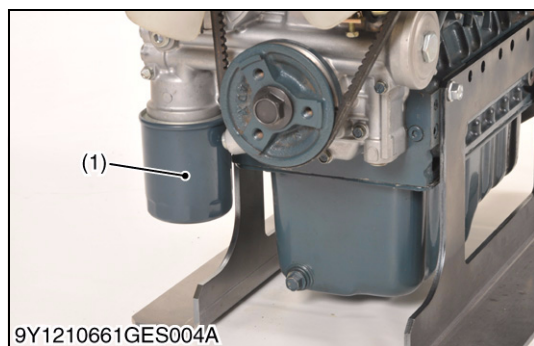
Engine oil capacity	6.0 L 1.6 U.S.gals
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Tightening torque	Drain plug	32.4 to 37.3 N·m 3.31 to 3.80 kgf·m 23.9 to 27.5 lbf·ft
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(1) Drain Plug

(2) Dipstick

9Y1210661GEG0012US0



Replacing Oil Filter Cartridge

⚠ CAUTION

- **Be sure to stop the engine before changing filter cartridge.**
1. Remove the oil filter cartridge (1) with the filter wrench.
 2. Apply a slight coat of oil onto the new cartridge gasket.
 3. To install the new cartridge, screw it in by hand. Over tightening may cause deformation of rubber gasket.
 4. After the new cartridge has been replaced, the engine oil normally decrease a little. Thus see that the engine oil does not leak through the seal and be sure to read the oil level on the dipstick. Then, replenish the engine oil up to the specified level.

■ IMPORTANT

- **To prevent serious damage to the engine, replacement element must be highly efficient. Use only a KUBOTA genuine filter or its equivalent.**

(1) Engine Oil Filter Cartridge

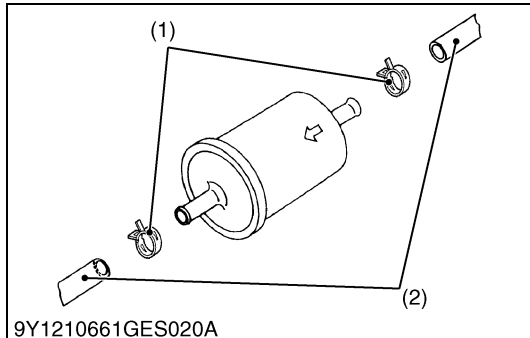
9Y1210661GEG0013US0

[3] CHECK POINTS OF EVERY 50 HOURS

CAUTION

- Stop the engine when attempting the check and replace prescribed below.
- Remember to check the fuel line periodically. The fuel line is subject to wear and aging, fuel may leak out onto the running engine, causing a fire.

9Y1210318GEG0020US0



Checking Gasoline Fuel Hose and Clamp Bands

Check the fuel hoses every 50 hours of operation.

1. Use good engineering judgment to ensure that all fuel-line fittings will remain securely connected to prevent fuel leakage throughout the useful life of the equipment.
Replace the fuel hose together with the clamp every year.
2. If the fuel hose and clamp are found to be damaged or deteriorate earlier than year, then replace or remedy.
3. After the fuel hose and the clamp have been replaced, make sure that there is no fuel leakage.

(1) Clamp

(2) Fuel Hose

9Y1210661GEG0043US0

Checking LPG Fuel Hose and Clamp Bands (WG1605-G-E3, WG1605-L-E3, WG1605-GL-E3)

■ IMPORTANT

- Never test for gas leaks with a FLAME.

■ NOTE

- Check for fuel leakage with soapy water or gas-detector, if leakage is found, correct leakage or replace the hose.

9Y1210661GEG0014US0

[4] CHECK POINTS OF EVERY 100 HOURS



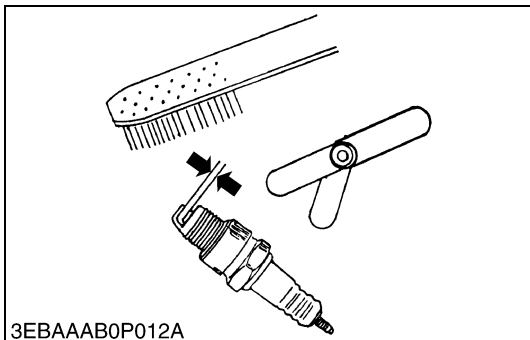
Cleaning Air Cleaner Element

1. Remove the air cleaner element.
2. Use clean dry compressed air on the inside of the element. Pressure of compressed air must be under 205 kPa (2.1 kgf/cm², 30 psi). Maintain reasonable distance between the nozzle and the filter.

■ **NOTE**

- The air cleaner uses a dry element. Never apply oil to it.
- Do not run the engine with filter element removed.
- Change the element once a year or every 6th cleaning.

9Y1210661GEG0042US0



Cleaning Spark Plug

1. Remove the spark plug, and remove carbon from the electrode with a wire brush or other tools.
2. Measure the spark plug gap with a feeler gauge, and adjust or replace the spark plug if the measured gap differs from the factory specification.
3. Replace the spark plug if the electrode or the insulator is deformed or cracked.
4. Tighten the spark plug with a plug wrench.

■ **IMPORTANT**

(When reassembling)

- Put the ignition coil inside the spark plug terminal firmly.
- Make sure that the wiring and the ignition coil are correctly connected.
- Fix the ignition coil by screw / nut.

Spark plug gap	Factory specification	0.70 to 0.80 mm 0.028 to 0.031 in.
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Spark plug	NGK IFR6F8DN
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Tightening torque	Spark plug	24.5 to 29.4 N·m 2.50 to 2.99 kgf·m 18.1 to 21.6 lbf·ft
	Ignition coil mounting screw / nut	9.81 to 11.3 N·m 1.00 to 1.15 kgf·m 7.24 to 8.33 lbf·ft

9Y1210661GEG0044US0

Checking Fuel Filter

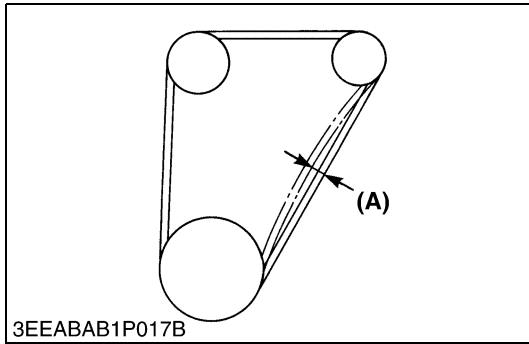
1. Check the fuel filter.
2. If the fuel filter is dirty, clean it or replace it.



CAUTION

- Stop the engine when attempting to check and clean the fuel filter.
- Gasoline fuel is extremely flammable, so avoid fires.

9Y1210318GEG0028US0



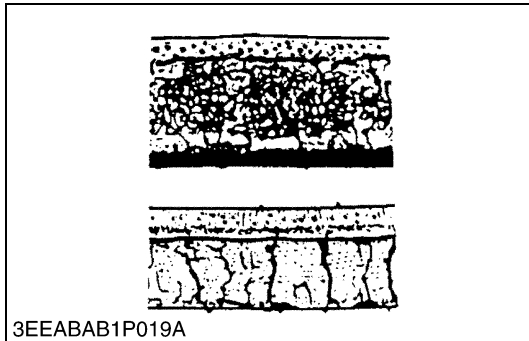
Fan Belt Tension

1. Measure the deflection **(A)**, depressing the belt halfway between the fan drive pulley and alternator pulley at specified force 98 N (10 kgf, 22 lbf).
2. If the measurement is not within the factory specifications, loosen the alternator mounting screws and relocate the alternator to adjust.

Deflection (A)	Factory specification	7.0 to 9.0 mm 0.28 to 0.35 in.
-----------------------	-----------------------	-----------------------------------

(A) Deflection

9Y1210318GEG0001US0



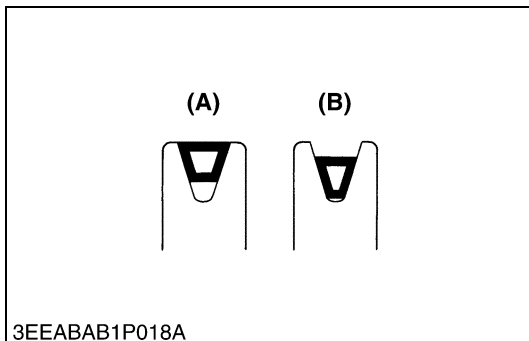
Fan Belt Damage and Wear

1. Check the fan belt for damage.
2. If the fan belt is damaged, replace it.
3. Check if the fan belt is worn and sunk in the pulley groove.
4. If the fan belt is nearly worn out and deeply sunk in the pulley groove, replace it.

(A) Good

(B) Bad

9Y1210318GEG0002US0



Checking Battery Electrolyte Level

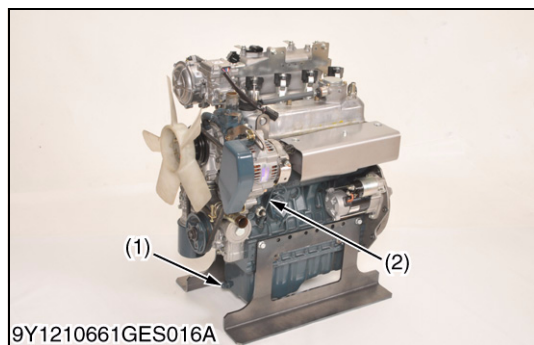
1. Check the battery electrolyte level.
2. If the level is below than lower level line, add the distilled water to pour level of each cell.

CAUTION

- Never remove the vent plugs while the engine is running.
- Keep electrolyte away from eyes, hands and clothes. If you are splattered with it, wash it away completely with water immediately and get medical attention.
- Wear eye protection and rubber gloves when working around battery.

9Y1210318GEG00026US0

[5] CHECK POINTS OF EVERY 200 HOURS



Changing Engine Oil

⚠ CAUTION

- **Be sure to stop engine before changing engine oil.**
1. Start and warm up the engine for approx. 5 minutes.
 2. Place an oil pan underneath the engine.
 3. To drain the used oil, remove the drain plug (1) at the bottom of the engine and drain the oil completely.
 4. Screw the drain plug (1).
 5. Fill new oil up to upper line on the dipstick (2).

■ IMPORTANT

- **When using an oil of different maker or viscosity from the previous one, remove all of the old oil.**
- **Never mix two different types of oil.**
- **Engine oil should have properties of API classification better than SH.**
- **Use the proper SAE Engine Oil according to ambient temperature.**

Above 25 °C (77 °F)	SAE30 or SAE10W-30 or SAE15W-40
0 °C to 25 °C (32 °F to 77 °F)	SAE20 or SAE10W-30
0 °C to -20 °C (32 °F to -4 °F)	SAE10W or SAE10W-30

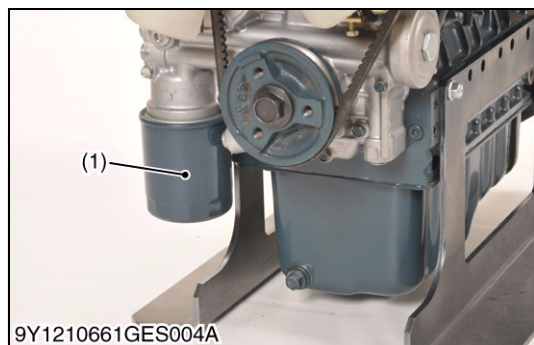
Engine oil capacity	6.0 L 1.6 U.S.gals
---------------------	-----------------------

Tightening torque	Drain plug	32.4 to 37.3 N·m 3.31 to 3.80 kgf·m 23.9 to 27.5 lbf·ft
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(1) Drain Plug

(2) Dipstick

9Y1210661GEG0012US0



Replacing Oil Filter Cartridge

⚠ CAUTION

- **Be sure to stop the engine before changing filter cartridge.**
1. Remove the oil filter cartridge (1) with the filter wrench.
 2. Apply a slight coat of oil onto the new cartridge gasket.
 3. To install the new cartridge, screw it in by hand. Over tightening may cause deformation of rubber gasket.
 4. After the new cartridge has been replaced, the engine oil normally decrease a little. Thus see that the engine oil does not leak through the seal and be sure to read the oil level on the dipstick. Then, replenish the engine oil up to the specified level.

■ IMPORTANT

- **To prevent serious damage to the engine, replacement element must be highly efficient. Use only a KUBOTA genuine filter or its equivalent.**

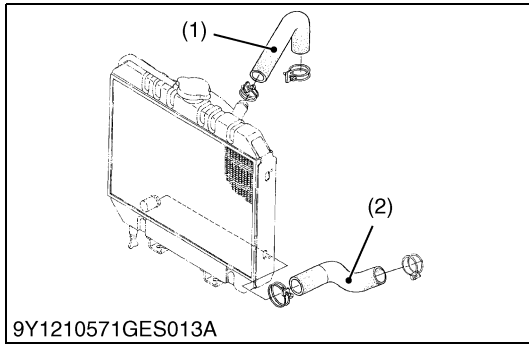
(1) Engine Oil Filter Cartridge

9Y1210661GEG0013US0

Checking LPG Tank Setting Condition (WG1605-L-E3,WG1605-GL-E3)

1. Check the setting condition of LPG fuel tank.

9Y1210661GEG0016US0



Checking Radiator Hoses and Clamp Bands

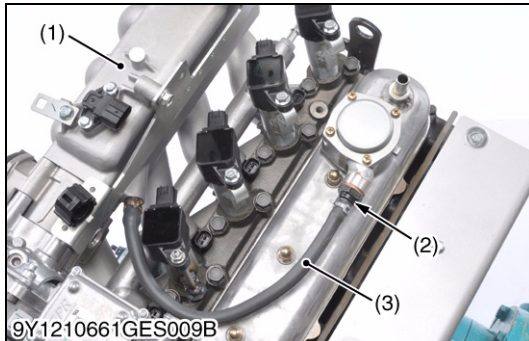
1. Check to see if the radiator hoses are properly fixed every 200 hours of operation or every six months, whichever comes first.
2. If the clamp is loose, apply oil to the threads and retighten it securely.
3. The coolant hose is made of rubber and tends to age. It must be replaced every two years. Also replace the clamp and tighten it securely.

(1) Upper Hose

(2) Lower Hose

9Y1210571GEG0039US0

[6] CHECK POINTS OF EVERY 1000 HOURS



Checking PCV Valve

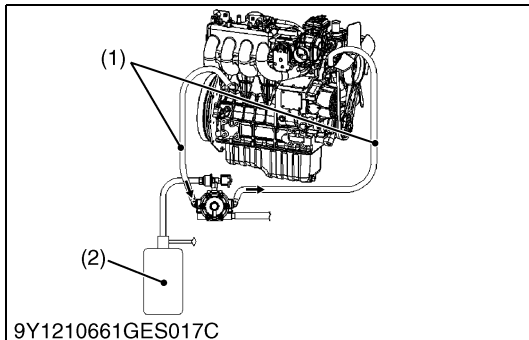
1. Disconnect the breather hose (3) from the intake manifold (1).
2. Blow into the breather hose (3).
3. Stop to blow.
4. Make sure that a slight operation sound is heard from the PCV valve.
5. If there is no operation sound, replace the PCV valve (2).
6. Connect the breather hose (3) to the intake manifold (1)

(1) Intake Manifold

(3) Breather Hose

(2) PCV Valve

9Y1210661GEG0039US0



Checking Coolant Hose of LPG Vaporizer

1. Check the coolant hoses (1) for damage.
2. If the coolant hose is damaged, replace it.

(1) Coolant Hose

(2) LPG Tank

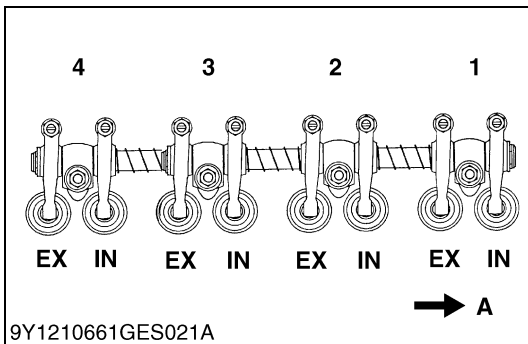
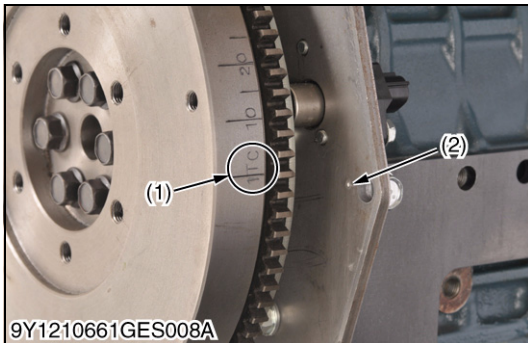
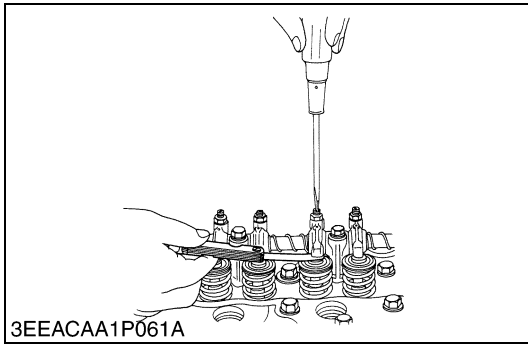
9Y1210661GEG0019US0



Checking LPG Lock Off Valve

1. Start the engine.
2. Make sure that an operation sound of solenoid is heard from the LPG lock off valve.
3. Make sure that there is no fuel leakage from the LPG lock off valve.
4. If there is no operation sound or fuel leakage, replace the LPG lock off valve.

9Y1210661GEG0040US0



Checking Valve Clearance

■ **IMPORTANT**

- **The valve clearance must be checked and adjusted when engine is cold.**
1. Remove the cylinder head cover.
 2. Align the "1TC" mark (1) on the flywheel and alignment mark (2) on the rear end plate so that the No. 1 piston comes to the compression top dead center.
 3. Check the following valve clearance marked with "☆" using a feeler gauge.
 4. If the clearance is not within the factory specifications, adjust with the adjusting screw.
 5. Then turn the flywheel 6.28 rad (360 °), and align the "1TC" mark (1) on the flywheel and alignment mark (2) on the rear end plate so that the No. 1 piston comes to the overlap position.
 6. Check the following valve clearance marked with "☆" using a feeler gauge.
 7. If the clearance is not within the factory specifications, adjust with the adjusting screw.

Adjustable Cylinder Location of Piston	Intake valve		Exhaust valve	
	1st	☆	☆	☆
When No. 1 piston is at compression top dead center	1st	☆	☆	☆
	2nd	☆		
	3rd			☆
	4th			
When No. 1 piston is at overlap position	1st			
	2nd			☆
	3rd	☆		
	4th	☆		☆
Intake and exhaust valve clearance (cold)	Factory specification	0.145 to 0.185 mm 0.00571 to 0.00728 in.		

■ **NOTE**

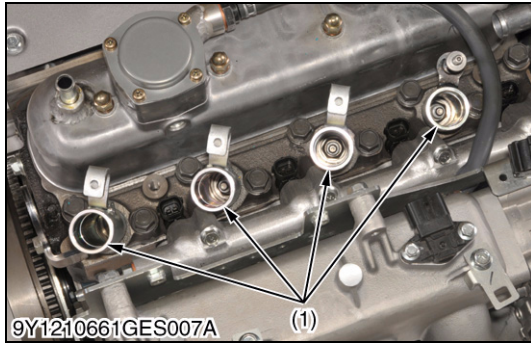
- **The sequence of cylinder numbers is given as No. 1, No. 2, No. 3 and No. 4 starting from the gear case side.**
- **After adjusting the valve clearance, secure the adjusting screw with the lock nut.**

- (1) "1TC" Mark
- (2) Alignment Mark

A: Gear Case Side

9Y1210661GEG0045US0

[7] CHECK POINTS OF EVERY 2000 HOURS



Replacing Spark Plug

1. Disconnect the ignition coil.
2. Remove the spark plug.
3. Replace the new spark plug.
4. Tighten the spark plug with a plug wrench.

■ IMPORTANT

(When reassembling)

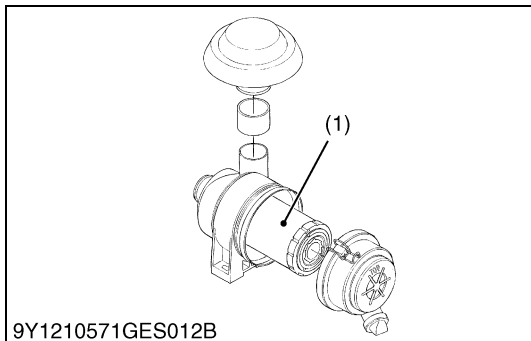
- Put the ignition coil inside the spark plug terminal firmly.
- Make sure that the wiring and the ignition coil are correctly connected.
- Fix the ignition coil by screw / nut.

Spark plug	NGK IFR6F8DN	
Tightening torque	Spark plug	24.5 to 29.4 N·m 2.50 to 2.99 kgf·m 18.1 to 21.6 lbf·ft
	Ignition coil mounting screw / nut	9.81 to 11.3 N·m 1.00 to 1.15 kgf·m 7.24 to 8.33 lbf·ft

(1) Spark Plug

9Y1210661GEG0046US0

[8] CHECK POINTS OF EVERY 1 YEAR

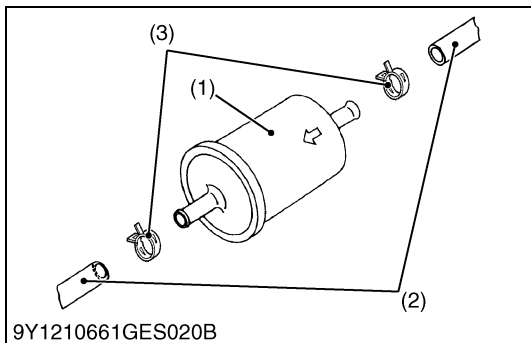


Replacing Air Cleaner Element

1. Remove the dust cup from the air cleaner.
2. After cleaning the dust cup, remove the air cleaner element.
3. Replace the new air cleaner element.

(1) Air Cleaner Element

9Y1210571GEG0040US0



Replacing Gasoline Fuel Hose, Clamp Bands and Fuel Filter

1. Replace the fuel filter (1) with a new one.
2. Replace the hose (2) and clamp (3).

⚠ CAUTION

- In order to reduce the fuel pressure, do not remove the fuel hose at least 3 minutes after stopping the engine.
- Remove the hose after covering the hose with a waste to prevent scatter of fuel.

(1) Fuel Filter
(2) Fuel Hose

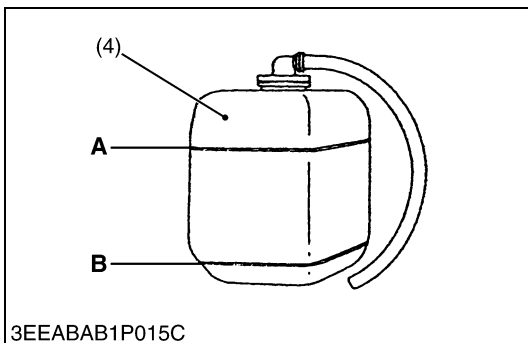
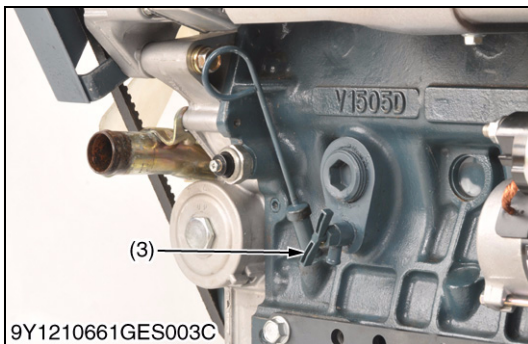
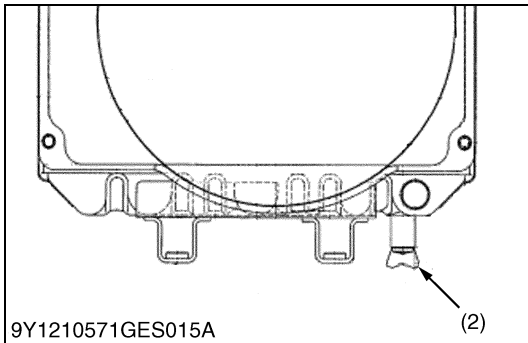
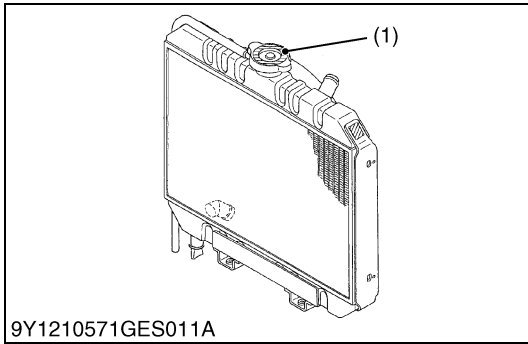
(3) Clamp

9Y1210571GEG0012US0

Cleaning Fuel Tank Inside (for Gasoline Fuel)

1. Following the unit / machine's operators manual, drain the gasoline fuel in the fuel tank.
2. Clean the fuel tank inside.

9Y1210318GEG0037US0



Cleaning Water Jacket and Radiator Interior

CAUTION

- Do not remove the radiator cap when the engine is hot. Then loosen cap slightly to the stop to relieve any excess pressure before removing cap completely.

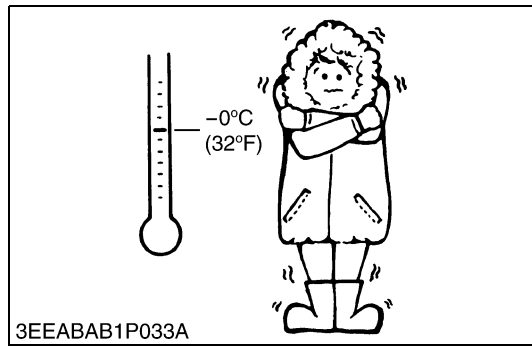
1. Stop the engine and let cool down.
2. To drain the coolant, open the radiator drain plug (2) and remove the radiator cap (1). Then radiator cap (1) must be removed to completely drain the coolant. And open the drain cock (3) of engine body.
3. After all coolant is drained, close the drain plug.
4. Fill with clean water and cooling system cleaner.
5. Follow directions of the cleaner instruction.
6. After flushing, fill with clean water and anti-freeze until the coolant level is just below the port. Install the radiator cap (1) securely.
7. Fill with coolant up to **FULL "A"** mark on the recovery tank (4).
8. Start and operate the engine for few minutes.
9. Stop the engine and let cool. Check coolant level of recovery tank (4) and add coolant if necessary.

IMPORTANT

- Do not start engine without coolant.
- Use clean, fresh, soft water and anti-freeze to fill the radiator and recovery tank.
- When the anti-freeze is mixed with fresh, soft water, the anti-freeze mixing ratio must be less than 50 %.
- Securely tighten radiator cap. If the cap is loose or improperly fitted, water may leak out and the engine could overheat.

- | | |
|-------------------|---------|
| (1) Radiator Cap | A: FULL |
| (2) Drain Plug | B: LOW |
| (3) Drain Cock | |
| (4) Recovery Tank | |

9Y1210661GEG0017US0



Anti-Freeze

- There are two types of anti-freeze available: use the permanent type (PT) for this engine.
- Before adding anti-freeze for the first time, clean the radiator interior by pouring fresh, soft water and draining it a few times.
- The procedure for mixing water and anti-freeze differs according to the make of the anti-freeze and the ambient temperature. Basically, it should be referred to SAE J1034 standard, more specifically also to SAE J814c.
- Mix the anti-freeze with fresh, soft water, and then fill into the radiator.

■ IMPORTANT

- **When the anti-freeze is mixed with fresh, soft water, the anti-freeze mixing ratio must be less than 50 %.**

Vol % anti-freeze	Freezing point		Boiling point*	
	°C	°F	°C	°F
40	-24	-11	106	223
50	-37	-35	108	226

* At 1.01×100000 Pa (760 mmHg) pressure (atmospheric). A higher boiling point is obtained by using a radiator pressure cap which permits the development of pressure within the cooling system.

■ NOTE

- **The above data represents industrial standards that necessitate a minimum glycol content in the concentrated anti-freeze.**
- **When the coolant level drops due to evaporation, add fresh, soft water only to keep the anti-freeze mixing ratio less than 50 %. In case of leakage, add anti-freeze and fresh, soft water in the specified mixing ratio.**
- **Anti-freeze absorbs moisture. Keep unused anti-freeze in a tightly sealed container.**
- **Do not use radiator cleaning agents when anti-freeze has been added to the coolant.**
(Anti-freeze contains an anti-corrosive agent, which will react with the radiator cleaning agent forming sludge which will affect the engine parts.)

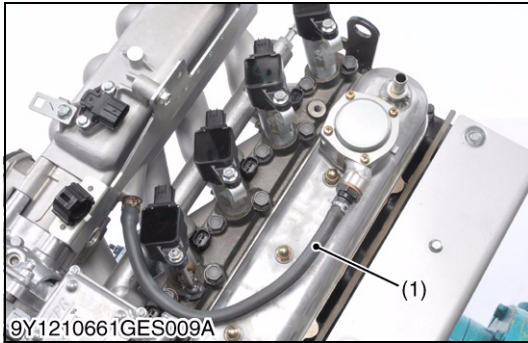
9Y1210318GEG0041US0

[9] CHECK POINTS OF EVERY 2 YEARS

Replacing Intake Air Line

1. Replace the intake hose and the clamps between the air cleaner and the electronic throttle body or gas mixer.

9Y1210661GEG0047US0



9Y1210661GES009A

Replacing Breather Hose

1. Replace the breather hose and the clamps between the head cover and the intake manifold.

- (1) Breather Hose

9Y1210661GEG0048US0

Replacing LPG Fuel Hose and Clamp Bands (WG1605-L-E3, WG1605-GL-E3)

1. Replace the fuel hose and the clamps.

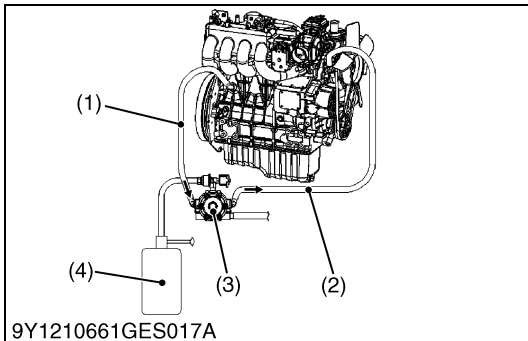
9Y1210661GEG0025US0

Replacing Coolant Hose of LPG Vaporizer (WG1605-L-E3, WG1605-GL-E3)

1. Connect the new coolant hose (1) and (2) to the vaporizer (3).
2. The coolant replenished to radiator, and bleed the air from the vaporizer (3).

- | | |
|------------------|---------------|
| (1) Coolant Hose | (3) Vaporizer |
| (2) Coolant Hose | (4) LPG Tank |

9Y1210661GEG0026US0

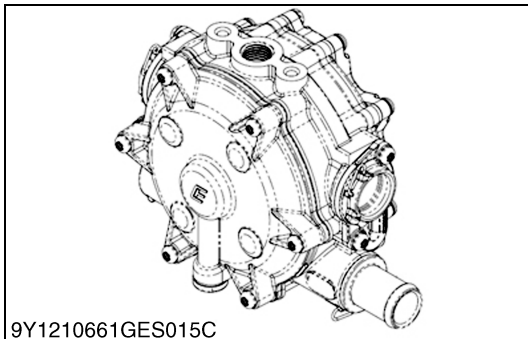


9Y1210661GES017A

Checking LPG Vaporizer (WG1605-L-E3, WG1605-GL-E3)

1. Make sure that any fuel leaks at the inlet and outlet fittings.
2. Make sure that the mounting bracket to insure the vaporizer is securely mounted.

9Y1210661GEG0041US0



9Y1210661GES015C

Replacing Radiator Hoses and Clamp Bands

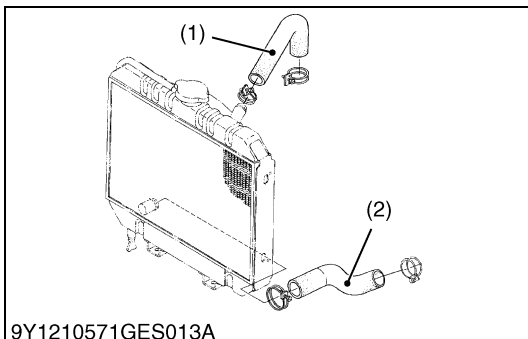
CAUTION

- Do not remove the radiator cap when the engine is hot. Then loosen cap slightly to the stop to relieve any excess pressure before removing cap completely.

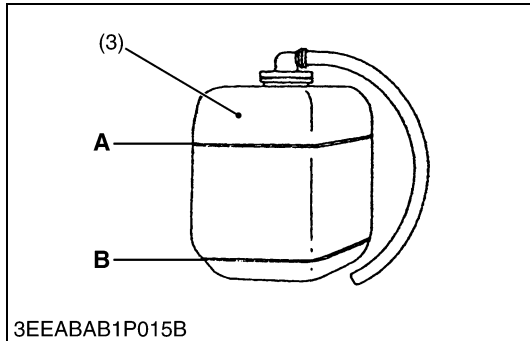
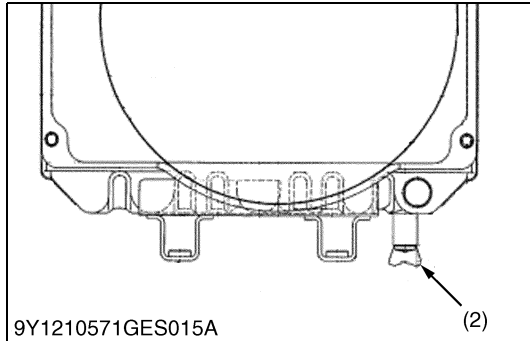
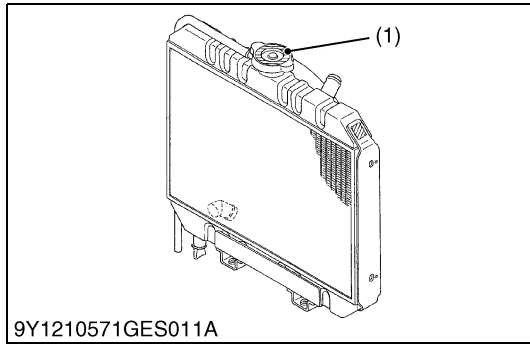
1. Drain the coolant.
2. Loosen the clamp bands.
3. Remove the upper hose (1) and lower hose (2).
4. Replace new upper / lower hose (1), (2) and clamp bands.
5. Tighten the clamp bands.
6. Fill with clean water and anti-freeze until the coolant level is just below the port. Install the radiator cap securely.

- | | |
|----------------|----------------|
| (1) Upper Hose | (2) Lower Hose |
|----------------|----------------|

9Y1210571GEG0042US0



9Y1210571GES013A



Changing Radiator Coolant (L.L.C.)

⚠ CAUTION

- **Do not remove the radiator cap when the engine is hot. Then loosen cap slightly to the stop to relieve any excess pressure before removing cap completely.**
1. Stop the engine and let cool down.
 2. To drain the coolant, open the radiator drain plug (2) and remove the radiator cap (1). Then radiator (1) must be removed to completely drain the coolant. And open the drain cock of engine body.
 3. After all coolant is drained, close the drain plug (2).
 4. Fill with clean water and cooling system cleaner.
 5. Follow directions of the cleaner instruction.
 6. After flushing, fill with clean water and anti-freeze until the coolant level is just below the port. Install the radiator cap (1) securely.
 7. Fill with coolant up to **FULL "A"** mark on the recovery tank (3).
 8. Start and operate the engine for few minutes.
 9. Stop the engine and let cool. Check coolant level of radiator and recovery tank (3) and add coolant if necessary.

■ IMPORTANT

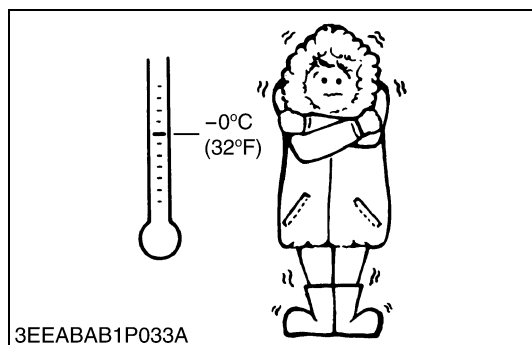
- **Do not start engine without coolant.**
- **Use clean, fresh, soft water and anti-freeze to fill the radiator and recovery tank.**
- **When the anti-freeze is mixed with fresh, soft water, the anti-freeze mixing ratio must be less than 50 %.**
- **Securely tighten radiator cap. If the cap is loose or improperly fitted, water may leak out and the engine could overheat.**

- (1) Radiator Cap
 (2) Drain Plug
 (3) Recovery Tank

- A: Full
 B: Low

(To be continued)

(Continued)



(Anti-freeze)

- There are two types of anti-freeze available; use the permanent type (PT) for this engine.
- Before adding anti-freeze for the first time, clean the radiator interior by pouring fresh, soft water and drain it a few times.
- The procedure for mixing water and anti-freeze differs according to the make of the anti-freeze and the ambient temperature. Basically, it should be referred to SAE J1034 standard, more specifically also to SAE J814c.
- Mix the anti-freeze with fresh, soft water, and then fill into the radiator.

■ **IMPORTANT**

- **When the anti-freeze is mixed with fresh, soft water, and anti-freeze mixing ratio must be less than 50 %.**

Vol % anti-freeze	Freezing point		Boiling point*	
	°C	°F	°C	°F
40	-24	-11	106	223
50	-37	-35	108	226

* At 1.01 x 100000 Pa (760 mmHg) pressure (atmospheric). A higher boiling point is obtained by using a radiator pressure cap which permits the development of pressure within the cooling system.

■ **NOTE**

- The above data represents industrial standards that necessitate a minimum glycol content in the concentrated anti-freeze.
- When the coolant level drops due to evaporation, add fresh, soft water only to keep the anti-freeze mixing ratio less than 50 %. In case of leakage, add anti-freeze and fresh, soft water in the specified mixing ratio.
- Anti-freeze absorbs moisture. Keep unused anti-freeze in a tightly sealed container.
- Do not use radiator cleaning agents when anti-freeze has been added to the coolant.
(Anti-freeze contains an anti-corrosive agent, which will react with the radiator cleaning agent forming sludge which will affect the engine parts.)

9Y1210571GEG0043US0

Replacing Battery

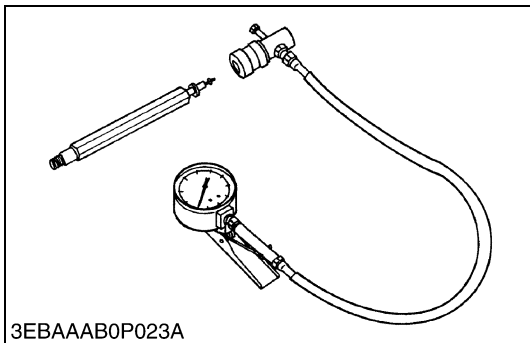


CAUTION

- **When the battery is being activated, hydrogen and oxygen gases in the battery are extremely explosive. Keep open sparks and flames away from the battery at all times, especially when charging the battery.**
 - **When charging battery, remove battery vent plugs.**
 - **When disconnecting the cable from the battery, start with the negative terminal first. When connecting the cable to the battery, start with the positive terminal first.**
 - **Never check battery charge by placing a metal object across the posts.**
1. Disconnect the negative terminal and positive terminal.
 2. Remove the battery holder.
 3. Remove the used battery.
 4. Replace the new battery.
 5. Tighten the battery holder.
 6. Connect the positive terminal.
 7. Connect the negative terminal.

9Y1210318GEG0058US0

5. SPECIAL TOOLS



3EBAAAB0P023A

Compression Tester

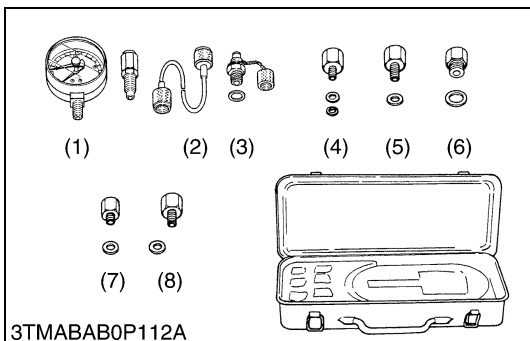
Code No.

- 07909-30251

Application

- Use to measure gasoline engine compression and diagnose the engine for a major overhaul.

WSM000001GEG0088US0



3TMABAB0P112A

Oil Pressure Tester

Code No.

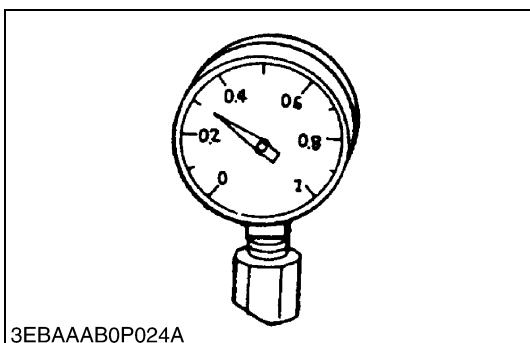
- 07916-32032

Application

- Use to measure lubricating oil pressure.

- | | |
|--------------------|---------------|
| (1) Gauge | (5) Adaptor 2 |
| (2) Cable | (6) Adaptor 3 |
| (3) Threaded Joint | (7) Adaptor 4 |
| (4) Adaptor 1 | (8) Adaptor 5 |

WSM000001GEG0015US0



3EBAAAB0P024A

Pressure Gauge

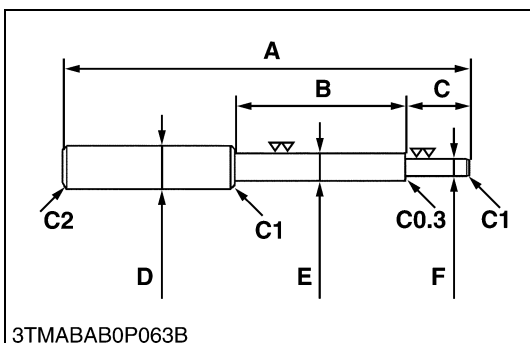
Specification

- 1745 kPa (17.79 kg/cm², 253.1 psi)

Application

- Check the pressure of vaporizer.

9Y1210661GEG0049US0



3TMABAB0P063B

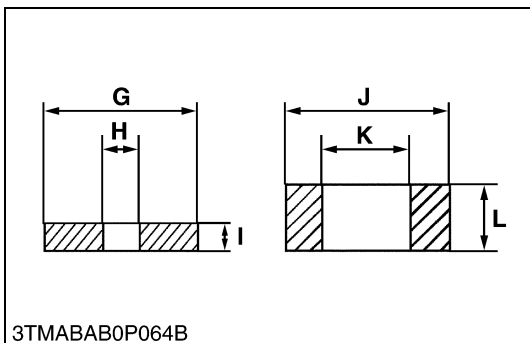
Valve Guide Replacing Tool

Application

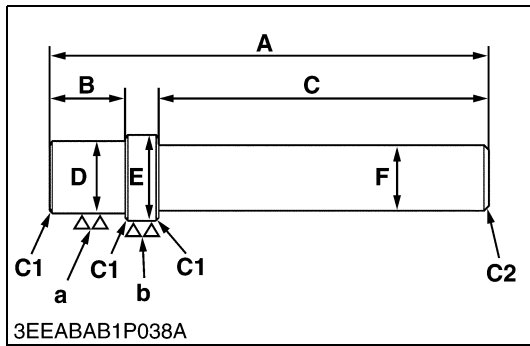
- Use to press out and press fit the valve guide.

A	225 mm (8.86 in.)
B	70 mm (2.8 in.)
C	45 mm (1.8 in.)
D	20 mm dia. (0.79 in. dia.)
E	11.7 to 11.9 mm dia. (0.461 to 0.468 in. dia.)
F	6.50 to 6.60 mm dia. (0.256 to 0.259 in. dia.)
G	25 mm dia. (0.98 in. dia.)
H	6.70 to 7.00 mm dia. (0.264 to 0.275 in. dia.)
I	5.0 mm (0.20 in.)
J	20 mm dia. (0.79 in. dia.)
K	12.5 to 12.8 mm dia. (0.493 to 0.503 in. dia.)
L	8.90 to 9.10 mm (0.351 to 0.358 in.)
C1	Chamfer 1.0 mm (0.039 in.)
C2	Chamfer 2.0 mm (0.079 in.)
C0.3	Chamfer 0.3 mm (0.01 in.)

9Y1210661GEG0031US0



3TMABAB0P064B



Bushing Replacing Tool

Application

- Use to press out and press fit the bushing.

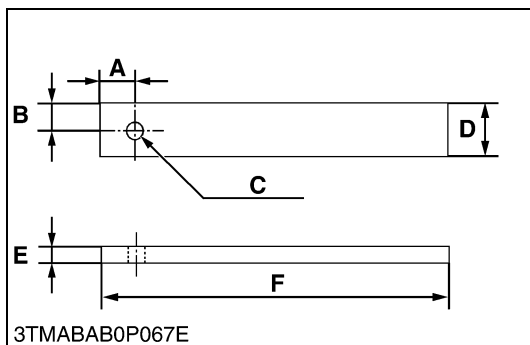
[For small end bushing]

A	157 mm (6.18 in.)
B	24 mm (0.94 in.)
C	120 mm (4.72 in.)
D	21.8 to 21.9 mm dia. (0.859 to 0.862 in. dia.)
E	24.8 to 24.9 mm dia. (0.977 to 0.980 in. dia.)
F	20 mm dia. (0.79 in. dia.)
a	6.3 μm (250 μin.)
b	6.3 μm (250 μin.)
C1	Chamfer 1.0 mm (0.039 in.)
C2	Chamfer 2.0 mm (0.079 in.)

[For idle gear bushing]

A	196 mm (7.72 in.)
B	26 mm (1.0 in.)
C	150 mm (5.91 in.)
D	25.80 to 25.90 mm dia. (1.016 to 1.019 in. dia.)
E	28.80 to 28.90 mm dia. (1.134 to 1.137 in. dia.)
F	20 mm dia. (0.79 in. dia.)
a	6.3 μm (250 μin.)
b	6.3 μm (250 μin.)
C1	Chamfer 1.0 mm (0.039 in.)
C2	Chamfer 2.0 mm (0.079 in.)

9Y1210661GEG0032US0



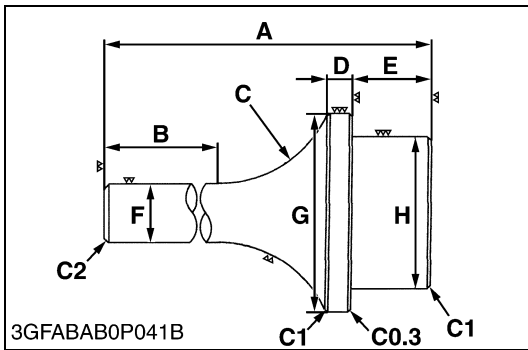
Flywheel Stopper

Application

- Use to loosen and tighten the flywheel screw.

A	20 mm (0.79 in.)
B	15 mm (0.59 in.)
C	10 mm dia. (0.39 in. dia.)
D	30 mm (1.2 in.)
E	8.0 mm (0.31 in.)
F	200 mm (7.87 in.)

9Y1210661GEG0036US0



Crankshaft Bearing 1 Replacing Tool

Application

- Use to press out and press fit the crankshaft bearing 1.

[Press out]

A	135 mm (5.31 in.)
B	72 mm (2.8 in.)
C	40 mm radius (1.6 in. radius)
D	10 mm (0.39 in.)
E	24 mm (0.94 in.)
F	20 mm dia. (0.79 in. dia.)
G	51.20 to 51.40 mm dia. (2.016 to 2.023 in. dia.)
H	47.30 to 47.50 mm dia. (1.863 to 1.870 in. dia.)
C1	Chamfer 1.0 mm (0.039 in.)
C2	Chamfer 2.0 mm (0.079 in.)
C0.3	Chamfer 0.30 mm (0.012 in.)

[Press fit]

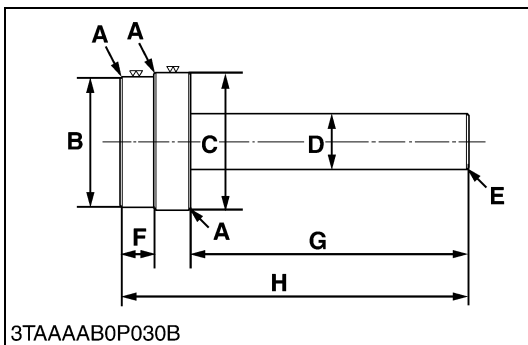
A	135 mm (5.31 in.)
B	72 mm (2.8 in.)
C	40 mm radius (1.6 in. radius)
D	10 mm (0.39 in.)
E	24 mm (0.94 in.)
F	20 mm dia. (0.79 in. dia.)
G	68 mm dia. (2.7 in. dia.)
H	47.30 to 47.50 mm dia. (1.863 to 1.870 in. dia.)
C1	Chamfer 1.0 mm (0.039 in.)
C2	Chamfer 2.0 mm (0.079 in.)
C0.3	Chamfer 0.30 mm (0.012 in.)

9Y1210661GEG0034US0

Governor Gear Holder Bushing Replacing Tool

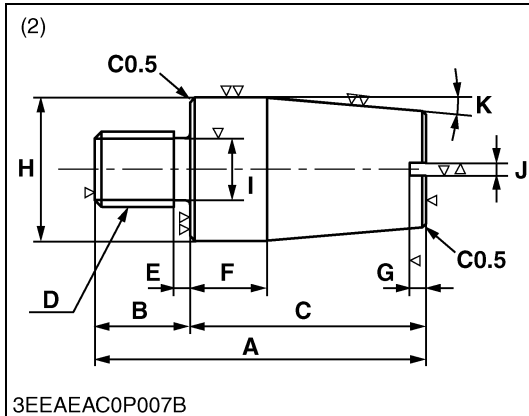
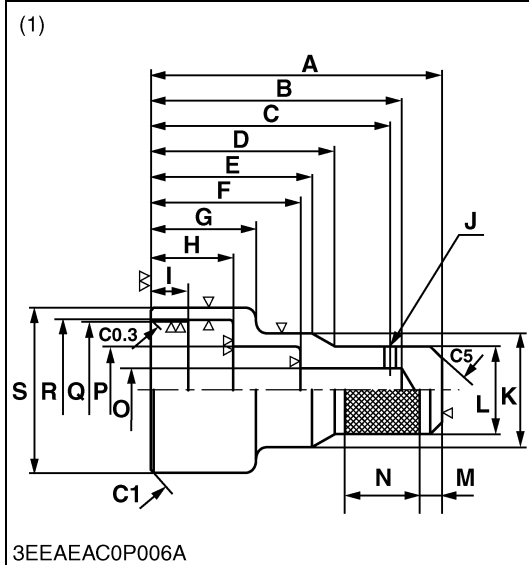
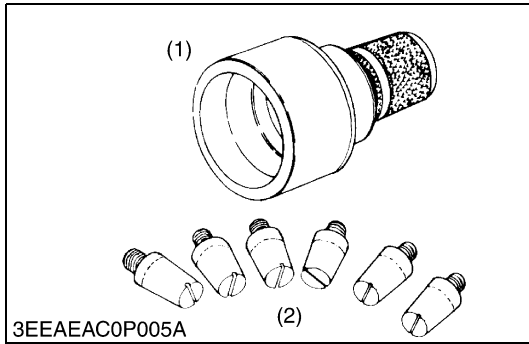
Application

- Use to press out and to press fit the governor gear holder bushing.



A	C1: Chamfer 1.0 mm (0.039 in.)
B	73.90 to 74.00 mm dia. (2.910 to 2.913 in. dia.)
C	69.80 to 69.90 mm dia. (2.748 to 2.751 in. dia.)
D	30 mm dia. (1.2 in. dia.)
E	C2: Chamfer 2.0 mm (0.079 in.)
F	18 mm (0.71 in.)
G	150 mm (5.91 in.)
H	188 mm (7.40 in.)

9Y1210661GEG0033US0



Crank Sleeve Setter

Application

- Use to fix the crankshaft sleeve.

(1) Auxiliary socket for pushing

A	130 mm (5.12 in.)
B	112 mm (4.41 in.)
C	107 mm (4.21 in.)
D	82 mm (3.2 in.)
E	72 mm (2.8 in.)
F	67 mm (2.6 in.)
G	47 mm (1.8 in.)
H	36.00 to 36.20 mm (1.418 to 1.425 in.)
I	17 mm (0.67 in.)
J	5.0 mm dia. (0.20 in. dia.)
K	52 mm dia. (2.0 in. dia.)
L	40 mm dia. (1.6 in. dia.)
M	10 mm (0.39 in.)
N	33 mm (1.3 in.)
O	20 mm dia. (0.79 in. dia.)
P	40 mm dia. (1.6 in. dia.)
Q	72.10 to 72.15 mm dia. (2.839 to 2.840 in. dia.)
R	73 mm dia. (2.9 in. dia.)
S	83 mm dia. (3.3 in. dia.)
C0.3	Chamfer 0.30 mm (0.012 in.)
C1	Chamfer 1.0 mm (0.039 in.)
C5	Chamfer 5.0 mm (0.20 in.)

(2) Sleeve guide

A	42 mm (1.7 in.)
B	12 mm (0.47 in.)
C	30 mm (1.2 in.)
D	M10 × Pitch 1.25
E	2.0 mm (0.079 in.)
F	10 mm (0.39 in.)
G	2.0 mm (0.079 in.)
H	17.90 to 17.95 mm dia. (0.7048 to 0.7066 in. dia.)
I	8.0 mm dia. (0.31 in. dia.)
J	1.8 mm (0.071 in.)
K	0.09 rad (5 °)
C0.5	Chamfer 0.5 mm (0.02 in.)

9Y1210661GEG0035US0

1 ENGINE

MECHANISM

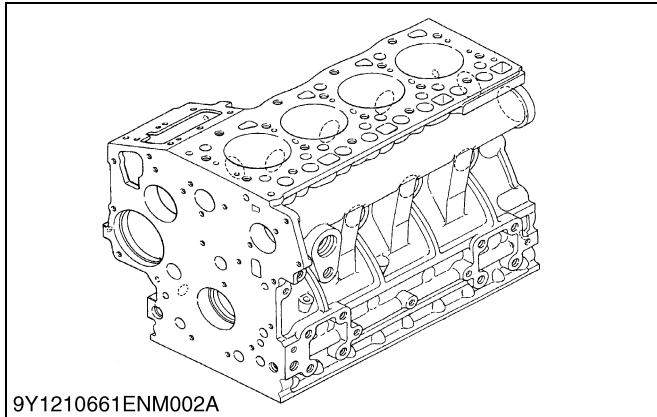
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1. ENGINE BODY

[1] CYLINDER BLOCK

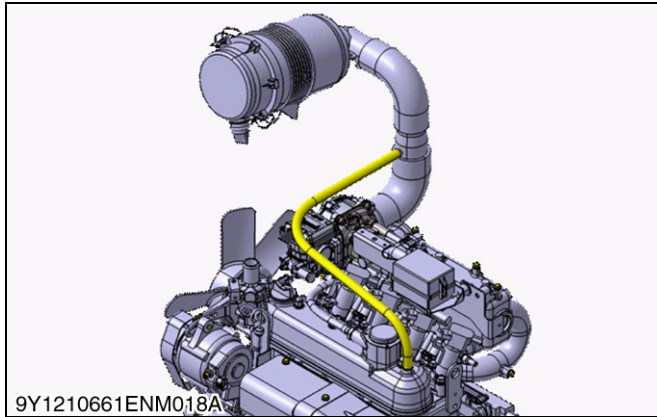


The engine has a high durability tunnel-type cylinder block in which the crank bearing component is a constructed body. Furthermore, liner less type, allow effective cooling, less distortion, and greater wear resistance. The noise level is reduced to a minimum because each cylinder has its own chamber.

To increase the rigidity of the cylinder block, parts of engine block which support main bearing case has thicker rib for additional rigidity to improve noise and vibration.

9Y1210661ENM001US0

[2] POSITIVE CRANKCASE VENTILATION (PCV) SYSTEM

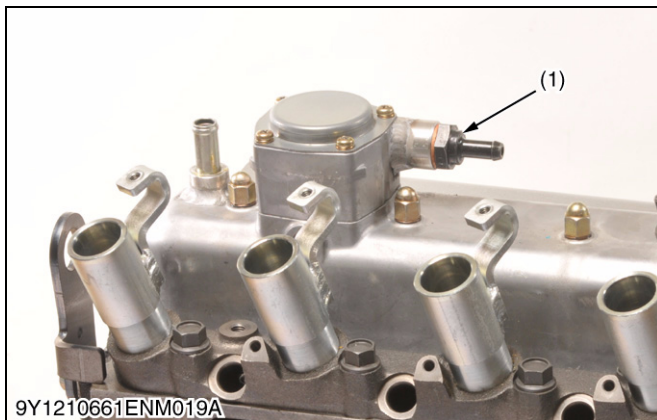


During normal compression stroke, a small amount of gases in the combustion chamber escapes past the piston. Approximately 70 % of these blowby gases are unburned fuel (HC) that can dilute and contaminate the engine oil, cause corrosion to critical parts, and contribute to sludge build up.

The purpose of the Positive Crankcase Ventilation (PCV) system is to remove these harmful gases from the crankcase before damage occurs and combine them with the engine's normal incoming air / fuel charge.

9Y1210661ENM0014US0

[3] PCV VALVE



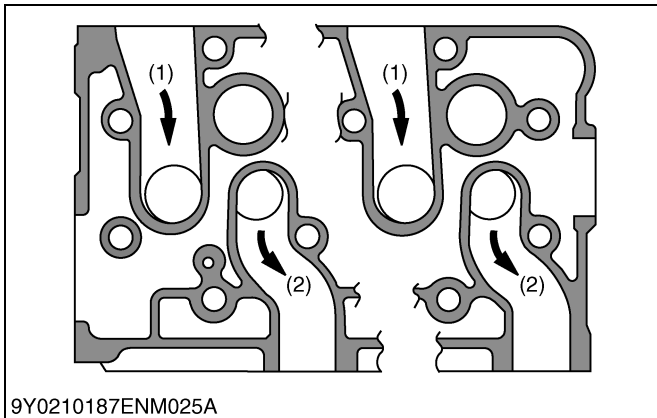
The PCV valve consists of a spring and a valve, and it is installed between an engine body and an intake manifold.

The PCV valve controls the inhalation volume of blow-by gas and the volume of fresh air according to the engine operation status.

(1) PCV Valve

9Y1210661ENM0015US0

[4] CYLINDER HEAD



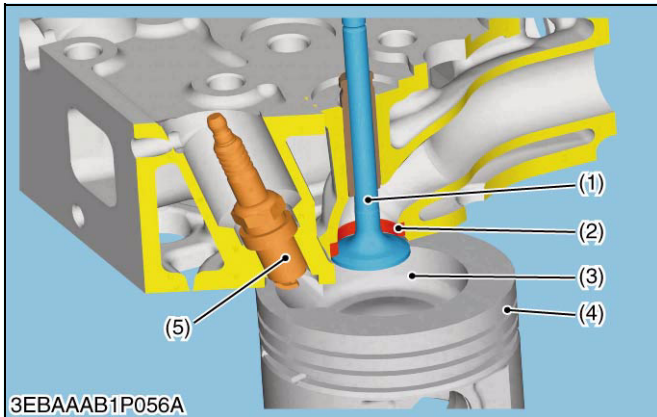
9Y0210187ENM025A

Intake and Exhaust Port

The cross-flow type intake / exhaust ports, which lower the heat conduction from the exhaust port to the intake port. The low heat conduction keeps the intake air from being heated and expanded by the exhaust gas.

- (1) Intake Port
- (2) Exhaust Port

9Y1210661ENM0027US0



3EBAAAB1P056A

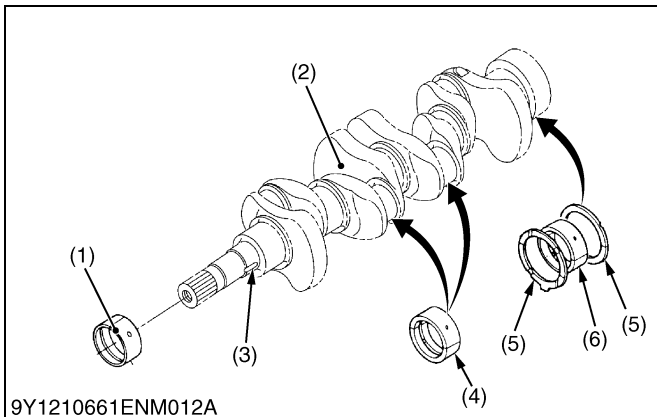
Combustion System

The Spark Ignition type combustion chamber, compactly placed on top of the piston head, successfully reduces emissions. To ensure even more reliable emission life, the intake / exhaust valve seats are fitted with special heat resistant stellite alloys.

- (1) Valve
- (2) Valve Seat
- (3) Main Combustion Chamber
- (4) Piston
- (5) Spark Plug

9Y1210318ENM0004US0

[5] CRANKSHAFT



9Y1210661ENM012A

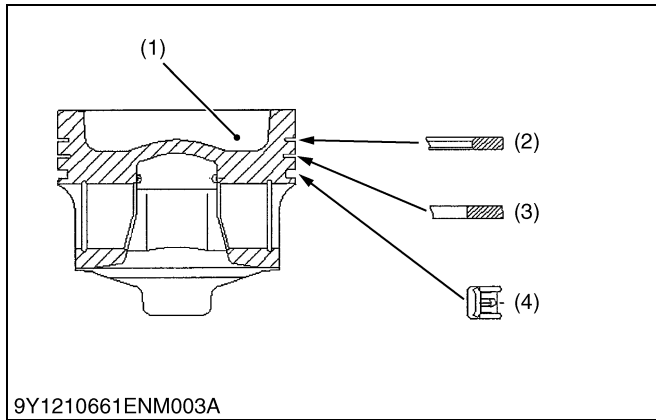
The crankshaft with the connecting rod converts the reciprocating motion of the piston into rotating motion. The crankshaft (2) has oil passages drilled so that oil can flow from the main bearings to the crank pin bearings.

The front journal is supported by a sleeve type bearing (crankshaft bearing 1) (1), the intermediate journal by a split type (crankshaft bearing 3) (4), and the rear by a split type (crankshaft bearing 2) (6) with thrust bearings (5).

- (1) Crankshaft Bearing 1
- (2) Crankshaft
- (3) Feather Key
- (4) Crankshaft Bearing 3
- (5) Thrust Bearing
- (6) Crankshaft Bearing 2

9Y1210661ENM0011US0

[6] PISTON AND PISTON RING



Piston and Piston Ring

The piston has a slightly oval shape when cold (in consideration of thermal expansion) and a concave head.

Top Ring:

The top ring is of plain barrel face type. The barrel face type has an arc sliding surface easy to run in and prevents abnormal wears by providing a maintained oil film against the lined wall.

Second Ring:

For the second ring, the tapered outer surface area that comes in contact with the lined wall is reduced to obtain a high surface pressure for the prevention of gas leakage, compression leakage and oil spillage.

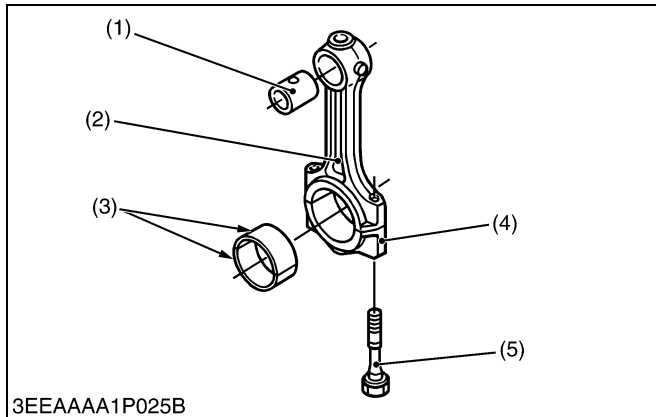
Oil Ring:

Oil ring consists of three steel components, that is upper and lower rails and one spacer being held between two rails. This function is particularly effective in preventing oil-up because of high boost at the time of engine coasting.

- | | |
|------------------------|-----------------|
| (1) Combustion Chamber | (3) Second Ring |
| (2) Top Ring | (4) Oil Ring |

9Y1210661ENM0002US0

[7] CONNECTING ROD

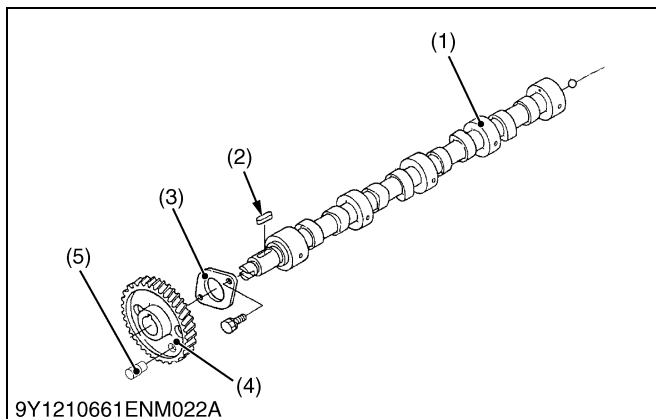


The connecting rod (2) is used to connect the piston with the crankshaft. The big end of the connecting rod has a crankpin bearing (3) (split type) and the small end has a small end bushing (1) (solid type).

- | | |
|-----------------------|--------------------------|
| (1) Small End Bushing | (4) Connecting Rod Cap |
| (2) Connecting Rod | (5) Connecting Rod Screw |
| (3) Crankpin Bearing | |

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[8] CAMSHAFT



The camshaft (1) is made of special cast iron, and the journal and cam sections are chilled to resist wear.

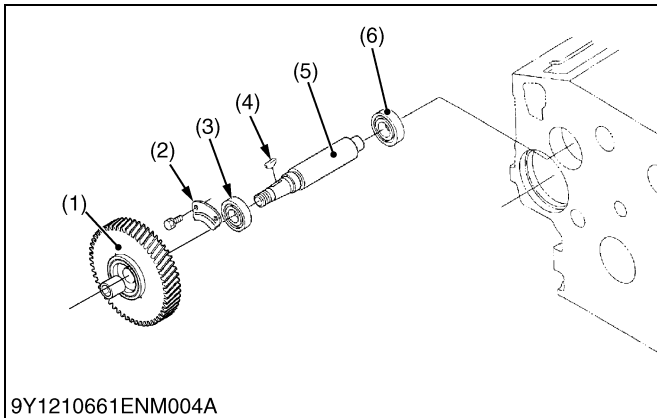
The cams on the camshaft cause the intake and exhaust valves to open as the camshaft rotates. The bearing and journals are force-lubricated.

A rotation detective pin is attached to the cam gear.

- | | |
|----------------------|--------------|
| (1) Camshaft | (4) Cam Gear |
| (2) Feather Key | (5) Pin |
| (3) Camshaft Stopper | |

9Y1210661ENM0029US0

[9] GEAR SHAFT



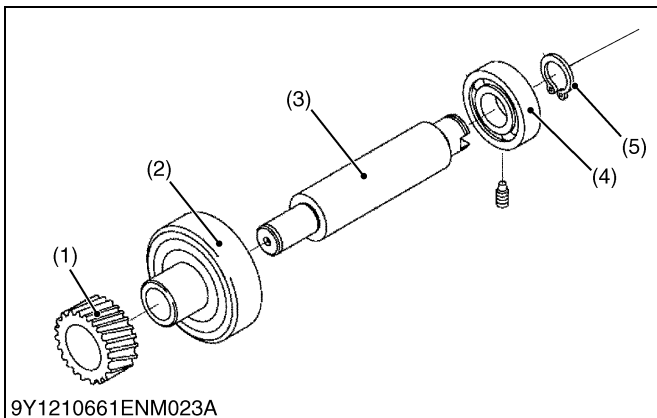
9Y1210661ENM004A

The gear shaft is a shaft that was changed from the fuel camshaft for 05-E3B engine to the shaft with no cam.

- | | |
|-------------------------|------------------|
| (1) Injection Pump Gear | (4) Feather key |
| (2) Stopper | (5) Gear shaft |
| (3) Ball Bearing | (6) Ball Bearing |

9Y1210661ENM009US0

[10] PTO SHAFT



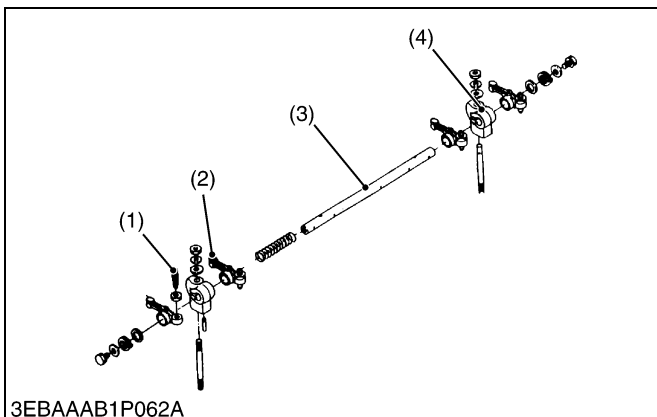
9Y1210661ENM023A

It is possible to takeoff the power of hydraulic pump drive from the PTO shaft.

- | | |
|--------------------------|---------------|
| (1) Governor Gear | (4) Bearing |
| (2) Governor Gear Holder | (5) Snap Ring |
| (3) PTO Shaft | |

9Y1210661ENM0031US0

[11] ROCKER ARM ASSEMBLY



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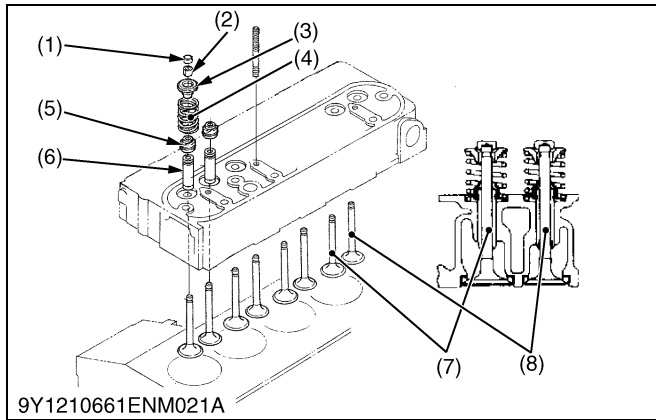
The rocker arm assembly includes the rocker arms (2) and adjusting screws (1), the end of which rests on the push rods, rocker arm brackets (4) and rocker arm shaft (3).

The rocker arms swing and transmits the reciprocating motion of the push rods to the inlet and exhaust valves to open and close them.

- | | |
|---------------------|------------------------|
| (1) Adjusting Screw | (3) Rocker Arm Shaft |
| (2) Rocker Arm | (4) Rocker Arm Bracket |

9Y1210318ENM0012US0

[12] INLET AND EXHAUST VALVES



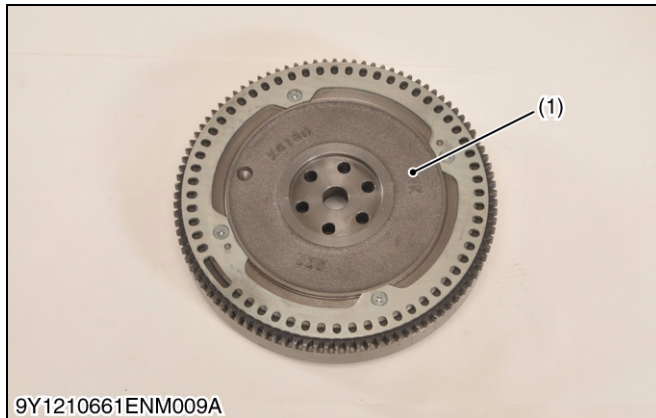
The valve and its guide for the inlet are different from those for the exhaust.

Other parts, such as the spring (4), spring retainer (3), collet (2), stem seal (5), and cap (1) are the same for both the inlet and exhaust.

- | | |
|---------------------|-------------------|
| (1) Valve Cap | (5) Stem Seal |
| (2) Collet | (6) Valve Guide |
| (3) Spring Retainer | (7) Inlet Valve |
| (4) Spring | (8) Exhaust Valve |

9Y1210661ENM0028US0

[13] FLYWHEEL



The flywheel (1) is connected with the crankshaft, it stores the rotating force in the combustion stroke as inertial energy to rotate the crankshaft smoothly.

The flywheel periphery is provided with marks showing fuel injection timing and top dead center.

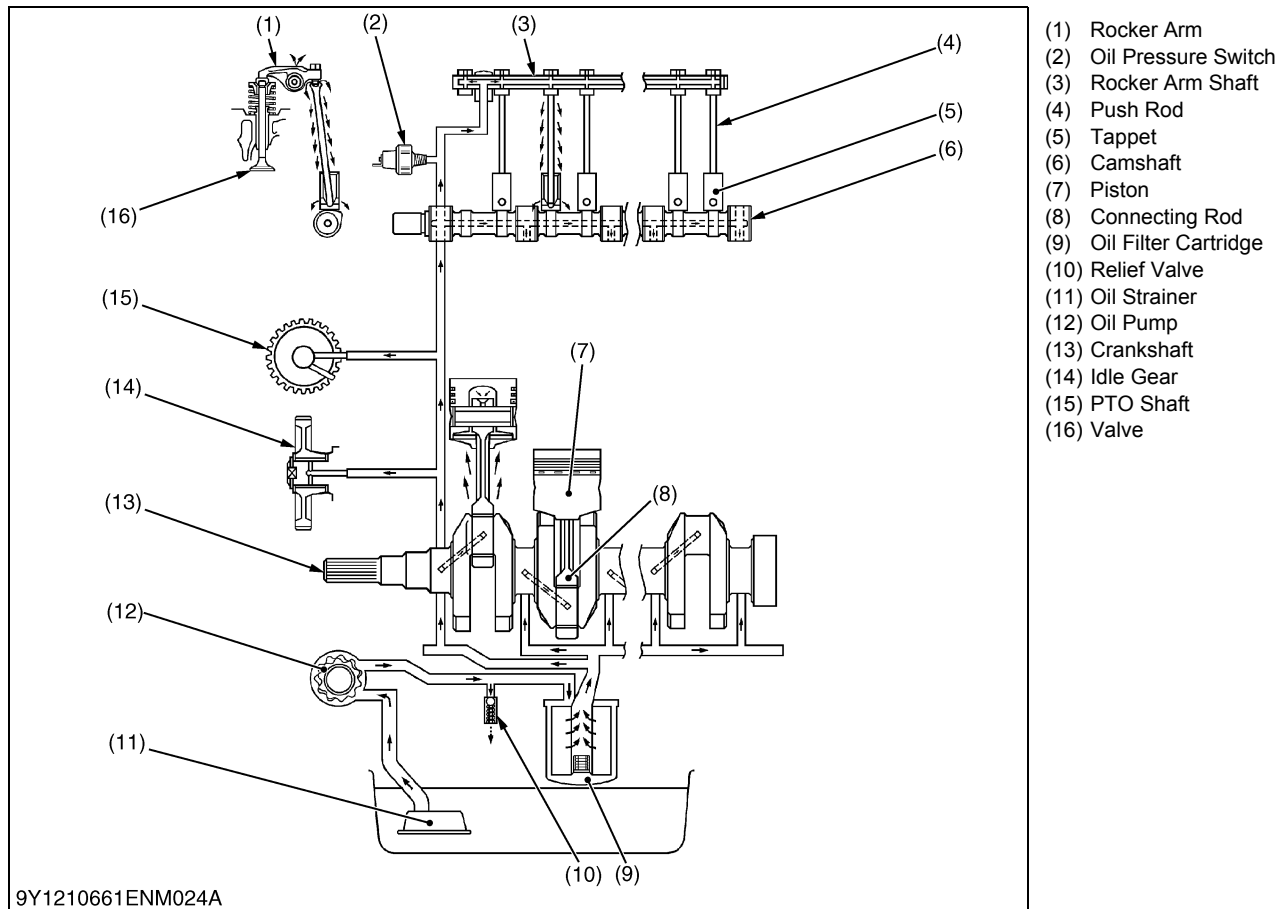
The flywheel has gear teeth around its outer rim, which mesh with the drive pinion of the starter. Also, a rotor for determining the ignition timing is attached to the flywheel.

- (1) Flywheel

9Y1210661ENM0032US0

2. LUBRICATING SYSTEM

[1] GENERAL



- (1) Rocker Arm
- (2) Oil Pressure Switch
- (3) Rocker Arm Shaft
- (4) Push Rod
- (5) Tappet
- (6) Camshaft
- (7) Piston
- (8) Connecting Rod
- (9) Oil Filter Cartridge
- (10) Relief Valve
- (11) Oil Strainer
- (12) Oil Pump
- (13) Crankshaft
- (14) Idle Gear
- (15) PTO Shaft
- (16) Valve

Engine lubricating system may be classified as:

- Full pressure feed type
- Pressure feed and splash type

KUBOTA engines have lubricating system of full pressure feed type.

This system consists of an oil strainer (11), oil pump (12), relief valve (10), oil filter cartridge (9) and oil pressure switch (2).

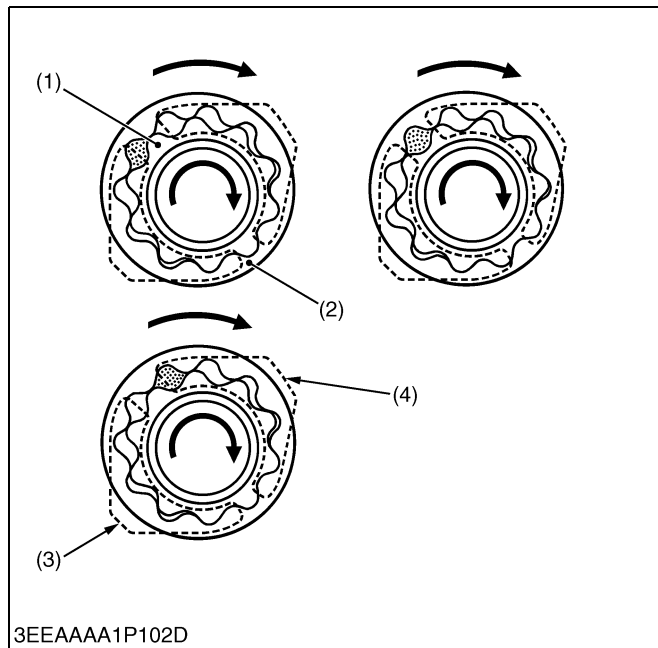
The oil pump sucks lubricating oil from the oil pan through the oil strainer and the oil flows down to the oil filter, cartridge where it is further filtered. Then the oil is forced to crankshaft (13), connecting rods (8), idle gear (14), PTO shaft (15), camshaft (6) and rocker arm shaft (3) to lubricate each part through the oil gallery.

Some part of oil, splashed by the crankshaft or leaking and dropping from gaps of each part, lubricates following parts.

- Pistons (7)
- Cylinder walls
- Small ends of connecting rods
- Tappets (5)
- Push rods (4)
- Intake and exhaust valves (16)
- Timing gears

9Y1210661ENM0030US0

[2] OIL PUMP



This oil pump has an inner rotor (1) and an outer rotor (2).

The inner rotor (1), which is driven by crankshaft, rotates the outer rotor (2) in the same direction.

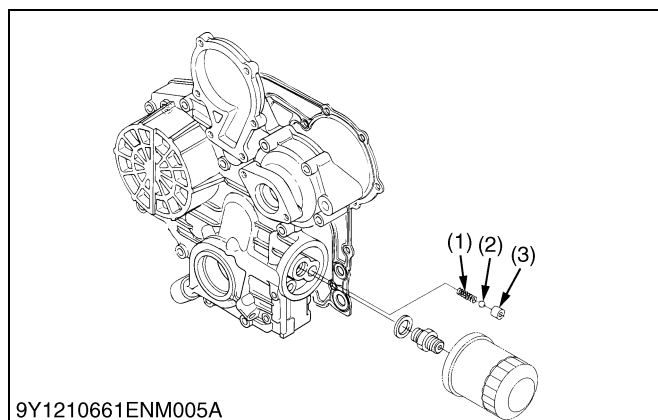
The inner rotor (1) has one less lobe than the outer rotor (2), and they are eccentrically engaged with each other.

This allows the other lobes to slide over the outer lobes, making a seal to prevent back-up of oil. As the lobes slide up and over the lobes on the outer rotor (2), oil is drawn in. As the lobes fall into the outer rotor's cavities, oil is squeezed out.

- (1) Inner Rotor
- (2) Outer Rotor
- (3) Inlet Port
- (4) Outlet Port

9Y1210661ENM0033US0

[3] RELIEF VALVE



The relief valve prevents the damage to the lubricating system due to the high pressure of the oil.

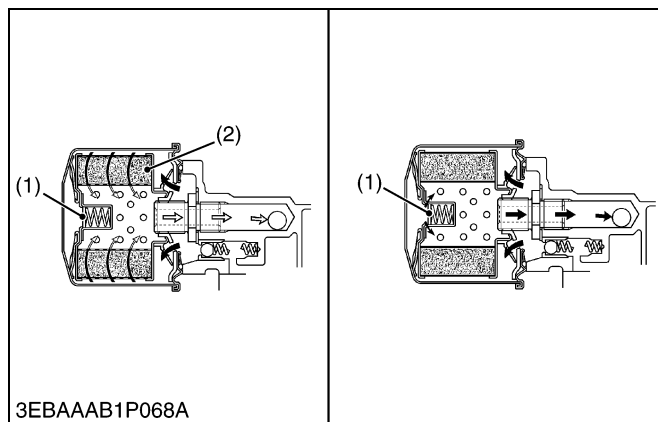
This relief valve is a ball direct acting type, and is best suited for low pressures.

When the pressure of the oil, forced by the pump, exceeds the specified value, the oil pushes back the ball (2) and escapes to the oil pan.

- (1) Spring
- (2) Ball
- (3) Valve Seat

9Y1210661ENM0005US0

[4] OIL FILTER CARTRIDGE



After lubricating, the lubricating oil brings back various particles of grit and dirt to the oil pan. Those particles and the impurities in the lubricating oil can cause wear or seizure of the engine parts. It may also impair the physical and chemical properties of the oil itself.

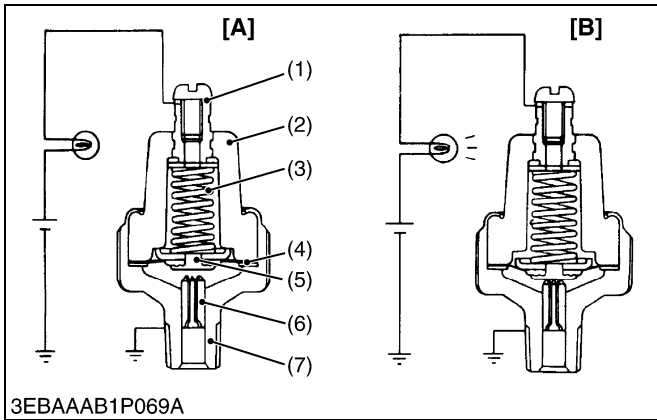
The lubricating oil which is force-fed by the pump, is filtered by the filter cartridge with the filter element (2).

When the filter element accumulates on excessive amount of dirt and the oil pressure in the inlet line builds up by 98 kPa (1.0 kgf/cm², 14 psi) more than the outlet line, the bypass valve (1) opens to allow the oil to flow from the inlet into the outlet line, bypassing the filter element.

- (1) Bypass Valve
- (2) Filter Element

9Y1210318ENM0019US0

[5] OIL PRESSURE SWITCH



The oil pressure switch is mounted on the cylinder block and is led to the lubricating oil passage.

When the oil pressure falls below the specified value, the oil pressure warning lamp lights.

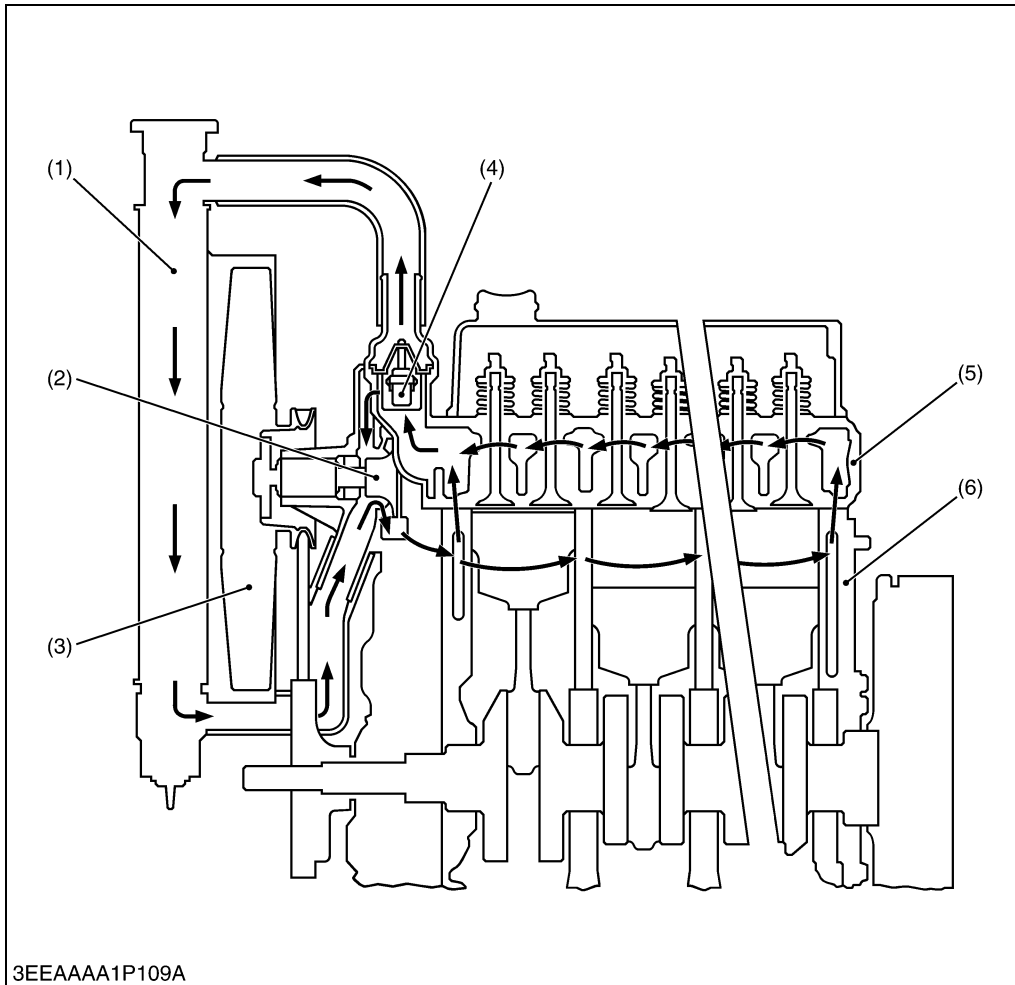
- (1) Terminal
- (2) Insulator
- (3) Spring
- (4) Rubber Gasket
- (5) Contact Rivet
- (6) Contact
- (7) Oil Switch Body

- [A] At the proper oil pressure**
- [B] At lower oil pressure,
50 kPa (0.5 kgf/cm², 7 psi)
or less**

9Y1210318ENM0020US0

3. COOLING SYSTEM

[1] GENERAL



- (1) Radiator
- (2) Water Pump
- (3) Cooling Fan
- (4) Thermostat
- (5) Cylinder Head
- (6) Cylinder Block

3EEAAA1P109A

The cooling system consists of a radiator (1), a centrifugal water pump (2), a cooling fan (3) and a thermostat (4). The coolant is cooled through the radiator core, and the fan behind the radiator pulls the cooling air through the core to improve cooling.

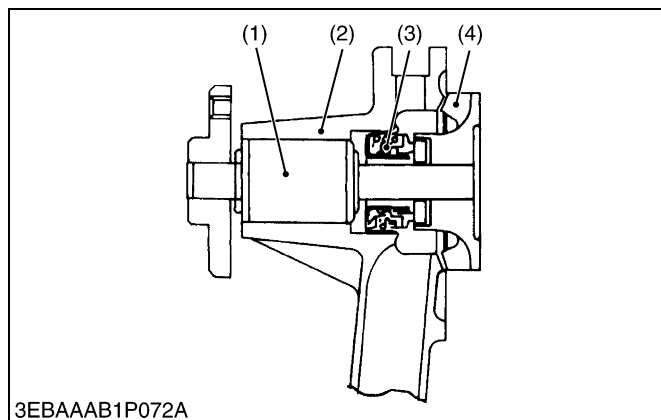
The water pump sucks the coolant from the radiator or from the cylinder head and forces it into the cylinder block.

The thermostat opens or closes according to the coolant temperature, to allow the coolant to flow from the cylinder block to the radiator while open, or only to the water pump while closed.

Thermostat's valve opening temperature	Factory specification	69.5 to 72.5 °C 157.1 to 162.5 °F
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[2] WATER PUMP



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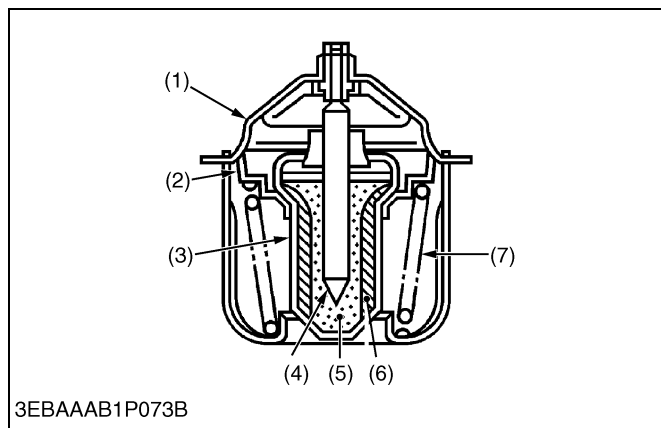
The water pump is driven by the crankshaft and a V belt. The rotating impeller (4) in the water pump sucks the coolant from the radiator and sends it into the water jacket in the cylinder block.

The mechanical seal (3) prevents the water from entering the bearing unit (1).

- | | |
|---------------------|---------------------|
| (1) Bearing Unit | (3) Mechanical Seal |
| (2) Water Pump Body | (4) Impeller |

9Y1210318ENM0023US0

[3] THERMOSTAT



3EBAAAB1P073B

The thermostat is of the wax pellet type.

The thermostat controls the flow of the coolant to the radiator to keep the proper temperature.

The case, which serves as a valve seat, has a spindle inserted in the pellet (3) which is installed to the valve (2). The spindle is covered with the synthetic rubber (5) in the pellet.

The wax is charged between the pellet and the rubber.

■ **At low temperature (lower than valve opening temperature (at beginning))**

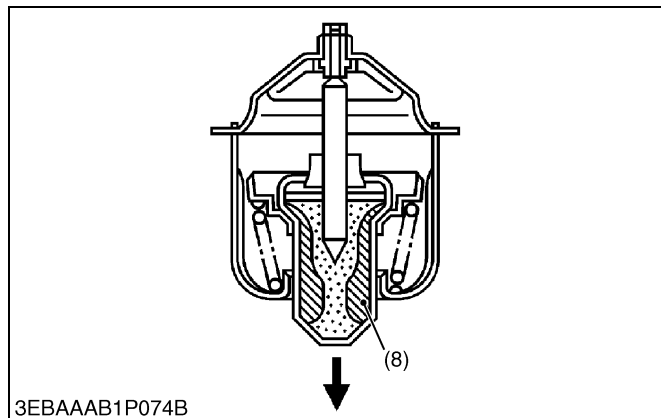
The valve (2) is seated by the spring (7) and the coolant circulates in the engine through the water return hose without running into the radiator. Only the air in the water jacket escapes to the radiator through the leak hole of the thermostat.

■ **At high temperature (higher than valve opening temperature (opened completely))**

As the coolant temperature rises, the wax in the pellet (3) turns liquid and expands, repelling the spindle, which causes the pellet to lower. The valve (2) opens to send the coolant to the radiator.

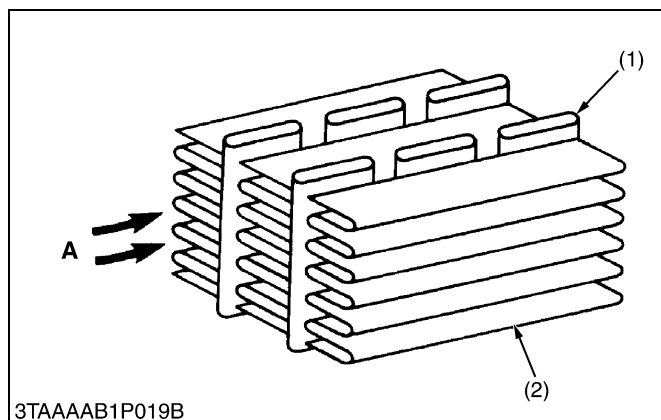
- | | |
|-------------|----------------------|
| (1) Seat | (5) Synthetic Rubber |
| (2) Valve | (6) Wax (Solid) |
| (3) Pellet | (7) Spring |
| (4) Spindle | (8) Wax (liquid) |

9Y1210571ENM0022US0



3EBAAAB1P074B

[4] RADIATOR



3TAAAAB1P019B

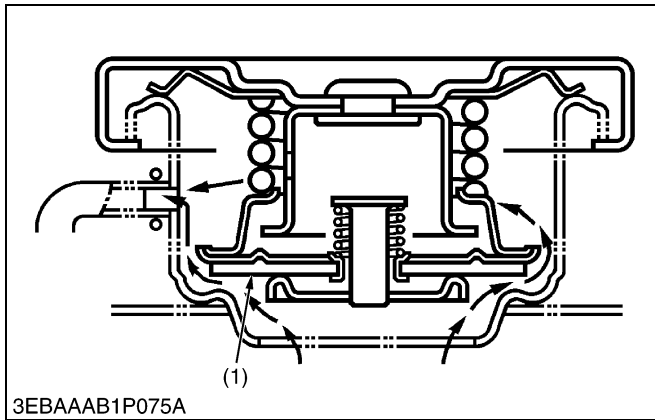
The radiator core consists of coolant carrying tubes (1) and fins (2) meeting at a right angle with the tubes. The fin is a louverless, corrugated type which is light in weight, high in heat exchange ratio and less apt to clog.

The coolant in the tubes is cooled by the air flowing through the tube walls and fins.

- | | |
|----------|-----------------------|
| (1) Tube | A: Cooling Air |
| (2) Fin | |

9Y1210318ENM0025US0

[5] RADIATOR CAP



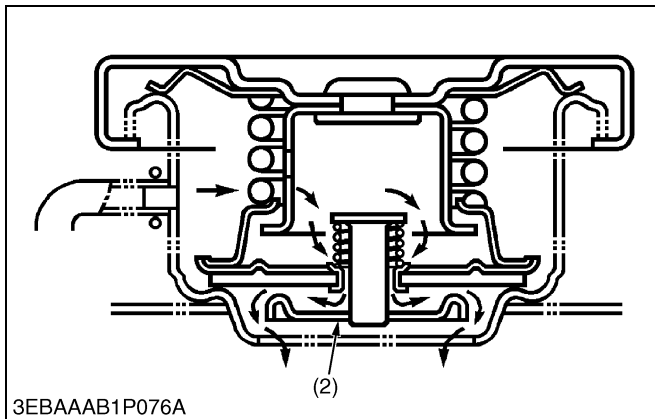
The pressure type radiator cap prevents differences in pressure between the inside and the outside of the radiator from deforming the radiator.

When the coolant temperature rises and the pressure in the radiator increases above the specified pressure, the pressure valve (1) opens to reduce the internal pressure.

When the coolant temperature falls and a vacuum forms in the radiator, the vacuum valve (2) opens to introduce the air into the radiator.

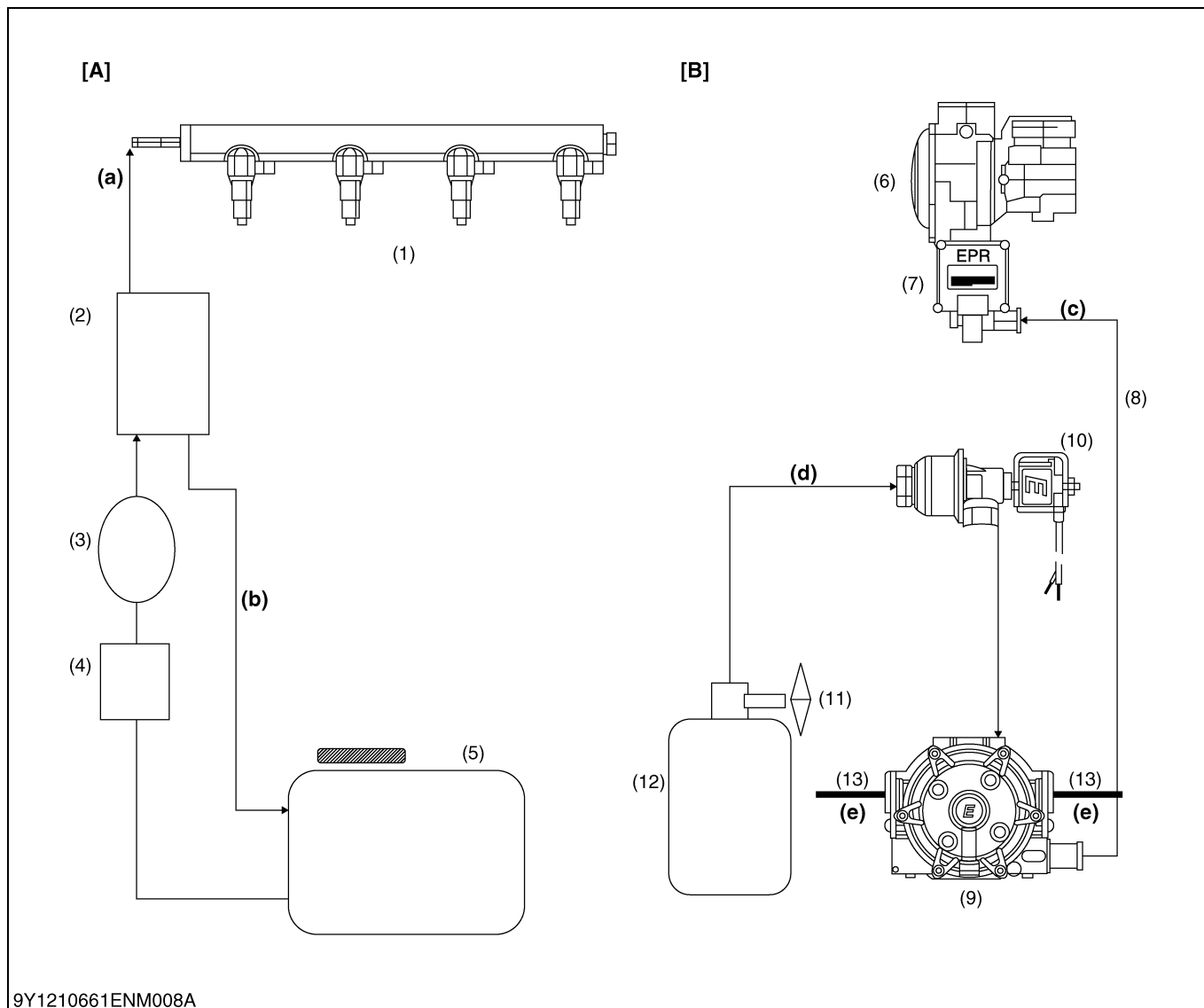
- (1) Pressure Valve (Opening pressure 88 kPa (0.90 kgf/cm², 13 psi)) (2) Vacuum Valve

9Y1210318ENM0026US0



4. FUEL SYSTEM

[1] GENERAL



- (1) Delivery Pipe
- (2) Fuel Pressure Manifold (FPM)
- (3) Fuel Pump
- (4) Fuel Filter
- (5) Gasoline Tank*
- (6) Mixer
- (7) Regulator (D-EPR)

- (8) Vapor Hose*
- (9) Vaporizer (DSR)
- (10) Lock Off Valve
- (11) LPG Manual Valve*
- (12) LPG Tank*
- (13) Coolant Hose*

[A] Gasoline Fuel
[B] LPG Fuel

- (a) Gasoline Line*
- (b) Bleed / Return Circuit*
- (c) Gaseous Propane Line*

- (d) Liquid Propane Line*
- (e) Hot Coolant Inlet or Outlet Line*

Component Marked * is Not Provided by KUBOTA

WG1605-G-E3:

The fuel is fed from the gasoline tank (5) through the fuel filter (4) to the delivery pipe (1) by the fuel pump (3).

WG1605-L-E3:

The LPG fuel stored in the LPG tank (12) is sent to vaporizer (9) by pressure in the gaseous phase in the tank through the lock off valve (10).

The LPG fuel is evaporated in vaporizer (9) and is sent to the regulator (7) as a gaseous fuel of gas pressure near the atmospheric pressure.

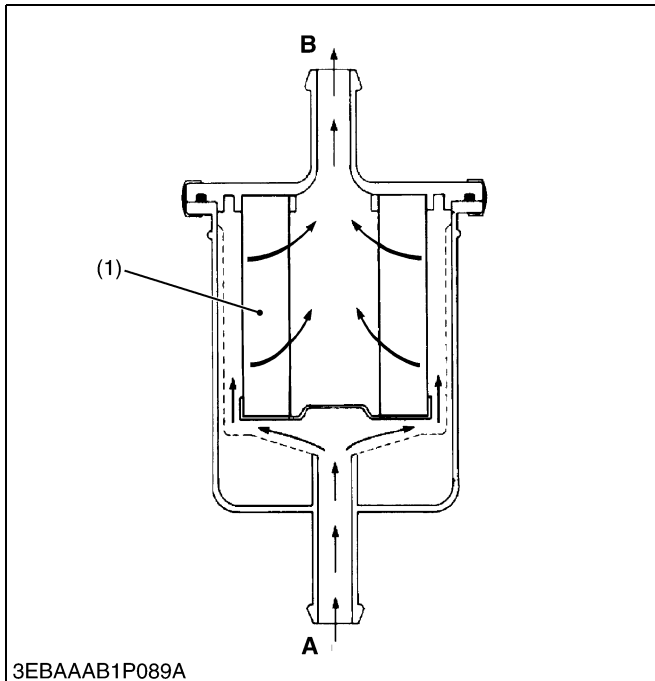
The regulator (7) mixes the gas and air is supplied in the cylinder.

WG1605-GL-E3:

This fuel system has 2 ways (gasoline fuel and LPG fuel).

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[2] FUEL FILTER (WG1605-G-E3, WG1605-GL-E3)



3EBAAAB1P089A

The fuel filter is installed in the fuel line between the fuel tank and the feed pump.

As the fuel flows from the inlet "A" through the filter element (1), the dirt and impurities in the fuel are filtered, allowing only clean fuel to penetrate the inside of the filter element. The cleaned fuel flows out from the outlet "B".

Type of filter element	Accordion-pleated paper type
Material of filter element	Cotton fiber
Filter mesh	15 μm (0.00059 in.)

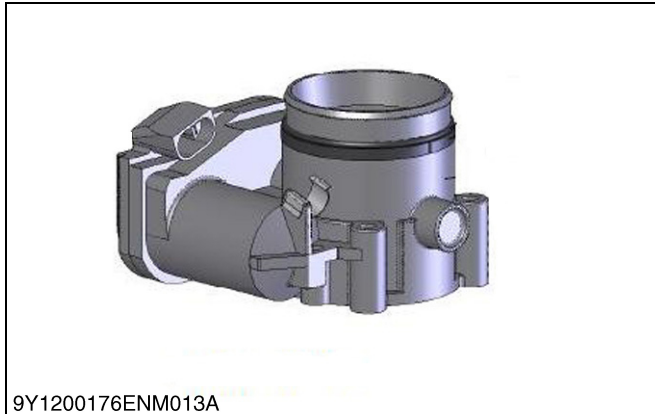
(1) Filter Element

A: Inlet

B: Outlet

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[3] ELECTRONIC THROTTLE BODY (ETB)

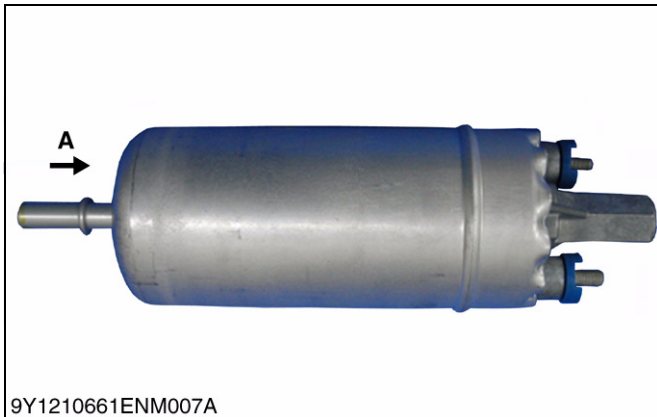


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The ETB is connected to the intake manifold of the engine. The ETB utilizes an electric motor connected to the throttle shaft. In addition, an accelerator position sensor (a foot pedal position sensor) is located in the operator's compartment. When the engine is running, electrical signals are sent from the accelerator position sensor (the foot pedal position sensor) to the Engine Control Unit (ECU) when the operator depresses or releases the accelerator. The ECU then sends an electrical signal to the motor on the ETB to increase or decrease the angle of the throttle blade, thus increasing or decreasing the air flow to the engine.

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[4] FUEL PUMP (WG1605-G-E3, WG1605-GL-E3)



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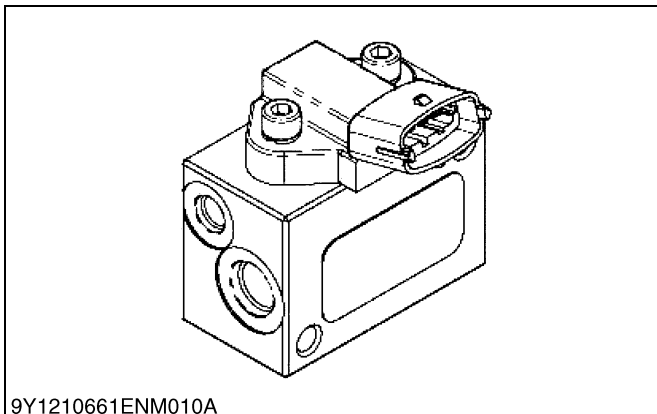
The gasoline system will utilize an external electric gasoline fuel pump. The pump will be mounted in the chassis of the vehicle, or equipment near the fuel tank. Gasoline rated fuel hose and securing devices supplied by the OEM, will be used to transfer the pumped fuel to the Gasoline Fuel Pressure Manifold assembly. The OEM may have installed a fuel filtration device ahead of the electric pump, which may be located in the tank or an external filter. Most industrial equipment will be exposed to dusty and dirty environments, therefore use caution when opening the gasoline tank, to prevent dirt and debris from falling in the tank. For filter maintenance, refer to "3. MAINTENANCE CHECK LIST".

The electric gasoline fuel pump, utilized on USA emission certified engines are a critical part of the certified emissions system, and do not require any periodic adjustment.

The pump will be mounted in the chassis of the vehicle, or equipment near the fuel tank. Gasoline rated fuel hose and securing devices supplied by the OEM, will be used to transfer the pumped fuel to the Gasoline Fuel Pressure Manifold.

A: From Fuel Tank

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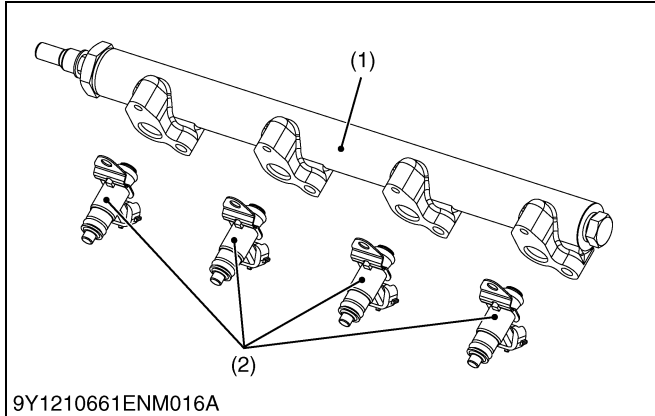
9Y1210661ENM010A

Fuel Pressure Manifold (FPM) **(WG1605-G-E3, WG1605-GL-E3)**

The gasoline fuel system, utilizes a Fuel Pressure Manifold assembly, to control the delivery pressure to the delivery pipe. The manifold is mounted to the chassis, between the electric fuel pump and the delivery pipe. The manifold is equipped with a sensor, which provides the ECU with the gasoline fuel temperature, and pressure being regulated to the delivery pipe. The ECU uses the fuel temperature and pressure, to calculate the precise amount of gasoline, to be injected to the engine during operation. The manifold is designed into the system, to control pressure, as well as the amount of gasoline, to be returned to the fuel tank. In normal gasoline delivery systems, the electric fuel pump, delivers a constant pressure to the delivery pipe, and allows a significant amount of fuel to be recycled to the tank, thus causing the gas to heat and vaporize, and requiring the use of a vapor recovery system to control the excess vapor. The system manages the fuel pressure at the manifold and minimizes the amount of returned fuel, thus reducing the vapor fuel in the tank.

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[5] INJECTORS AND DELIVERY PIPE (WG1605-G-E3, WG1605-GL-E3)



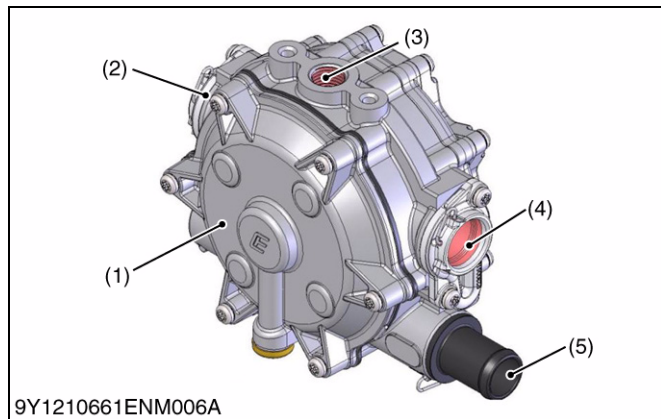
The gasoline fuel delivery system, utilizes a delivery pipe (1) mounted with injectors (2), for each cylinder. The Engine Control Unit (ECU) will utilize the gasoline fuel delivery calibrations, to pulse width modulate each injector (2), to deliver the correct amount of gasoline, for optimized performance and emission control. The injector pulsing or "firing" is accomplished by supplying a 12 volt supply, to the positive side of the injector coil, and switching the ground circuit side, using the injector drivers, internal to the ECU. Injectors (2) are an emissions control device, and do not require periodic adjustment.

(1) Delivery Pipe

(2) Injector

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[6] VAPORIZER (DUAL STAGE REGULATOR (DSR)) (WG1605-L-E3, WG1605-GL-E3)

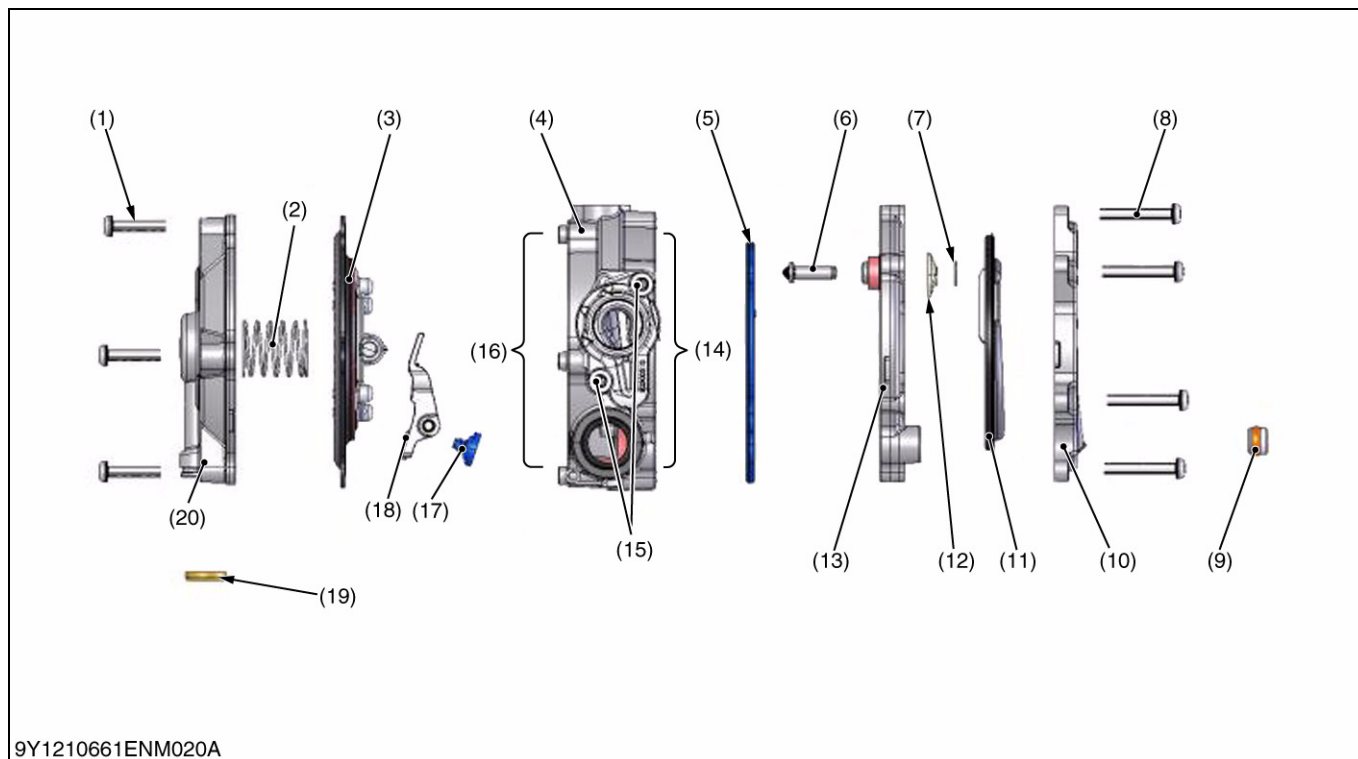


When evaporating by primary chamber of vaporizer liquid LPG needs the evaporation heat.

This vaporizer installs the water jacket, throws the coolant of engine, heats primary chamber, promotes evaporation.

- (1) Vaporizer
- (2) Hot Coolant In / Out
- (3) Fuel In
- (4) Hot Coolant Out / In
- (5) Fuel Out

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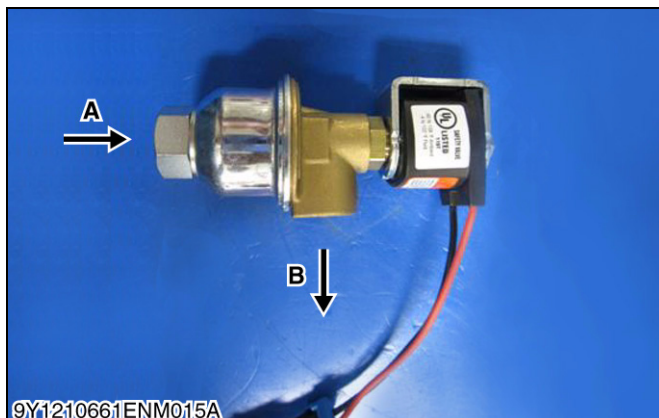
- | | | | |
|---------------------------|-----------------------------------|--|---------------------------|
| (1) Secondary Cover Screw | (6) Primary Pin | (11) Primary Diaphragm | (16) Secondary Chamber |
| (2) Secondary Spring | (7) Primary Spring Retaining Clip | (12) Primary Spring | (17) Secondary Seat |
| (3) Secondary Diaphragm | (8) Primary Cover Screw | (13) Primary Plate | (18) Secondary Lever |
| (4) Heat Exchanger | (9) Primary Test Port Plug | (14) Primary Chamber | (19) Secondary Cover Vent |
| (5) Coolant Gasket | (10) Primary Cover | (15) Coolant Fitting Housing Retaining Screw | (20) Secondary Cover |

The DSR is a combination vaporizer, pressure regulating device. The DSR is a two stage regulator that is normally closed, when the engine is not running. When the engine is cranking or running, a partial vacuum is created in the fuel line, which connects the regulator to the Direct Electronic Pressure Regulators (DEPR), and mixer. This partial vacuum opens the second stage regulator, permitting fuel to flow to the DEPR, and mixer.

As the propane passes through the heat exchanger (4), the fuel expands, and creates pressure inside the primary chamber (14). The pressure rises as the fuel expands, when the pressure rises above 10.34 kPa (1.500 psi); sufficient pressure is exerted on the primary diaphragm (11), and press against the primary pin (6), thus closing off the flow of fuel. This action causes the flow of fuel, into the regulator to be regulated. When the engine is cranking, sufficient vacuum will be introduce into the secondary chamber (16), from the EPR / mixer, drawing the secondary diaphragm (3) down onto the secondary lever (18), allowing vaporized fuel, to pass to the mixer. Increased vacuum, in the secondary chamber (16), increases the downward action on the secondary lever (18), allowing more fuel to flow to the mixer.

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[7] LOCK OFF VALVE (WG1605-L-E3, WG1605-GL-E3)



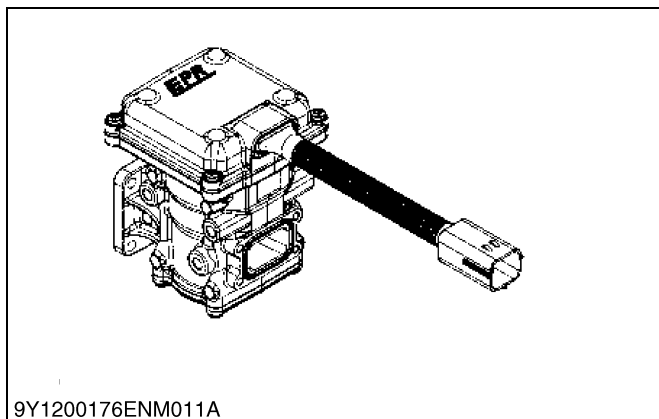
Vaporizer requires a normally-closed electrically controlled fuel lock off valve that is close coupled to the vaporizer and off when ignition switch is off or when the engine is not running normally. In operation without a lock off upstream the vaporizer will flow fuel with the engine off. The vaporizer is not a fuel shut-off safety device

A: From LPG Tank

B: To Vaporizer

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[8] DIRECT ELECTRONIC PRESSURE REGULATOR (DEPR) (WG1605-L-E3, WG1605-GL-E3)

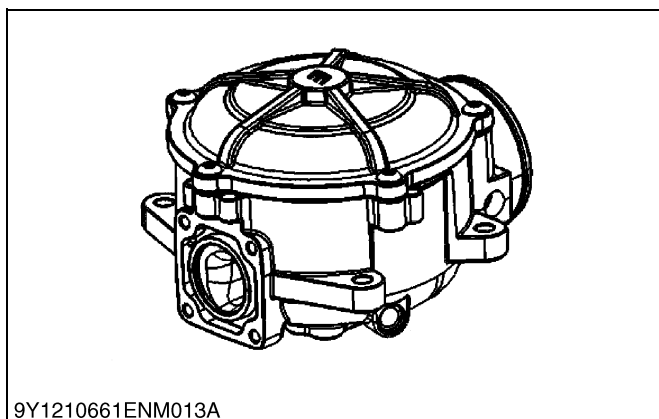


The Direct Electronic Pressure Regulator (DEPR) is the primary fuel control device, used to maintain both performance and emissions control. The DEPR contains an internal computer, which communicates to the Engine Control Unit (ECU), via a Communications Area Network (CAN), high speed connection.

The DEPR precisely controls the fuel flow required to insure Stoichiometric (correct air / fuel mixture for complete burn) fuel delivery to the engine combustion chambers. The DEPR also contains internally mounted fuel pressure and temperature sensors, which provide input across the CAN link, to the ECU, for fuel calculation. The ECU will process this information and command changes back across the CAN link, to the DEPR, to adjust fueling.

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[9] MIXER (WG1605-L-E3, WG1605-GL-E3)

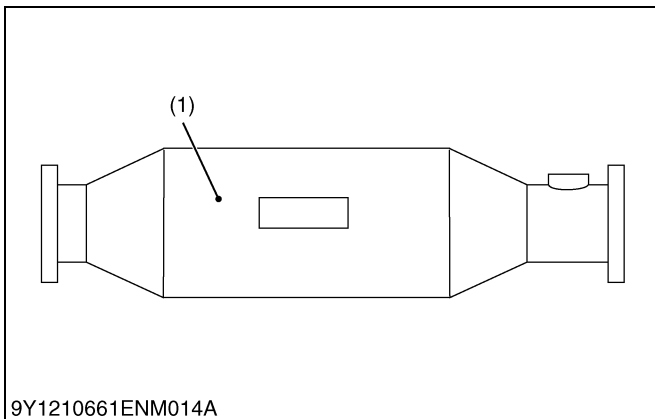


The air valve mixer is an air-fuel metering device, and is completely self-contained. The mixer is an air valve design, utilizing a relatively constant pressure drop, to draw fuel into the mixer from cranking, to full load. The mixer is mounted in the air stream, ahead of the throttle control device.

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5. EXHAUST SYSTEM

[1] THREE-WAY CATALYST



9Y1210661ENM014A

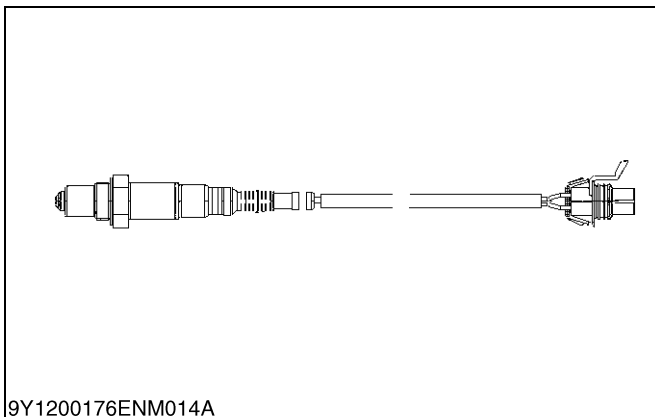
A three-way catalyst is a catalyst that oxidizes HC to CO_2 and H_2O and also CO to CO_2 respectively and at the same time reduces NO_x to N_2 near the stoichiometric ratio.

The main basic component of an exhaust gas purification system that uses a three-way catalyst is feedback control of air-fuel ratio by means of an oxygen sensor for the purpose of maximizing the emission purification efficiency characteristic with reference to the intake air-fuel ratio of the three-way catalyst.

(1) Catalytic Converter

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[2] OXYGEN SENSOR



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An Oxygen sensor is an essential element of a feedback control of air-fuel ratio. The sensor has a mechanism in which a zirconia tube, which is a solid electrolyte, is exposed into the exhaust gas and the outside of a zirconia tube to an exhaust gas, the inside to an atmosphere with a known oxygen concentration respectively. Any difference produced between the two sides of the zirconia tube causes electromotive force to be generated. Oxygen sensor should be installed at the catalyst inlet and outlet each.

[Pre-Catalyst Oxygen Sensor]

When the air-fuel ratio is rich, HC, CO, H_2 , etc. react with the oxygen (O_2) that remains in the exhaust gas. This causes a significant reduction of the concentration of the remaining oxygen, which considerably increases the ratio of it to the concentration of oxygen contained in the atmosphere inside, increasing the electromotive force. When the air-fuel ratio is lean, the process is the other way around, resulting in a significant drop in the electromotive force near the stoichiometric ratio. That is, the feedback control functions as electronic control that reduces the air-fuel ratio when it is judged to be on the rich side based on the electromotive force and increases the ratio when it is on the lean side.

[Post-Catalyst Oxygen Sensor]

A post-catalyst oxygen sensor provides information that can be used 1) to diagnose how efficiently a catalyst is using the available oxygen to react and 2) to adjust or trim pre-catalyst equivalence ratio (air-fuel ratio) to a desired level to optimize catalyst conversion efficiency.

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6. ELECTRICAL SYSTEM

[1] STARTING SYSTEM

(1) General

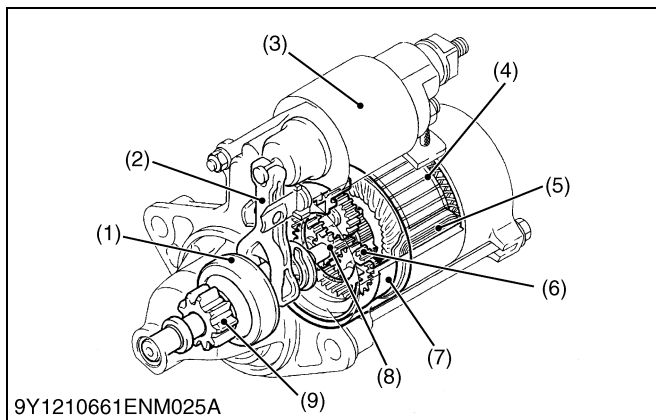
The starting device is composed of the starter, starter switch, fuse, battery etc., and the outline of the basic operation is as the followings;

1. Voltage from battery is added to the **B** terminal of starter switch through the fuse.
2. If the starter switch is turned on, **B** terminal will be connected to **AC**, and the electrical current will flow to each load.
3. If the starter switch is turned to the starting position, **B** terminal will be connected to **AC**, **19**, and **50** will be connected to the **ST** terminal of starter (in case of the type with safety relay, it shall be connected via relay) to start the engine.
4. After the engine is started, if you have let your hand off the starter switch, it automatically returns to **ON** position.

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(2) Starter

[A] P Type Starters



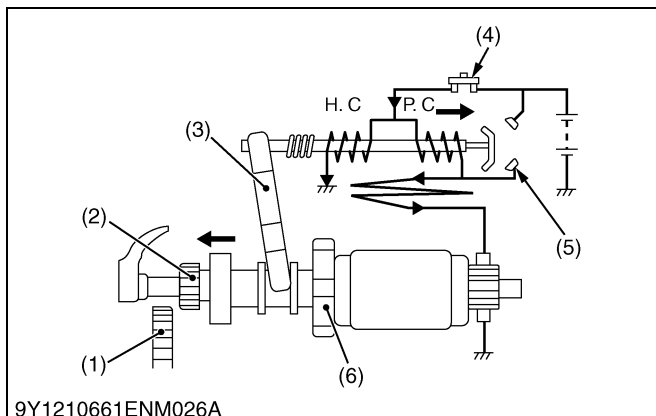
- The P type starters are reduction type starters that uses a planetary gears. The P types use the same type of compact, high-speed motor as the reduction type, and have planetary gears between the clutch and armature.

As a result, a more compact and lightweight starter design has been achieved.

- To engage with the engine, the magnetic switch moves the clutch forward via the drive lever. The clutch slides along a shaft (planetary carrier shaft) connected to the planetary gears.
- The P type starters are equipped with shock absorbers that reduce the shock generated during starter actuation.

- | | |
|---------------------|--------------------|
| (1) Clutch | (6) Planetary Gear |
| (2) Drive Lever | (7) Internal Gear |
| (3) Magnetic Switch | (8) Sun Gear |
| (4) Armature | (9) Pinion Gear |
| (5) Field Coil | |

9Y1210661ENM0038US0



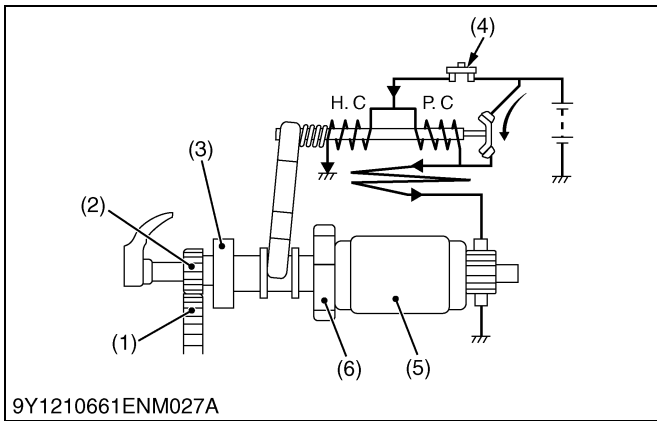
Starter Switch ON

When the starter switch is on, current flows to both the pull-in coil PC and holding coil HC, and the plunger is pulled in by the electromagnetic force generated in both coils.

The pinion gear is thus pushed out to the left, and engages with the ring gear.

- | | |
|-----------------|--------------------|
| (1) Ring Gear | (4) Starter Switch |
| (2) Pinion Gear | (5) Plunger |
| (3) Drive Lever | (6) Planetary Gear |

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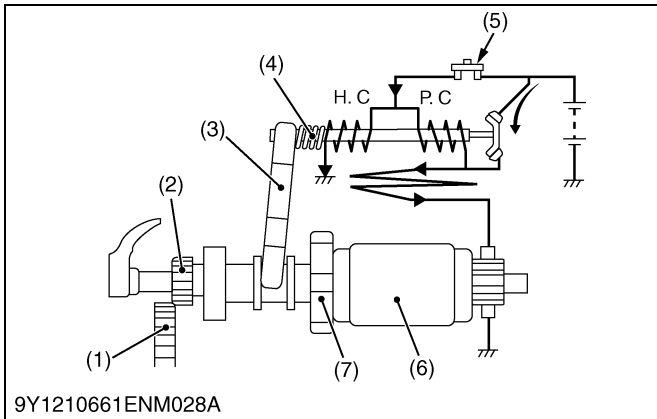
When the Pinion Gear Engages with the Ring Gear without Collision

When the pinion gear engages with the ring gear at a certain position, the magnetic switch main contact closes, and a large current flows through the main contact to the armature.

The force of the armature spiral spline pushes the pinion gear forward, engaging the pinion gear with the ring gear to start the engine.

- (1) Ring Gear
- (2) Pinion Gear
- (3) Clutch
- (4) Starter Switch
- (5) Armature

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When the Pinion Gear and Ring Gear Collide

If the pinion gear and ring gear teeth contact, the pinion gear cannot move any further. If this happens, the magnetic switch drive spring compresses, and the magnetic switch contact closes. As a result, the armature rotates at high torque, and the teeth alignment position slides. The compression force of the drive spring and the force of the armature spiral spline move the pinion gear forward, engaging the pinion gear with the ring gear to start the engine.

- (1) Ring Gear
- (2) Pinion Gear
- (3) Drive Gear
- (4) Drive Spring
- (5) Starter Switch
- (6) Armature
- (7) Planetary Gear

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When the Engine is Started

When the engine starts, the clutch idles to prevent the ring gear from driving the armature in reverse.

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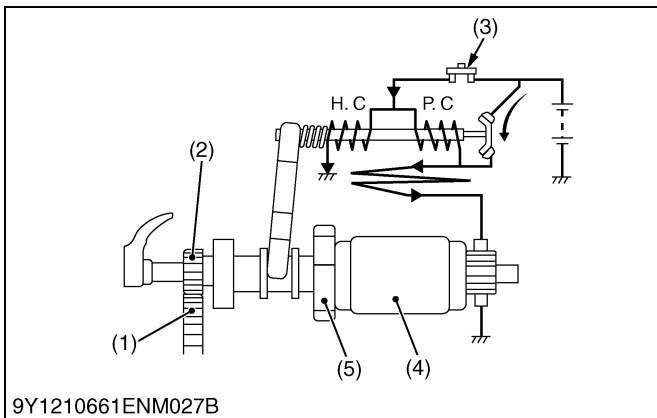
Starter Switch OFF

When the starter switch is turned **OFF**, the magnetic switch attraction is cancelled and the pinion gear is returned by the magnetic switch return spring.

The main contact then opens, interrupting the flow of current to the armature.

- (1) Ring Gear
- (2) Pinion Gear
- (3) Starter Switch
- (4) Armature
- (5) Planetary Gear

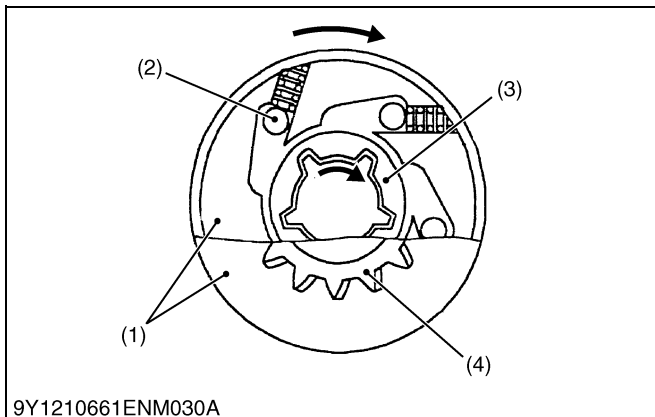
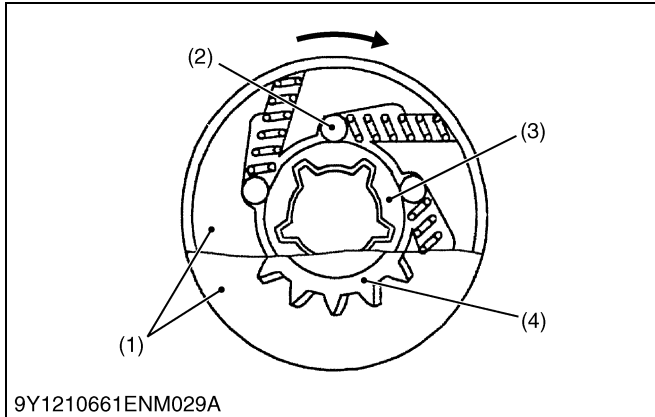
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[B] Overrunning Clutch
Function

In case that the pinion gear and ring gear are still inter meshed even when the engine is started, the motor will be forced to run in abnormal rotation, and the armature, brush, etc. will be damaged. In order to prevent such an error, the overrunning clutch will function as the device to let the pinion race against the armature shaft when the engine is started, and to shut off transmission of rotation of the engine to the motor.

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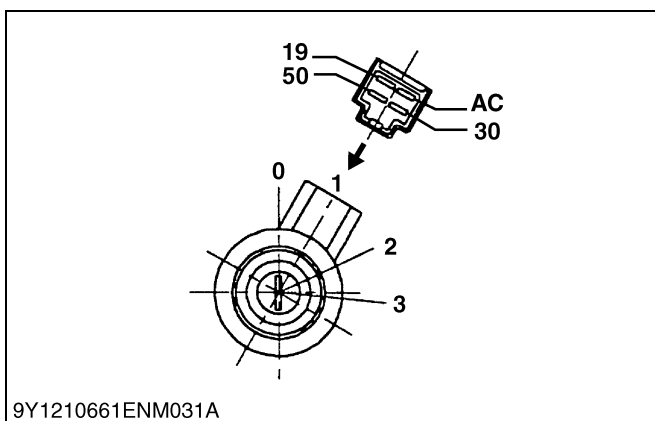
Action

1. When starting:
 If the outer is rotated in the arrow mark direction receiving rotation of the armature, the clutch roller will be pushed toward the narrower side of clearance between the outer concave side and the inner so that the outer and inner will be locked. The roller will function as a wedge between the inner and outer, and will transmit the rotation of the outer to the inner, and both will rotate in the same speed.
2. After the engine is started:
 When the pinion is forced to rotate by the ring gear, rotation of the inner (rotation of engine x gear ratio) will become faster than that of the outer (a number of rotation of armature), and the clutch roller will move toward the direction that compresses the spring. Consequently, clearance between the outer concave side and the inner becomes wide to prevent overrunning of the armature.
 (It is required to decrease the contact pressure of the pinion gear and ring gear to realize smooth separation of the pinion gear, and for the sake of this, the pinion gear must be in the state of racing.)

- (1) Outer (Integral Structure with Spline Tube)
- (2) Clutch Roller
- (3) Inner (Integral Structure with Pinion Tube)
- (4) Pinion Gear

9Y1210661ENM0045US0

(3) Starter Switch



Starter Switch

Starter switch is an important part comprising of the starting device of engine. Particularly, as seizing of the starter may be incurred due to failure of the starter switch, careful consideration is required for the installation position, place, and direction, so that rain or cleaning water should not directly splash on the starter switch.

As the standard part of KUBOTA engine, the starter switch in below figure is recommended.

[Connection Diagram]

Position	19	30	50	AC
0				
1		●	—	●
2	●	●		●
3	●	●	●	●

9Y1210661ENM032US

9Y1210661ENM0046US0

(4) Starter Safety System

The ECU can be configured for either auto cranking (crank until starting) or crank limiting (maximum crank time and disabling of starter if frequency and number of attempts is too high).

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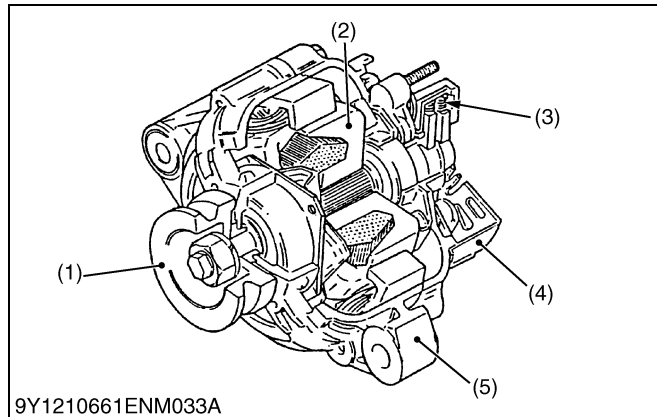
[2] CHARGING SYSTEM

(1) General

The function of the charging device is to charge batteries.

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(2) IC Regulator Built-in Type Alternator



The alternator is the incorporated with an IC regulator, this has been made small size and light weight by the semiconductor technique of the IC regulator.

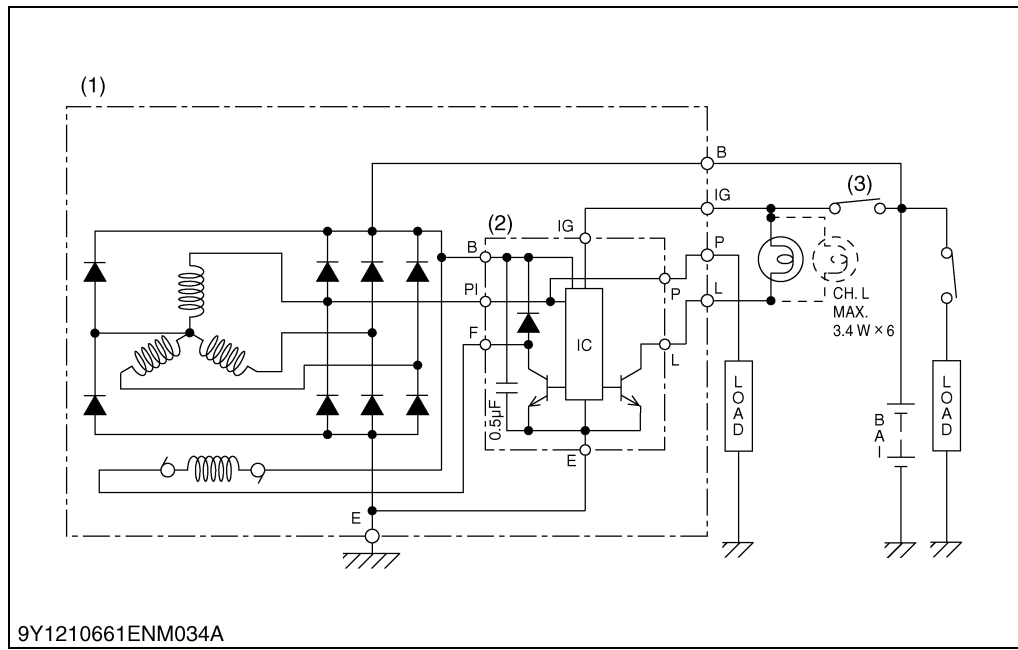
The cooling property and safety is improved by incorporating the cooling fan and roller that is an integral structure.

Further, the serviceability is also improved by facilitating mounting and removal of the rectifier and IC regulator.

- | | |
|------------|---------------------|
| (1) Pulley | (4) Cover |
| (2) Rotor | (5) Drive and Frame |
| (3) Brush | |

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D2 Type Regulator



- (1) Alternator Assembly
- (2) IC Regulator
- (3) Key Switch

IC regulator has a special feature that makes it possible to interrupt field current by using the transistor or IC instead of the contact-point-type regulator.

IC regulator has the special features as follows:

1. Readjustment for this regulator is unnecessary because the control voltage does not change over time. Further, vibration-proof property and durability is excellent because IC regulator has no moving parts.
2. Since IC regulator has over-temperature compensation property, which makes the control voltage low if the temperature is increased, it makes it possible to properly charge the batteries.

The circuit inside IC regulator is as shown in the following figure.

It is composed of the monolithic IC-incorporated hybrid IC. (Since the inside circuit of the monolithic IC is extremely complex, it is described as **M.IC** circuit.)

Tr1 has the function as the contact point to control field electrical current, and as the charging lamp relay to light the charging lamp.

M.IC controls **Tr1** and **Tr2** by detecting decrease of the output voltage of alternator, decrease of the **L** terminal voltage, disconnection of the rotor coil, etc.

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Charge Light Control

Turns the charge light **ON** and **OFF** in accordance with alternator power generation.

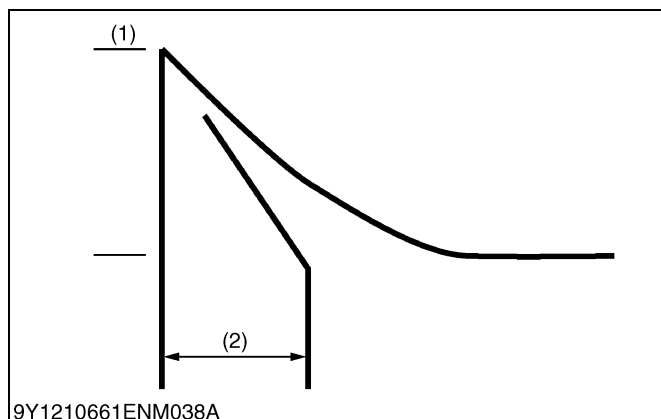
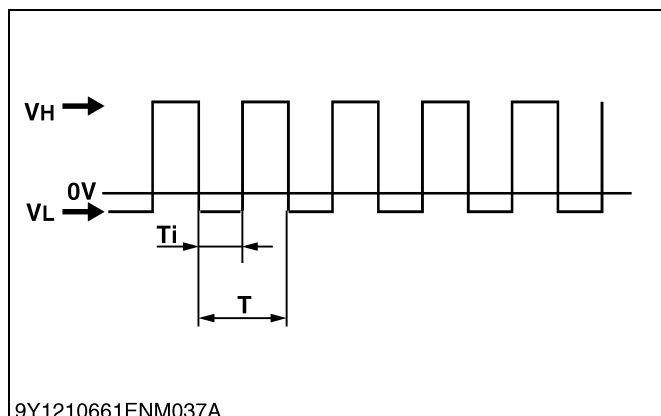
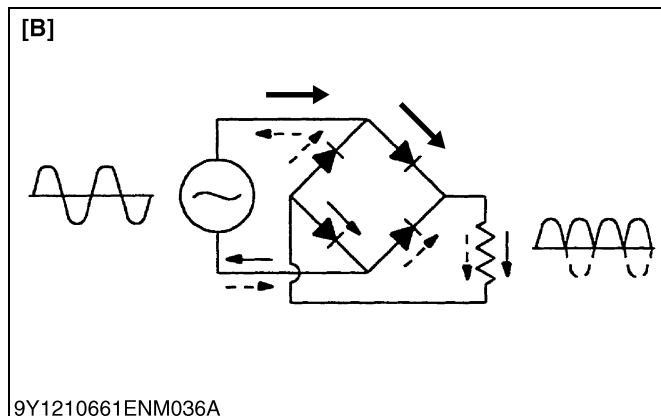
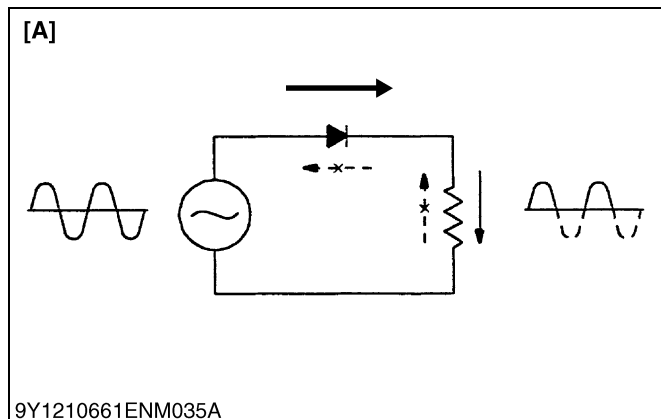
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Specification of Alternator with IC (Incorporated with) Regulator

Nominal voltage	12 V
Maximum output	40 A, 60 A
Rotational direction	Right as seen from pulley side
Armature wiring	3 phase, Y wiring
Rectifying system	Total wave rectification
min ⁻¹ (rpm) at no load (when cold)	14 V at 0 A 1050 to 1350 min ⁻¹ (rpm)
min ⁻¹ (rpm) at max. output (when cold)	14 V at maximum output below 4000 min ⁻¹ (rpm)

Generating capacity will be determined by rpm of engine and pulley ratio.

9Y1210661ENM0052US0



Total Wave Rectification

In case of the generator for mobile equipment of which purpose is to charge the batteries, alternating current cannot be used as it is. Because of this, it is required to conduct the action called rectification so that the alternating current can be changed to direct current. Alternator conducts rectification by means of diode.

If the voltage is applied to diode in the normal direction, enough electrical current can flow even by small voltage, however if applied in the reverse direction, it inhibits the reverse flow of electrical current.

Using this property, alternate current generated in the stator coil is changed to the direct current.

As for the rectification using diode, there are two methods, i.e., "half-wave rectification" that takes out only positive portion of alternate current, and 'total-wave rectification' that rectifies both positive and negative current and change to the direct current.

[A] Half-wave Rectification [B] Total-wave Rectification

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Alternator P Terminal

P terminal waveform: The alternator **P** terminal outputs rotation signals required by a tachometer, etc.

The **P** terminal corresponds with one phase of the alternator stator and the output waveform during power generation is a waveform equivalent to the rectangular wave with a frequency in proportion to the number of revolutions of the alternator.

Frequency (1/T): Number of Revolutions of Alternator
[rpm] / 10 [Hz]

Duty (Ti/T): Approx. 50 %

VH (average): About +0 to 2 V with Reference to the Alternator B Terminal Voltage (Average)

VL: About -2 to 0 V

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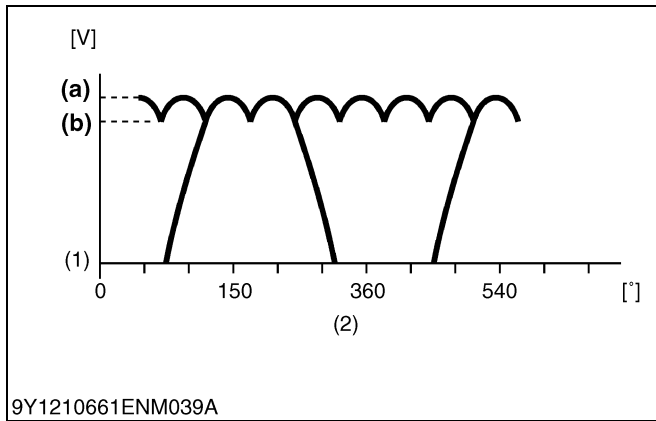
NOTE

- As with the B terminal waveform, the P terminal waveform includes noise, which varies depending on the number of revolutions, output and wiring (see the waveform in a separate material).
- Surge voltage may be generated by any charging cable disconnection (especially with high number of revolutions / high output), etc.

(1) Approx. 150 V

(2) Approx. 180 ms

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Surge voltage waveform with any charging cable disconnection.

- May be VHmin = 6.5 V in high electric load shedding or unloaded condition with the battery fully charged.

- | | |
|---------------------------|------------|
| (1) Voltage | (a) VH max |
| (2) Angle of Rotation (°) | (b) VH min |

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Load Connected To the P Terminal

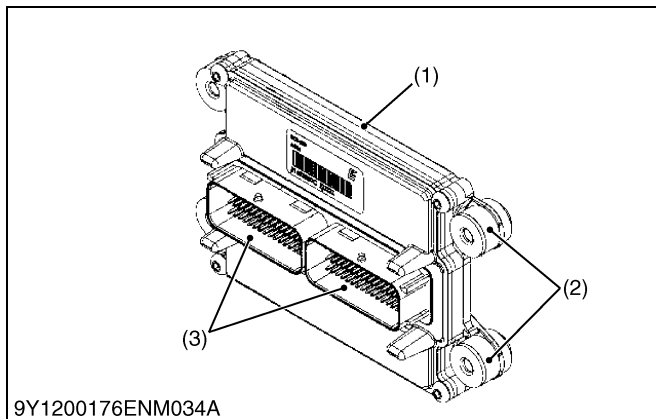
P terminal output current: 0.5 A max (average current).

NOTE

- Ensure that there is no load short circuit or wrong wiring.
- Do not connect inductive or capacitive load (connection of such load subject to discussion of the specification).
- When detecting a waveform, take the noise and VHmin into consideration.
- Take the surge voltage into consideration for the input of the load.
- Use the actual equipment for sufficient check of the operation of the load.

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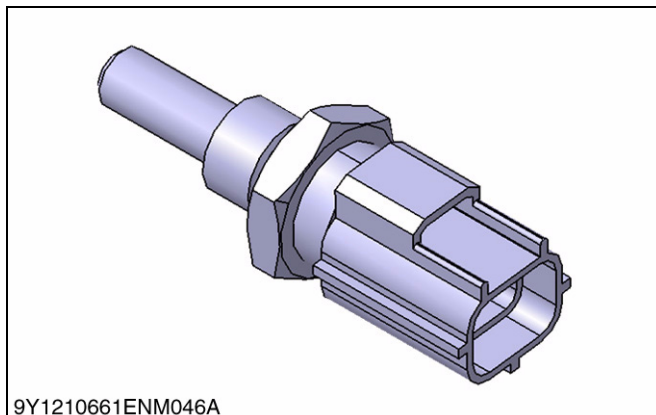
[3] ENGINE CONTROL UNIT (ECU)



The ECU will utilize signal inputs, from the engine sensors, to control the fuel metering and speed control, while the engine is running. As well, the ECU will provide diagnostic control, over the fuel system.

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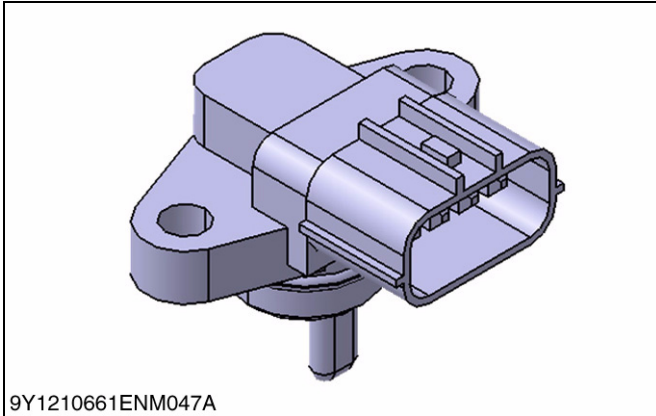
[4] WATER TEMPERATURE SENSOR



Ignition timing, fuel rate, and boost levels can be configured to vary with engine coolant temperature. This is typically done at very cold or very hot conditions. Coolant temperature is also used in the airflow models in the ECU.

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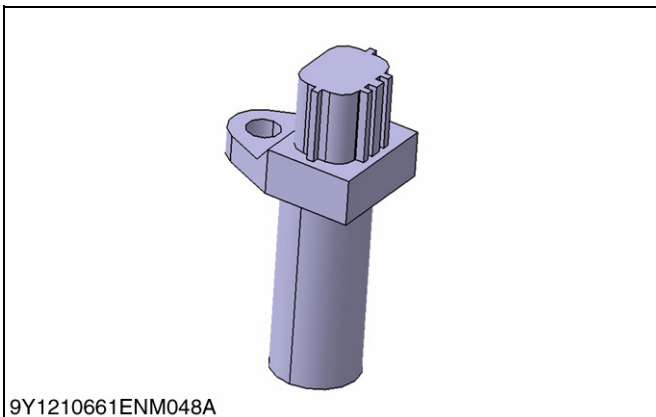
[5] TEMPERATURE AND MANIFOLD ABSOLUTE PRESSURE SENSOR (TMAP SENSOR)



TMAP sensor is mounted in the intake manifold and measures the absolute pressure as well as the temperature of the air / fuel stream. MAP data is used by the ECU for calculating airflow pressure. The temperature information from the TMAP is used for a density correction in the mass air flow calculation.

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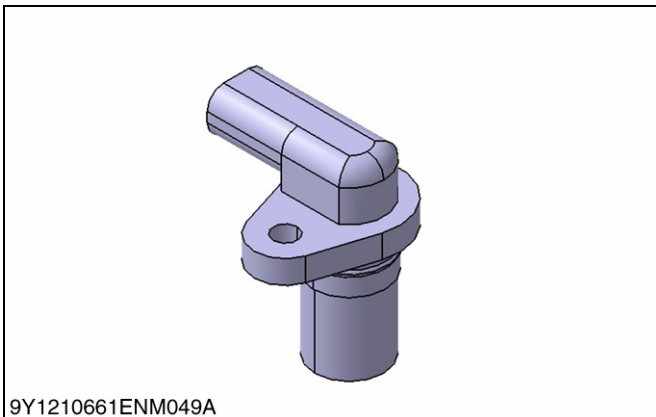
[6] CRANKSHAFT POSITION SENSOR



The Crankshaft Position Sensor provides engine speed information.

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[7] CAMSHAFT POSITION SENSOR



The Camshaft Position sensor informs the ECU which cylinders are in compression to signal spark timing.

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[8] KNOCK SENSOR



The knock sensor is used to detect detonation through mechanical vibration in the engine block and / or cylinder heads and provide feedback for the ignition system to retard spark to reduce knock intensity. In most applications the knock sensor is used to protect the engine from damage that can be caused from detonation or knock based on fixed spark advance.

The Knock Sensor is a 5 volt reference signal sensor, which operates by the resistance change in the sensor, to output a reference voltage for the Engine Control Unit (ECU) to use. The knock sensor sends a base or "no knock" signal to the ECU, when knocking does occur the sensor detects the increased vibration, and increases the voltage output to the ECU. When the ECU receives the voltage change, the ECU will slightly retard the timing, until such time, the knocking no longer exists.

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[9] IGNITION COIL



Ignition coil is a transformer to generate high electric voltage necessary for the ignition. Around the iron core of multi-layer thin crude steel plates, secondary coil is wound, on whose outside, in the same direction, primary coil is wound. The empty space in the case is filled with resin for electric insulation and good heat radiation.

The ignition timing is controlled by ECU and the high voltage is applied to the spark plugs by the ECU signals.

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SERVICING

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1. TROUBLESHOOTING

[1] FOR GENERAL

Symptom	Probable Cause	Solution	Reference Page
Engine Will Not Turn Over	Engine jammed	Check engine to find the problem and repair it	–
	Battery discharged	Charge	–
	Starter malfunctioning	Repair or replace	1-S23
	Wires disconnected	Reconnect	–
Engine Turns Over Slowly but Does Not Start	Increased resistance of moving parts	Repair or replace	–
	Excessively high viscosity engine oil at low temperature	Use specified engine oil	G-7
Engine Turns Over at Normal Speed but Does Not Start	Compression leak	Check the compression pressure and repair	1-S12
	Improper valve clearance	Adjust	1-S23
	Defective ignition coil	Replace	1-S20
	Defective spark plug	Adjust spark plug gap or replace	G-12
	Clogged air cleaner	Clean or replace	G-12
Rough Low-Speed Running and Idling	Defective ignition coil	Replace	1-S20
	Defective spark plug	Adjust spark plug gap or replace	G-12
	Improper valve clearance	Adjust	1-S23
Rough High-Speed Running	Defective spark plug	Adjust spark plug gap or replace	G-12
	Defective ignition coil	Replace	1-S20
Engine Speed Does Not Increase	Clogged air cleaner	Clean or replace	–
	Defective ignition coil	Replace	1-S20
	Defective throttle body	Replace	–
	Breather tube has separated	Attach correctly	–
	Improper input signal to ECU	Check the wire harness	–
Deficient Output	Improper intake or exhaust valve sealing	Replace	1-S42
	Improper valve clearance	Adjust	1-S13
	Piston ring and cylinder worn	Replace	1-S50, 1-S56
	Clogged air cleaner	Clean or replace	G-12
Engine Noise	Improper valve clearance	Adjust	1-S13
	Spark knock due to low-octane fuel or carbon	Use higher-octane fuel and remove carbon	–
	Rattles from loosely mounted external components	Retighten	–

Symptom	Probable Cause	Solution	Reference Page
Exhaust Flames	Defective ignition coil	Replace	1-S20
	Defective spark plug	Adjust spark plug or replace	G-12
	Wires disconnected or defective wire	Reconnect / replace	–
	Bad connection of ignition coil and spark plug	Reconnect	–

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[2] FOR GASOLINE FUEL

Symptom	Probable Cause	Solution	Reference Page
Engine Turns Over at Normal Speed but Does Not Start	No fuel	Replenish fuel	–
	Defective fuel system	Check fuel line and electronic throttle body and repair	–

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[3] FOR LPG FUEL

Symptom	Probable Cause	Solution	Reference Page
Engine Will Not Turn Over	Defective vaporizer	Replace	–
	Defective lock off valve	Replace	–
Engine Turns Over at Normal Speed but Does Not Start	No LPG fuel	Replenish LPG fuel Check LPG tank valve Check lock off valve	–
Rough Low-Speed Running and Idling	Shortage of gas supply	Replenish LPG fuel Check lock off valve	–
Defection Output	LPG density is rich or lean	Repair or replace of fuel system Replace vaporizer	–

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2. SERVICING SPECIFICATIONS

ENGINE BODY

Item		Factory Specification	Allowable Limit
Valve Clearance (Cold)		0.145 to 0.185 mm 0.00571 to 0.00728 in.	–
Compression Pressure	–	1.27 MPa 13.0 kgf/cm ² 185 psi	0.88 MPa 9.0 kgf/cm ² 130 psi
	Variance Among Cylinder	–	10% or less
Top Clearance		1.2 to 1.5 mm 0.048 to 0.059 in.	–
Cylinder Head Surface	Flatness	–	0.05 mm 0.002 in.
Valve Recessing (Intake and Exhaust)		–0.050 to 0.25 mm –0.0020 to 0.0098 in.	0.40 mm 0.016 in.
Valve Stem to Valve Guide	Clearance	0.035 to 0.065 mm 0.0014 to 0.0025 in.	0.10 mm 0.0039 in.
• Valve Stem	O.D.	6.960 to 6.975 mm 0.2741 to 0.2746 in.	–
• Valve Guide	I.D.	7.010 to 7.025 mm 0.2760 to 0.2765 in.	–
Valve Face	Angle (Intake)	1.0 rad 60 °	–
	Angle (Exhaust)	1.0 rad 60 °	–
Valve Seat	Angle (Intake)	1.0 rad 60 °	–
	Angle (Exhaust)	1.0 rad 60 °	–
	Width	2.12 mm 0.0835 in.	–
Valve Timing (Intake Valve)	Open	0.38 rad 22 ° before T.D.C.	–
	Close	0.82 rad 47 ° after B.D.C.	–
Valve Timing (Exhaust Valve)	Open	0.91 rad 52 ° before B.D.C.	–
	Close	0.30 rad 17 ° after T.D.C.	–

Item		Factory Specification	Allowable Limit
Valve Spring	Free Length	35.1 to 35.6 mm 1.39 to 1.40 in.	34.8 mm 1.37 in.
	Tilt	–	1.0 mm 0.039 in.
	Setting Load / Setting Length	74 N / 31.0 mm 7.5 kgf / 31.0 mm 17 lbf / 1.22 in.	63 N / 31.0 mm 6.4 kgf / 31.0 mm 14 lbf / 1.22 in.
Rocker Arm Shaft to Rocker Arm	Oil Clearance	0.016 to 0.045 mm 0.00063 to 0.0017 in.	0.10 mm 0.0039 in.
• Rocker Arm Shaft	O.D.	11.973 to 11.984 mm 0.47138 to 0.47181 in.	–
• Rocker Arm	I.D.	12.000 to 12.018 mm 0.47244 to 0.47314 in.	–
Push Rod	Alignment	–	0.25 mm 0.0098 in.
Tappet to Tappet Guide Bore	Oil Clearance	0.020 to 0.062 mm 0.00079 to 0.0024 in.	0.07 mm 0.003 in.
• Tappet	O.D.	19.959 to 19.980 mm 0.78579 to 0.78661 in.	–
• Tappet Guide Bore	I.D.	20.000 to 20.021 mm 0.78741 to 0.78822 in.	–
Timing Gear	Backlash	0.0320 to 0.115 mm 0.00126 to 0.00452 in.	0.15 mm 0.0059 in.
• Crank Gear to Idle Gear 1			
• Idle Gear 1 to Cam Gear	Backlash	0.0360 to 0.114 mm 0.00142 to 0.00448 in.	0.15 mm 0.0059 in.
• Idle Gear 1 to Injection Pump Gear	Backlash	0.0340 to 0.116 mm 0.00134 to 0.00456 in.	0.15 mm 0.0059 in.
• Idle Gear 1 to Idle Gear 2	Backlash	0.0330 to 0.117 mm 0.00130 to 0.00460 in.	0.15 mm 0.0059 in.
• Idle Gear 2 to Governor Gear	Backlash	0.0300 to 0.117 mm 0.00119 to 0.00460 in.	0.15 mm 0.0059 in.
Idle Gear	Side Clearance	0.20 to 0.51 mm 0.0079 to 0.020 in.	0.80 mm 0.031 in.
• Idle Gear 1			
• Idle Gear 2	Side Clearance	0.20 to 0.51 mm 0.0079 to 0.020 in.	0.80 mm 0.031 in.
Camshaft	Side Clearance	0.0700 to 0.220 mm 0.00276 to 0.00866 in.	0.30 mm 0.012 in.
	Alignment	–	0.01 mm 0.0004 in.

Item		Factory Specification	Allowable Limit
Cam Height	Intake	28.80 mm 1.134 in.	28.75 mm 1.132 in.
	Exhaust	29.00 mm 1.142 in.	28.95 mm 1.140 in.
Camshaft Journal to Cylinder Block Bore	Oil Clearance	0.050 to 0.091 mm 0.0020 to 0.0035 in.	0.15 mm 0.0059 in.
	• Camshaft Journal O.D.	35.934 to 35.950 mm 1.4148 to 1.4153 in.	–
	• Cylinder Block Bore I.D.	36.000 to 36.025 mm 1.4174 to 1.4183 in.	–
Idle Gear Shaft to Gear Bushing	• Idle Gear 1 Oil Clearance	0.020 to 0.054 mm 0.00079 to 0.0021 in.	0.10 mm 0.0039 in.
	• Idle Gear Bushing I.D.	26.000 to 26.021 mm 1.0237 to 1.0244 in.	–
	• Idle Gear Shaft 1 O.D.	25.967 to 25.980 mm 1.0224 to 1.0228 in.	–
	• Idle Gear 2 Oil Clearance	0.020 to 0.054 mm 0.00079 to 0.0021 in.	0.10 mm 0.0039 in.
	• Idle Gear Bushing I.D.	26.000 to 26.021 mm 1.0237 to 1.0244 in.	–
	• Idle Gear Shaft 2 O.D.	25.967 to 25.980 mm 1.0224 to 1.0228 in.	–
	Piston Pin Bore I.D.	22.000 to 22.013 mm 0.86615 to 0.86665 in.	22.03 mm 0.8673 in.
Piston Pin to Small End Bushing	Oil Clearance	0.014 to 0.038 mm 0.00056 to 0.0014 in.	0.15 mm 0.0059 in.
	• Piston Pin O.D.	22.002 to 22.011 mm 0.86622 to 0.86657 in.	–
	• Small End Bushing I.D.	22.025 to 22.040 mm 0.86713 to 0.86771 in.	–
Piston Pin to Small End Bushing (Spare Parts)	Oil Clearance	0.0650 to 0.144 mm 0.00256 to 0.00566 in.	0.15 mm 0.0059 in.
	• Small End Bushing I.D.	22.076 to 22.146 mm 0.86914 to 0.87188 in.	–
Piston Ring Gap	Top Ring	0.30 to 0.45 mm 0.012 to 0.017 in.	1.25 mm 0.0492 in.
	Second Ring	0.30 to 0.45 mm 0.012 to 0.017 in.	1.25 mm 0.0492 in.
	Oil Ring	0.20 to 0.70 mm 0.0079 to 0.027 in.	1.25 mm 0.0492 in.

Item		Factory Specification	Allowable Limit
Piston Ring to Piston Ring Groove	Top Ring (Clearance)	0.040 to 0.080 mm 0.0016 to 0.0031 in.	0.2 mm 0.008 in.
	Second Ring (Clearance)	0.030 to 0.070 mm 0.0012 to 0.0027 in.	0.2 mm 0.008 in.
	Oil Ring (Clearance)	0.020 to 0.19 mm 0.00079 to 0.0074 in	0.2 mm 0.008 in
Connecting Rod	Alignment	–	0.05 mm 0.002 in.
Crankshaft	Side Clearance	0.15 to 0.31 mm 0.0059 to 0.012 in.	0.50 mm 0.020 in.
	Alignment	–	0.02 mm 0.0008 in.
Crankpin to Crankpin Bearing	Oil Clearance	0.065 to 0.091 mm 0.0026 to 0.0035 in.	0.20 mm 0.0079 in.
	• Crankpin O.D.	39.959 to 39.975 mm 1.5732 to 1.5738 in.	–
	• Crankpin Bearing I.D.	40.040 to 40.050 mm 1.5764 to 1.5767 in.	–
Crankshaft Journal to Crankshaft Bearing 1	Oil Clearance	0.0340 to 0.114 mm 0.00134 to 0.00448 in	0.20 mm 0.0079 in.
	• Crankshaft Journal O.D.	47.934 to 47.950 mm 1.8872 to 1.8877 in	–
	• Crankshaft Bearing 1 I.D.	47.984 to 48.048 mm 1.8892 to 1.8916 in.	–
Crankshaft Journal to Crankshaft Bearing 2	Oil Clearance	0.034 to 0.095 mm 0.0014 to 0.0037 in.	0.20 mm 0.0079 in.
	• Crankshaft Journal O.D.	47.934 to 47.950 mm 1.8872 to 1.8877 in.	–
	• Crankshaft Bearing 2 I.D.	47.984 to 48.029 mm 1.8892 to 1.8909 in.	–
Crankshaft Journal to Crankshaft Bearing 3	Oil Clearance	0.0340 to 0.103 mm 0.00134 to 0.00405 in.	0.20 mm 0.0079 in.
	• Crankshaft Journal O.D.	51.921 to 51.940 mm 2.0442 to 2.0448 in.	–
	• Crankshaft Bearing 3 I.D.	51.974 to 52.024 mm 2.0463 to 2.0481 in.	–
Cylinder Liner [Standard]	I.D.	79.000 to 79.019 mm 3.1103 to 3.1109 in.	79.15 mm 3.116 in.
Cylinder Liner [Oversize: 0.5 mm (0.02 in.)]	I.D.	79.500 to 79.519 mm 3.1300 to 3.1306 in.	79.65 mm 3.136 in.

LUBRICATING SYSTEM

Item		Factory Specification	Allowable Limit
Engine Oil Pressure	At Idle Speed	49 kPa 0.50 kgf/cm ² 7.1 psi	—
	At Rated Speed	196 to 441 kPa 2.00 to 4.49 kgf/cm ² 28.5 to 63.9 psi	147 kPa 1.50 kgf/cm ² 21.3 psi
Inner Rotor to Outer Rotor	Clearance	0.060 to 0.18 mm 0.0024 to 0.0071 in.	—
Outer Rotor to Pump Body	Clearance	0.100 to 0.180 mm 0.00394 to 0.00708 in.	—
Inner Rotor to Cover	Clearance	0.025 to 0.075 mm 0.00099 to 0.0029 in	—

COOLING SYSTEM

Item		Factory Specification	Allowable Limit
Fan Belt	Tension	7.0 to 9.0 mm / 98 N 0.28 to 0.35 in. / 98 N (10 kgf, 22 lbf)	—
Thermostat	Valve Opening Temperature (At Beginning)	69.5 to 72.5 °C 157.1 to 162.5 °F	—
	Valve Opening Temperature (Opened Completely)	85 °C 185 °F	—
Radiator Cap	Pressure Falling Time	10 seconds or more 88 → 59 kPa 0.89 → 0.61 kgf/cm ² 12 → 8.6 psi	—
Radiator	Weak Leakage Test Pressure (210 kPa, 2.14 kgf/cm ² , 30.5 psi)	No leak at specified pressure	—

IGNITION SYSTEM

Item		Factory Specification	Allowable Limit
Ignition Timing	Gasoline fuel	0.45 rad (26 °) before T.D.C. / 3000 min ⁻¹ (rpm)	–
		0.17 rad (10 °) before T.D.C. / 800 min ⁻¹ (rpm)	–
	LPG fuel	0.35 rad (20 °) before T.D.C. / 3000 min ⁻¹ (rpm)	–
		0.17 rad (10 °) before T.D.C. / 800 min ⁻¹ (rpm)	–
Crank Sensor	Resistance	1.85 to 2.45 kΩ at 20 °C (68 °F)	–
Cam Sensor	Resistance	470 to 530 Ω at 20 °C (68 °F)	–
Spark Plug (NGK: IFR6F8DN)	Plug Gap	0.70 to 0.80 mm 0.028 to 0.031 in.	–
Resistance of Ignition Coil	Primary (+) - (-)	0.63 to 0.77 Ω at 25 °C (77 °F)	–
	Secondary Side (Primary (+) - Plug Cap)	7.29 to 8.91 kΩ at 25 °C (77 °F)	–

ELECTRICAL SYSTEM

Item		Factory Specification	Allowable Limit
Starter	Commutator (O.D.)	28.0 mm 1.10 in.	27.0 mm 1.06 in.
	Difference (O.D.)	Less than 0.05 mm 0.002 in.	0.4 mm 0.02 in.
	Mica (Undercut)	0.50 to 0.80 mm 0.020 to 0.031 in.	0.20 mm 0.0079 in.
	Brush (Length)	16.0 mm 0.630 in.	10.5 mm 0.413 in.
Alternator	No-load Voltage	14.2 V to 14.8 V at 5000 min ⁻¹ (rpm), 25 °C (77 °F)	–
	Stator (Resistance)	Less than 1.0 Ω	–
	Rotor (Resistance)	2.9 Ω	–
	Slip Ring (O.D.)	14.4 mm 0.567 in.	14.0 mm 0.551 in.
	Brush (Length)	10.0 mm 0.394 in.	8.4 mm 0.33 in.

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3. TIGHTENING TORQUES

Screws, bolts and nuts must be tightened to the specified torque using a torque wrench, several screws, bolts and nuts such as those used on the cylinder head must be tightened in proper sequence and the proper torque.

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[1] TIGHTENING TORQUES FOR GENERAL USE SCREWS, BOLTS AND NUTS

■ NOTE



- For "*" marked screws, bolts and nuts on the table, apply engine oil to their threads and seats before tightening.
- The letter "M" in Size × Pitch means that the screw, bolt or nut dimension stands for metric. The size is the nominal outside diameter in mm of the threads. The pitch is the nominal distance in mm between two threads.

Item	Dimension × Pitch	N·m	kgf·m	lbf·ft
Cylinder head screw	M10 × 1.25	63.7 to 68.6	6.50 to 6.99	47.0 to 50.5
*Connecting rod screw	M8 × 1.0	41.2 to 46.1	4.21 to 4.70	30.4 to 34.0
*Flywheel screw	M10 × 1.25	53.9 to 58.8	5.50 to 5.99	39.8 to 43.3
*Fan drive pulley screw	M14 × 1.5	235 to 245	24.0 to 24.9	174 to 180
*Main bearing case screw 1	M8 × 1.25	29.4 to 34.3	3.00 to 3.49	21.7 to 25.2
*Main bearing case screw 2	M9 × 1.25	49.0 to 53.9	5.00 to 5.49	36.2 to 39.7
*Cylinder head cover cap nut	M7 × 1.0	6.9 to 8.8	0.71 to 0.89	5.1 to 6.4
Oil pressure switch	PT 1/8	14.7 to 19.6	1.50 to 1.99	10.9 to 14.4
Bearing case cover mounting screw	M6 × 1.0	9.81 to 11.3	1.00 to 1.15	7.24 to 8.33
*Rocker arm bracket nut	M7 × 1.0	21.6 to 26.5	2.21 to 2.70	16.0 to 19.5
*Idle gear shaft mounting screw	M6 × 1.0	9.81 to 11.3	1.00 to 1.15	7.24 to 8.33
Injection pump gear cap nut	M12 × 1.5	58.8 to 68.6	6.00 to 6.99	43.4 to 50.5
Drain plug	M12 × 1.25	32.4 to 37.3	3.31 to 3.80	23.9 to 27.5
Rotation sensor mounting screw	M6 × 1.0	3.0 to 6.0	0.31 to 0.61	2.3 to 4.4
Spark plug	M14 × 1.25	24.5 to 29.4	2.50 to 2.99	18.1 to 21.6
Ignition coil mounting screw / nut	M6 × 1.0	9.81 to 11.3	1.00 to 1.15	7.24 to 8.33
Knock sensor mounting screw	M6 × 1.0	15.0 to 25.0	1.53 to 2.54	11.1 to 18.4
Water temperature sensor	M12 × 1.5	16.7 to 19.6	1.71 to 1.99	12.4 to 14.4
PCV Valve	M16 × 1.5	16.0 to 24.0	1.64 to 2.44	11.8 to 17.7
Exhaust manifold mounting nut	M7 × 1.0	15.7 to 18.6	1.60 to 1.89	11.6 to 13.7
Outlet of Exhaust manifold nut	M8 × 1.25	29.4 to 34.3	3.00 to 3.49	21.7 to 25.2
Starter B terminal nut	M8 × 1.25	5.88 to 11.8	0.600 to 1.20	4.34 to 8.70
Alternator's pulley nut	—	58.4 to 78.9	5.95 to 8.05	43.1 to 58.2
Inlet of Catalytic converter mounting screw / nut	M10 × 1.25	48.1 to 55.9	4.91 to 5.70	35.5 to 41.2
Outlet of catalytic converter mounting screw / nut	M12 × 1.25	77.5 to 90.2	7.91 to 9.19	57.2 to 66.5
LPG in	—	19.6 to 39.2	2.00 to 3.99	14.5 to 28.9

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[2] TIGHTENING TORQUES FOR GENERAL USE SCREWS, BOLTS

If the tightening torque is not specified, refer to the table below for the none specified torques values.

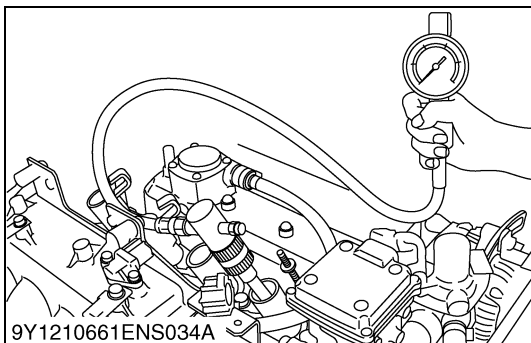
Indication on top of bolt	 4 No-grade or 4T			 7 7T			
	Unit	N·m	kgf·m	lbf·ft	N·m	kgf·m	lbf·ft
M6		7.9 to 9.3	0.80 to 0.95	5.8 to 6.8	9.81 to 11.2	1.00 to 1.15	7.24 to 8.31
M8		18 to 20	1.8 to 2.1	13 to 15	24 to 27	2.4 to 2.8	18 to 20
M10		40 to 45	4.0 to 4.6	29 to 33	49 to 55	5.0 to 5.7	37 to 41
M12		63 to 72	6.4 to 7.4	47 to 53	78 to 90	7.9 to 9.2	58 to 66

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4. CHECKING, DISASSEMBLING AND SERVICING

[1] CHECKING AND ADJUSTING

(1) Engine Body



Compression Pressure

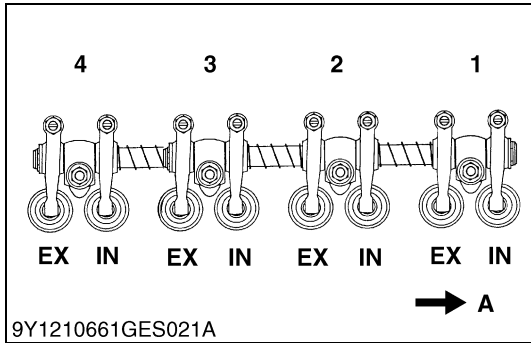
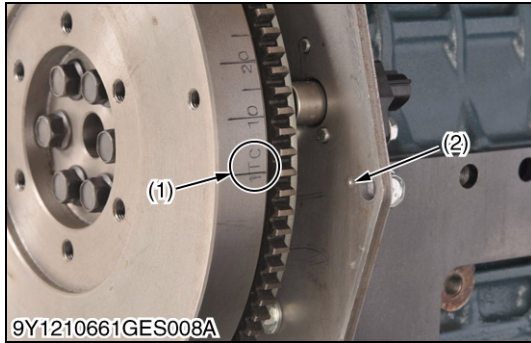
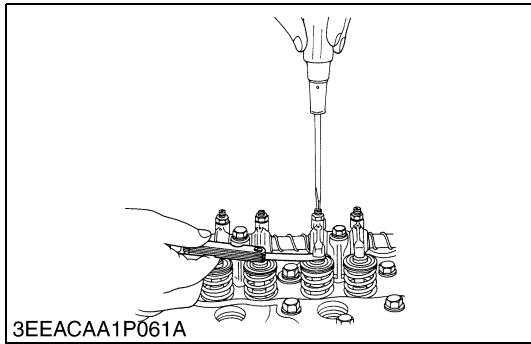
1. Run the engine until it is warmed up.
2. Stop the engine.
3. Remove the air cleaner, the converter and all spark plugs.
4. Set a compression tester with the adaptor to the spark plug hole.
5. Run the engine with the starter for 5 to 10 seconds keeping throttle valve fully open and read the maximum compression pressure.
6. Repeat steps 4 and 5 for each cylinder.
7. If the measurement is below the allowable limit, apply a small amount of oil to the cylinder wall through the spark plug hole and measure the compression pressure again.
8. If the compression pressure is still less than the allowable limit, check the top clearance, valve clearance and cylinder head.
9. If the compression pressure increases after applying oil, check the cylinder wall and piston rings.

■ NOTE

- Check the compression pressure with the specified valve clearance.
- Always use a fully charged battery for performing this test.
- Variances in cylinder compression values should be under 10 %.
- Replace the converter gasket with a new one

Compression pressure	Factory specification	1.27 MPa 13.0 kgf/cm ² 185 psi
	Allowable limit	0.88 MPa 9.0 kgf/cm ² 130 psi

9Y1210661ENS0006US0



Adjusting Valve Clearance

■ **IMPORTANT**

- **The clearance must be checked and adjusted when engine is cold.**
1. Remove the cylinder head cover and the spark plugs.
 2. Align the "1TC" mark (1) on the flywheel and alignment mark (2) on the rear end plate so that the No. 1 piston comes to the compression top dead center.
 3. Check the following valve clearance marked with "☆" using a feeler gauge.
 4. If the clearance is not within the factory specifications, adjust with the adjusting screw.
 5. Then turn the flywheel 6.28 rad (360 °), and align the "1TC" mark (1) on the flywheel and alignment mark (2) on the rear end plate so that the No. 1 piston comes to the overlap position.
 6. Check the following valve clearance marked with "☆" using a feeler gauge.
 7. If the clearance is not within the factory specifications, adjust with the adjusting screw.

Adjustable Cylinder Location of Piston		Intake valve	Exhaust valve
When No. 1 piston is at compression top dead center	1st	☆	☆
	2nd	☆	
	3rd		☆
	4th		
When No. 1 piston is at overlap position	1st		
	2nd		☆
	3rd	☆	
	4th	☆	☆
Intake and exhaust valve clearance (cold)	Factory specification	0.145 to 0.185 mm 0.00571 to 0.00728 in.	

■ **NOTE**

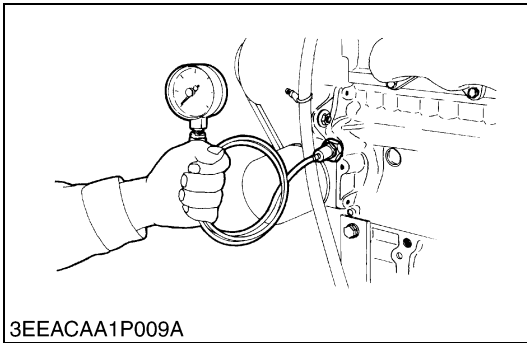
- **The sequence of cylinder numbers is given as No. 1, No. 2, No. 3 and No. 4 starting from the gear case side.**
- **After adjusting the valve clearance, secure the adjusting screw with the lock nut.**

- (1) "1TC" Mark
- (2) Alignment Mark

A: Gear Case Side

9Y1210661ENS0087US0

(2) Lubricating System



Engine Oil Pressure

1. Remove the engine oil pressure switch, and set an oil pressure tester.
2. Start the engine. After warming up, measure the oil pressure of both idling and rated speeds.
3. If the oil pressure is less than the allowable limit, check the following.
 - Engine oil insufficient
 - Oil pump defective
 - Oil strainer clogged
 - Oil filter cartridge clogged
 - Oil gallery clogged
 - Excessive oil clearance
 - Foreign matter in the relief valve

(When reassembling)

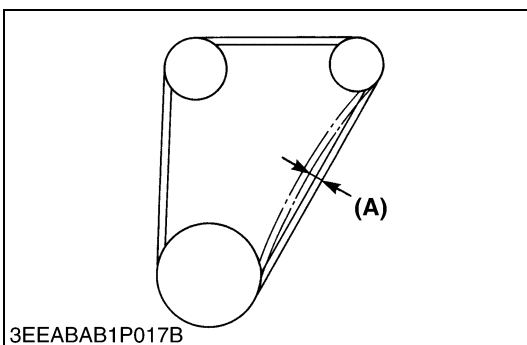
- After checking the engine oil pressure, tighten the engine oil pressure switch to the specified torque.

Engine oil pressure	At idle speed	Factory specification	49 kPa 0.50 kgf/cm ² 7.1 psi
	At rated speed	Factory specification	196 to 441 kPa 2.00 to 4.49 kgf/cm ² 28.5 to 63.9 psi
		Allowable limit	147 kPa 1.50 kgf/cm ² 21.3 psi

Tightening torque	Oil pressure switch	14.7 to 19.6 N·m 1.50 to 1.99 kgf·m 10.9 to 14.4 lbf·ft
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9Y1210661ENS0008US0

(3) Cooling System



Fan Belt Tension

1. Measure the deflection **(A)**, depressing the belt halfway between the fan drive pulley and alternator pulley at specified force 98 N (10 kgf, 22 lbf).
2. If the measurement is not within the factory specifications, loosen the alternator mounting screws and relocate the alternator to adjust.

Deflection (A)	Factory specification	7.0 to 9.0 mm 0.28 to 0.35 in.
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(A) Deflection

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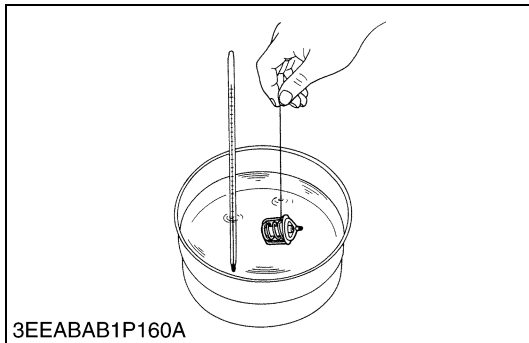
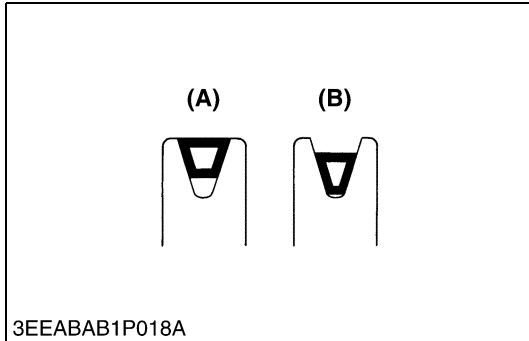
Fan Belt Damage and Wear

1. Check the fan belt for damage.
2. If the fan belt is damaged, replace it.
3. Check if the fan belt is worn and sunk in the pulley groove.
4. If the fan belt is nearly worn out and deeply sunk in the pulley groove, replace it.

(A) Good

(B) Bad

9Y1210318GEG0002US0



Thermostat Valve Opening Temperature

1. Suspend the thermostat in the water by a string with its end inserted between the valve and seat.
2. Heating the water gradually, read the temperature when the valve opens and leaves the string.
3. Continue heating and read the temperature when the valve opens approx. 8 mm (0.3 in.).
4. If the measurement is not within the factory specifications, replace the thermostat.

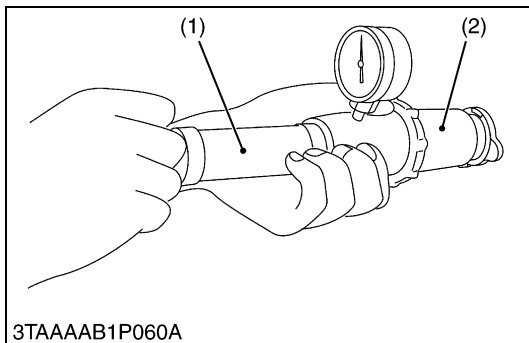
Thermostat's valve opening temperature	Factory specification	69.5 to 72.5 °C 157.1 to 162.5 °F
Temperature at which thermostat completely opens	Factory specification	85 °C 185 °F

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CAUTION

- When removing the radiator cap, wait at least ten minutes after the engine has stopped and cooled down. Otherwise, hot water may gush out, scalding nearby people.

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Radiator Cap Air Leakage

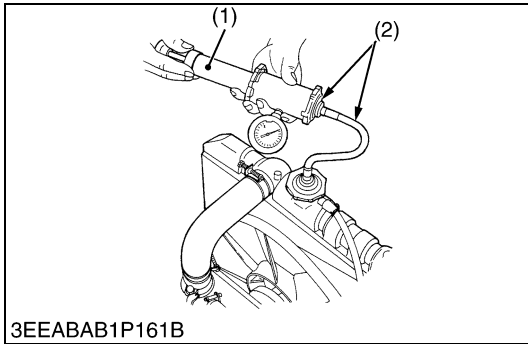
1. Set a radiator tester (1) and an adaptor (2) on the radiator cap.
2. Apply the specified pressure (90 kPa, 0.9 kgf/cm², 10 psi), and measure the time for the pressure to fall to 60 kPa (0.6 kgf/cm², 9 psi).
3. If the measurement is less than the factory specification, replace the radiator cap.

Pressure falling time	Factory specification	10 seconds or more 88 → 59 kPa 0.89 → 0.61 kgf/cm ² 12 → 8.6 psi
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(1) Radiator Tester

(2) Adaptor

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3EEABAB1P161B

Radiator Water Leakage

1. Pour a specified amount of water into the radiator.
2. Set a radiator tester (1) and an adaptor (2) and raise the water pressure to the specified pressure (210 kPa, 2.14 kgf/cm², 30.5 psi).
3. Check the radiator for water leaks.
4. For water leak from the pinhole, repair with the radiator cement. When water leak is excessive, replace the radiator.

Radiator water leakage test pressure	Factory specification	No leak at specified pressure
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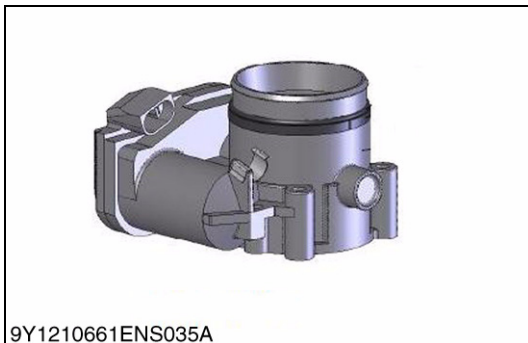
NOTE

- The pressure of the leak test is different from each radiator specification. Thus, do the leak test, refer to the test pressure of each radiator specification.

- (1) Radiator Tester (2) Adaptor

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(4) Fuel System



9Y1210661ENS035A

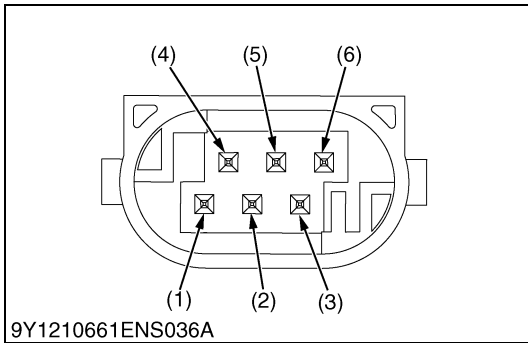
Resistance of Throttle Body

1. Disconnect the connector.
2. Measure the resistance between terminal 1 and terminal 4 with an ohmmeter.
3. If the resistance is 0 ohm or infinity, replace it.
4. Measure the resistance between terminal 2 and terminal 3 with an ohmmeter.
5. If the resistance is not with in the factory specifications, replace it.

Resistance	Factory specification	Terminal 1 – Terminal 4	Continuity
		Terminal 2 – Terminal 3	0.875 to 1.625 kΩ at 20 °C (68 °F)

- (1) Terminal 1 (2) Terminal 2 (3) Terminal 3 (4) Terminal 4 (5) Terminal 5 (6) Terminal 6

9Y1210661ENS0091US0

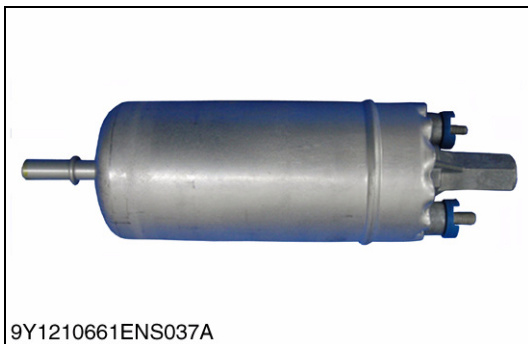


9Y1210661ENS036A

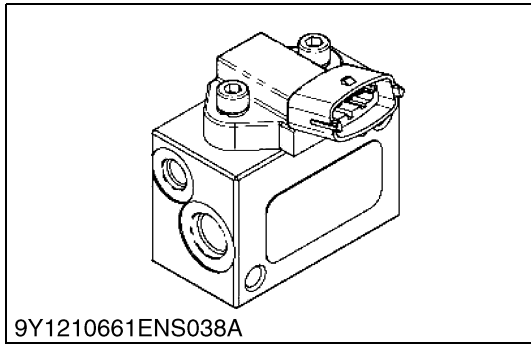
Fuel Pump

1. Disconnect the wiring.
2. Measure the resistance between terminals with an ohmmeter.
3. If the resistance is 0 ohm or infinity, replace it.

9Y1210661ENS0092US0



9Y1210661ENS037A



Resistance of Fuel Pressure Manifold (FPM)

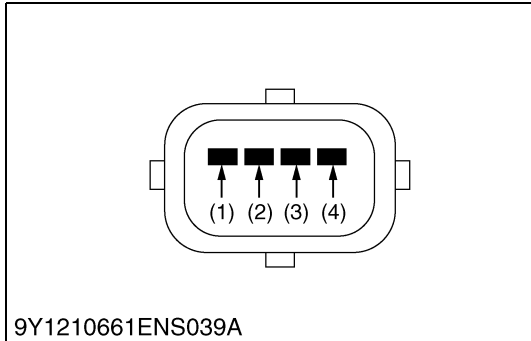
1. Disconnect the connector.
2. Measure the resistance between terminal 1 and terminal 2 with an ohmmeter.
3. If the resistance is not within the factory specifications, replace it.

Resistance	Factory specification	Terminal 1 – Terminal 2	2.35 to 2.65 kΩ at 20 °C (68 °F)
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- (1) Terminal 1
(2) Terminal 2

- (3) Terminal 3
(4) Terminal 4

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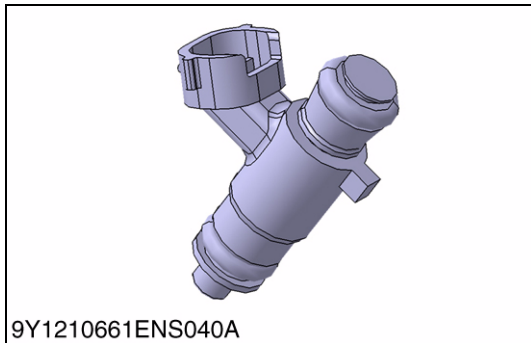


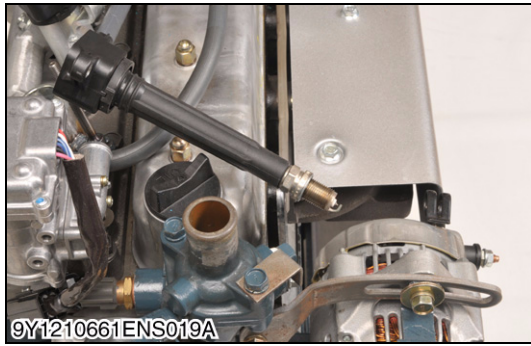
Injector

1. Disconnect the connector.
2. Measure the resistance between terminals with an ohmmeter.
3. If the resistance is not within the factory specifications, replace it.

Resistance	Factory specification	11.7 to 12.3 Ω at 20 °C (68 °F)
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9Y1210661ENS0094US0





Spark Test

(For gasoline)

1. Disconnect all injector connector.
2. Remove the spark plug, put it inside the ignition coil firmly, and then ground the threaded section to the engine body (not to painted or resin parts).
3. Rotate the starter with the key switch and check that the plug sparks.
4. If test is **OK**, tighten the spark plug with a plug wrench.

(For LPG)

1. Close the LPG tank valve.
2. Disconnect the lock off valve connector.
3. Remove the spark plug, put it inside the ignition coil firmly, and then ground the threaded section to the engine body (not to painted or resin parts).
4. Disconnect other ignition coil connector.
5. Rotate the starter with the key switch and check that the plug sparks.
6. If test is **OK**, tighten the spark plug with a plug wrench.

■ IMPORTANT

(When reassembling)

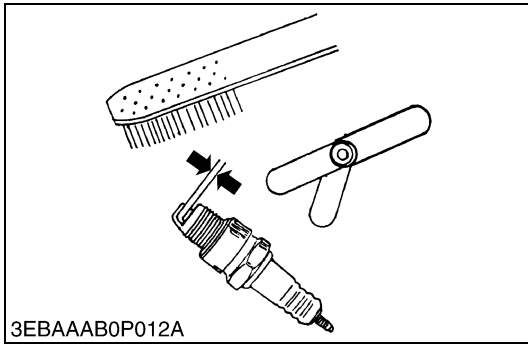
- **Put the ignition coil inside the spark plug terminal firmly.**
 - **Make sure that the wiring and the ignition coil are correctly connected.**
 - **Make sure that the removed connectors are correctly connected.**
- Open the LPG tank valve (for LPG).**



CAUTION

- **This test is hazardous of electric shocks. Never use hand or screwdriver to press the plug to ground it to the engine body.**
- **Keep inflammable away from the engine.**

9Y1210661ENS0088US0



Spark Plug Gap

1. Remove the spark plug, and remove carbon from the electrode with a wire brush or other tools.
2. Measure the spark plug gap with a feeler gauge, and repair or replace the plug if the measured gap differs from the factory specification.
3. Replace the plug if the electrode or the insulator is deformed or cracked.
4. Tighten the plug with a plug wrench.

■ IMPORTANT

(When reassembling)

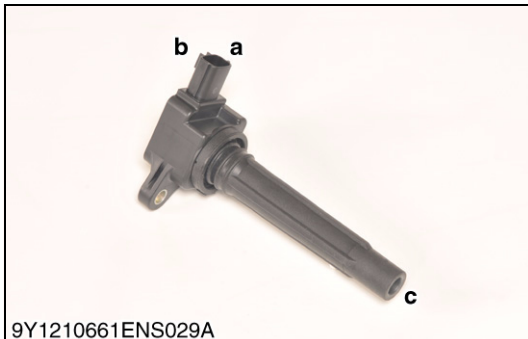
- Put the ignition coil inside the spark plug terminal firmly.
- Make sure that the wiring and the ignition coil are correctly connected.
- Fix the ignition coil by screw / nut.

Spark plug gap	Factory specification	0.70 to 0.80 mm 0.028 to 0.031 in
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Spark plug	NGK: IFR6F8DN
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Tightening torque	Spark plug	24.5 to 29.4 N·m 2.50 to 2.99 kgf·m 18.1 to 21.6 lbf·ft
	Ignition coil mounting screw / nut	9.81 to 11.3 N·m 1.00 to 1.15 kgf·m 7.24 to 8.33 lbf·ft

9Y1210661ENS0089US0

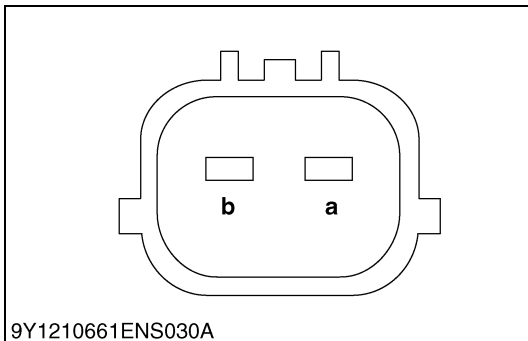


Resistance of Ignition Coil

1. Disconnect the ignition coil.
2. Measure the resistance with an ohmmeter.
3. If the resistance is not within the factory specifications, replace it.

Resistance	Factory specification	a – b	0.63 to 0.77 Ω at 25 °C (77 °F)
		a – c	7.29 to 8.91 kΩ at 25 °C (77 °F)

9Y1210661ENS0079US0



(6) Electrical System



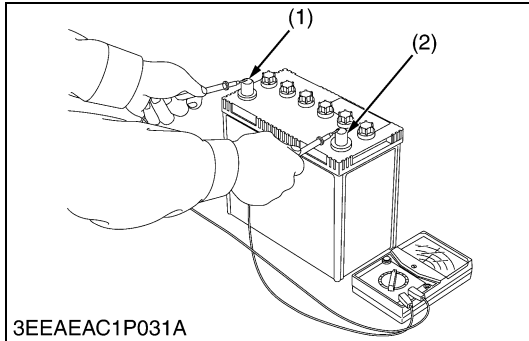
CAUTION

- To avoid accidental short circuit, be sure to attach the positive cable to the positive terminal before the negative cable is attached to the negative terminal.
- Never remove the battery cap while the engine is running.
- Keep electrolyte away from eyes, hands and clothes. If you are splattered with it, wash it away completely with water immediately.
- Keep open sparks and flames away from the battery at all times. Hydrogen gas mixed with oxygen becomes very explosive.

IMPORTANT

- If the machine is to be operated for a short time without battery (using a slave battery for starting), use additional current (lights) while engine is running and insulate terminal of battery. If this advice is disregarded, damage to alternator and regulator may result.

9Y1210661ENS0096US0



Battery Voltage

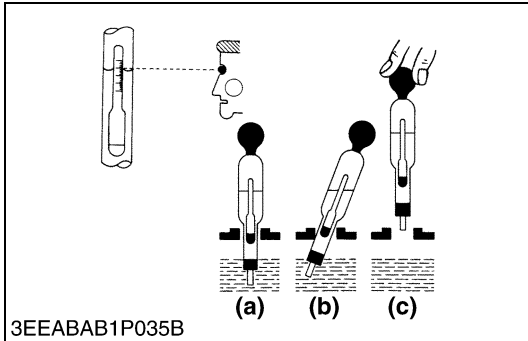
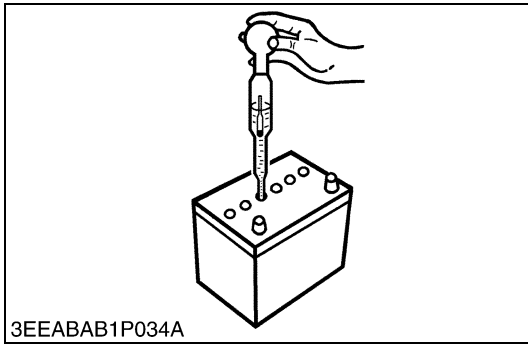
1. Stop the engine.
2. Measure the voltage with a circuit tester between the battery terminals.
3. If the battery voltage is less than the factory specification, check the battery specific gravity and recharge the battery.

Battery voltage	Factory specification	More than 12 V
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(1) Positive Terminal

(2) Negative Terminal

9Y1210661ENS0097US0



Battery Specific Gravity

1. Check the specific gravity of the electrolyte in each cell with a hydrometer.
2. When the electrolyte temperature differs from that at which the hydrometer was calibrated, correct the specific gravity reading following the formula mentioned in **(Reference)**.
3. If the specific gravity is less than 1.215 (after it is corrected for temperature), charge or replace the battery.
4. If the specific gravity differs between any two cells by more than 0.05, replace the battery.

■ **NOTE**

- **Hold the hydrometer tube vertical without removing it from the electrolyte.**
- **Do not suck too much electrolyte into the tube.**
- **Allow the float to move freely and hold the hydrometer at eye level.**
- **The hydrometer reading must be taken at the highest electrolyte level.**

(Reference)

- Specific gravity slightly varies with temperature. To be exact, the specific gravity decreases by 0.0007 with an increase of 1 °C (0.0004 with an increase of 1 °F) in temperature, and increases by 0.0007 with a decreases of 1 °C (0.0004 with a decrease of 1 °F).

Therefore, using 20 °C (68 °F) as a reference, the specific gravity reading must be corrected by the following formula:

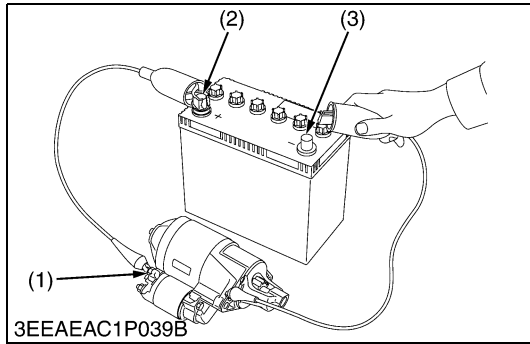
- Specific gravity at 20 °C = Measured value + 0.0007 × (electrolyte temperature - 20 °C)
- Specific gravity at 68 °F = Measured value + 0.0004 × (electrolyte temperature - 68 °F)

Gravity of electrolyte 20 °C (68 °F)	State of discharging
1.260	100
1.240	75
1.200	50
1.170	25
1.120	Totally discharged

(a) Good
(b) Bad

(c) Bad

9Y1210661ENS0098US0



Motor Test

⚠ CAUTION

- **Secure the starter to prevent it from jumping up and down while testing the motor.**
1. Disconnect the battery negative cable from the battery.
 2. Disconnect the battery positive cable from the battery.
 3. Disconnect the leads from the starter **B** terminal.
 4. Remove the starter from the engine.
 5. Connect a jumper lead from the starter **C** terminal (1) to the battery positive terminal (2).
 6. Connect a jumper lead momentarily between the starter's body and the battery negative terminal (3).
 7. If the motor does not run, starter is failure. Repair or replace the starter.

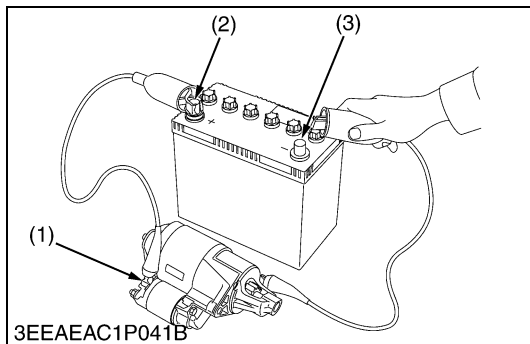
■ NOTE

- **B terminal: It is the terminal which connects the cable from the battery to the starter.**
- **C terminal: It is the terminal which connects the cable from the motor to the magnet switch.**

- (1) C Terminal
(2) Positive Terminal

- (3) Negative Terminal

9Y1210318ENS0038US0



Magnetic Switch Test

1. Disconnect the battery negative cable from the battery.
2. Disconnect the battery positive cable from the battery.
3. Disconnect the leads from the starter **B** terminal.
4. Remove the starter from the engine.
5. Connect a jumper lead from the starter **S** terminal (1) to the battery positive terminal (2).
6. Connect a jumper lead momentarily between the starter's body and the battery negative terminal (3).
7. If the pinion gear does not pop out, the magnetic switch is failure. Repair or replace the starter.

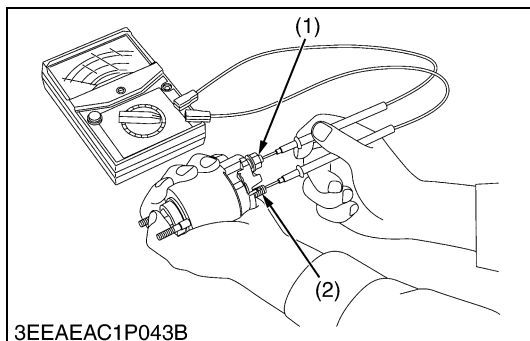
■ NOTE

- **B terminal: It is the terminal which connects the cable from the battery to the starter.**
- **S terminal: It is the terminal which connects the cable from the starter switch to the magnet switch.**

- (1) S Terminal
(2) Positive Terminal

- (3) Negative Terminal

9Y1210318ENS0039US0



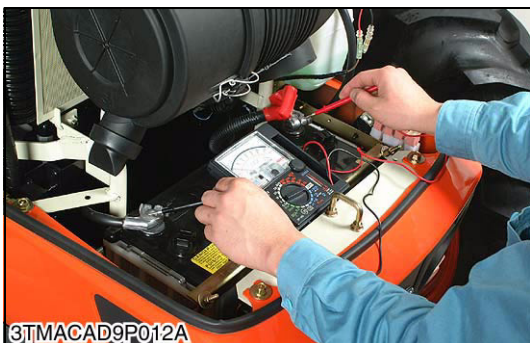
Magnet Switch Continuity Test

1. Check the continuity across the **C** terminal (1) and the **B** terminal (2) with a circuit tester, pushing in the plunger.
2. If not continuous or if a certain value is indicated, replace the magnet switch.

- (1) C Terminal

- (2) B Terminal

9Y1210318ENS0040US0



Alternator on Unit Test

(Before testing)

- Before alternator on unit test, check the battery terminal connections, circuit connection, fan belt tension, charging indicator lamp, fuses on the circuit, and abnormal noise from the alternator.
- Prepare full charged battery for the test.

■ NOTE

- **Be careful not to touch the rotating engine parts while engine is running.**

Keep safety distance from the engine rotating parts.

1. Start the engine.
2. When the engine is operating measure the voltage between two battery terminals. If the voltage is between 14.2 V and 14.8 V, the alternator is operating normally.
3. If the results of alternator on unit test are not within the specifications, disassemble the alternator and check the each component part for finding out the failure. See the "DISASSEMBLING AND ASSEMBLING" and "SERVICING" for alternator.

Regulating voltage at no load	Factory specification	14.2 to 14.8 V at 5000 min ⁻¹ (rpm), 25 °C (77 °F)
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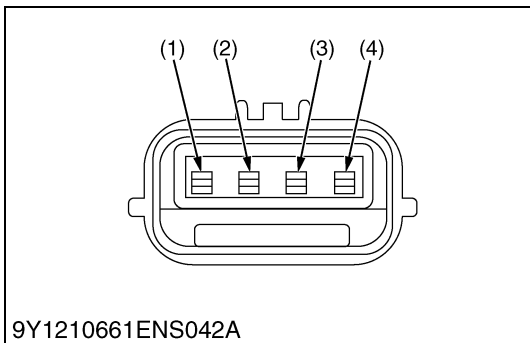
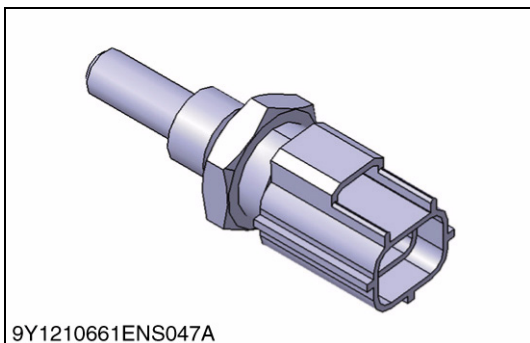
9Y1210318ENS0043US0

Resistance of Water Temperature Sensor

1. Disconnect the connector.
2. Measure the resistance with an ohmmeter.
3. If the resistance is not with in the factory specifications, replace it.

Resistance	Factory specification	2.32 to 2.59 kΩ at 20 °C (68 °F)
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9Y1210661ENS0099US0



Resistance of Temperature and Manifold Absolute Pressure (TMAP) Sensor

1. Measure the resistance between the terminal 1 and terminal 3 of the sensor.
2. If the measurement is not in the factory specification, the sensor is defective. Then replace it with a new one.
3. If the measurement is in the factory specification, the sensor is correct electrically.

Resistance of pressure sensor	Factory specification	Terminal 1 – Terminal 3	5.4 to 6.6 kΩ at 0 °C (32 °F)
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- (1) Terminal 1
- (2) Terminal 2

- (3) Terminal 3
- (4) Terminal 4

9Y1210661ENS0100US0

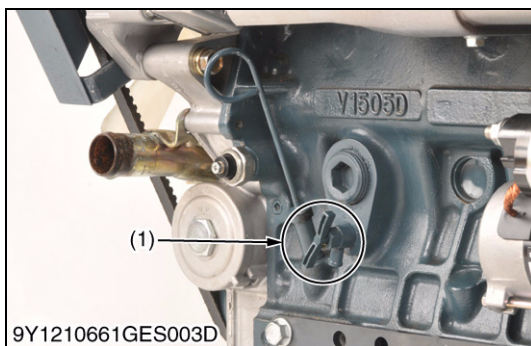
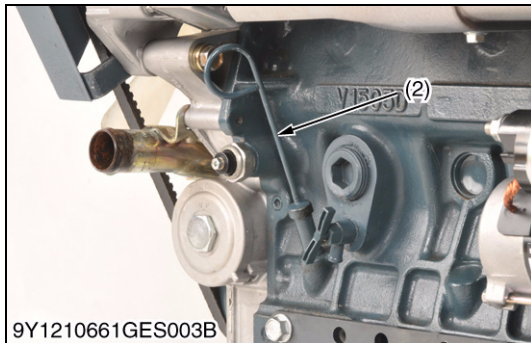
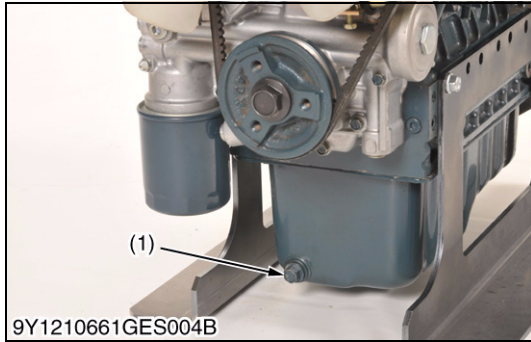
[2] DISASSEMBLING AND ASSEMBLING

■ IMPORTANT

- When reassembling, replace all of the O-rings and gaskets by new ones.
- When disassembling the LPG engine after completely consuming the fuel in piping.
- In order to reduce the fuel pressure, do not remove the fuel hose at least 3 minutes after stopping the engine.

9Y1210661ENS0101US0

(1) Draining Coolant and Engine Oil



Draining Engine Oil

1. Start and warm up the engine for approx. 5 minutes.
2. Place an oil pan underneath the engine.
3. Remove the drain plug (1) to drain oil.
4. After draining, screw in the drain plug (1).

(When refilling)

- Fill the engine oil up to the upper line on the dipstick (2).

■ IMPORTANT

- When using an oil of different maker or viscosity from the previous one, remove all of the old oil.
- Never mix two different types of oil.
- Engine oil should have properties of API classification SH.
- Use the proper SAE Engine Oil according to ambient temperature.

Above 25 °C (77 °F)	SAE30 or SAE10W-30 or SAE15W-40
0 °C to 25 °C (32 °F to 77 °F)	SAE20 or SAE10W-30
0 °C to -20 °C (32 °F to -4 °F)	SAE10W or SAE10W-30

Engine oil capacity	6.0 L 1.6 U.S. gals
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Tightening torque	Drain plug	32.4 to 37.3 N·m 3.31 to 3.80 kgf·m 23.9 to 27.5 lbf·ft
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(1) Drain Plug

(2) Dipstick

9Y1210661ENS0014US0

Draining Coolant

⚠ CAUTION

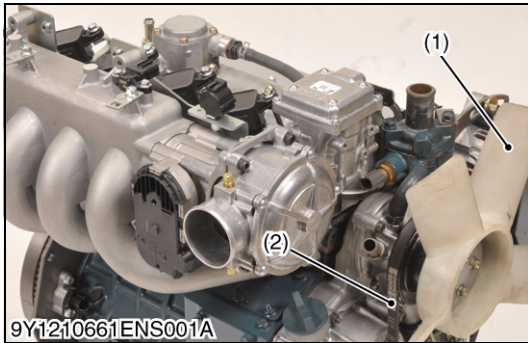
- Never remove radiator cap while operating or immediately after stopping. Otherwise, hot water will spout out from the radiator. Wait for more than ten minutes to cool the radiator, before opening the cap.

1. Prepare a bucket. Open the coolant drain cock.

(1) Coolant Drain Cock

9Y1210661ENS0015US0

(2) External Components



Alternator, Starter and Others

1. Remove the air cleaner, catalytic converter and exhaust manifold.
2. Remove the cooling fan (1), fan pulley and fan belt (2).
3. Remove the alternator.
4. Remove the starter.

(When reassembling)

- Check to see that there are no cracks on the belt surface.
- Replace the exhaust system gasket with a new one.

■ IMPORTANT

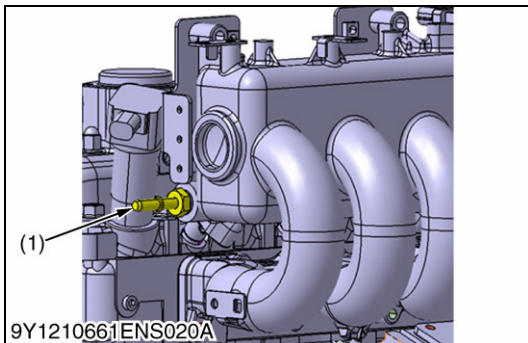
- **After reassembling the fan belt (2), be sure to adjust the fan belt tension.**
- **Do not confuse the direction of the cooling fan (1).**
- **To trace of the catalytic converter, put down the catalyst identification and engine identification when new service catalytic converter is installed.**

Tightening torque	Exhaust manifold mounting nut	15.7 to 18.6 N·m 1.60 to 1.89 kgf·m 11.6 to 13.7 lbf·ft
	Outlet of exhaust manifold nut	29.4 to 34.3 N·m 3.00 to 3.49 kgf·m 21.7 to 25.2 lbf·ft
	Inlet of catalytic converter mounting screw / nut	48.1 to 55.9 N·m 4.91 to 5.70 kgf·m 35.5 to 41.2 lbf·ft
	Outlet of catalytic converter mounting screw / nut	77.5 to 90.2 N·m 7.91 to 9.19 kgf·m 57.2 to 66.5 lbf·ft

(1) Cooling Fan

(2) Fan Belt

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Fuel Line (WG1605-G-E3, WG1605-GL-E3)

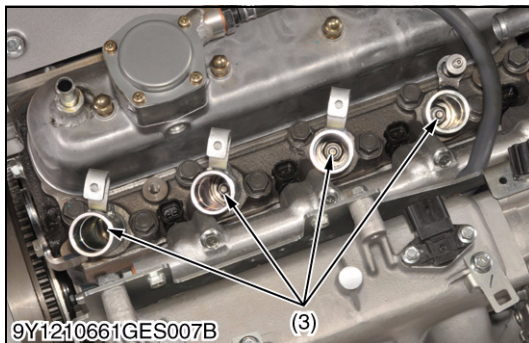
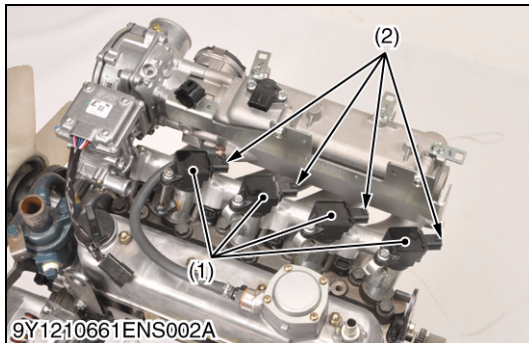
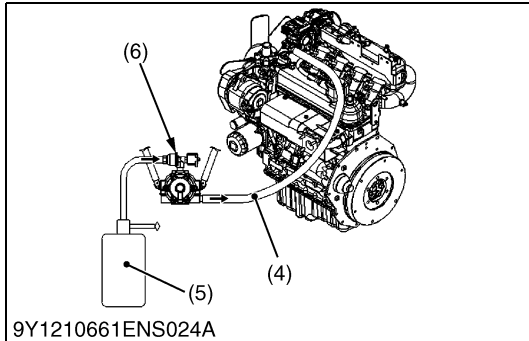
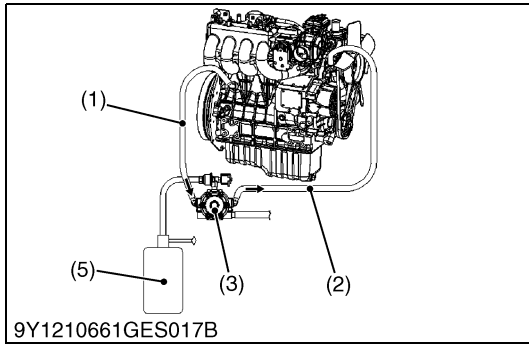
1. Disconnect the gasoline hose from the connector (1).

⚠ CAUTION

- **In order to reduce the fuel pressure, do not remove the fuel hose at least 3 minutes after stopping the engine.**
- **Remove the hose after covering the hose with a waste to prevent scatter of fuel.**

(1) Gasoline Hose Connector

9Y1210661ENS0103US0



Vapor Hose and Coolant Hose (WG1605-L-E3, WG1605-GL-E3)

⚠ CAUTION

- Close the LPG tank valve.
- In order to reduce the fuel pressure, do not remove the fuel hose at least 3 minutes after stopping the engine.
- Vent the air of the water passage of vaporizer (3) after detaching the coolant hose (1), (2).

1. Disconnect the vapor hose (4).
2. After drain the coolant, disconnect the coolant hose (1), (2).
3. Remove the vaporizer (3) (if necessary).

■ IMPORTANT

- When disassembling the fuel system, make sure that the LPG tank valve is closed.

(When reassembling)

- Bleed the vaporizer after supplying coolant.

- | | |
|------------------|--------------------|
| (1) Coolant Hose | (4) Vapor Hose |
| (2) Coolant Hose | (5) LPG Tank |
| (3) Vaporizer | (6) Lock Off Valve |

9Y1210661ENS0017US0

Ignition Coil and Spark Plug

1. Disconnect the ignition coil connector (2).
2. Remove the ignition coil (1).
3. Remove the spark plug (3).

(When reassembling)

- Tighten the spark plug with a plug wrench.

■ NOTE

(When reassembling)

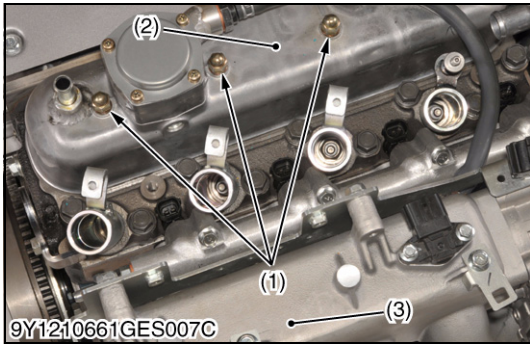
- Put the ignition coil inside the spark plug terminal firmly.
- Make sure that the wiring and the ignition coil are correctly connected.
- Make sure that the removed connectors are correctly connected.
- Fix the ignition coil by screw / nut.

Tightening torque	Spark plug	24.5 to 29.4 N·m 2.50 to 2.99 kgf·m 18.1 to 21.5 lbf·ft
	Ignition coil mounting screw / nut	9.81 to 11.3 N·m 1.00 to 1.15 kgf·m 7.24 to 8.33 lbf·ft

- | | |
|-----------------------------|----------------|
| (1) Ignition Coil | (3) Spark Plug |
| (2) Ignition Coil Connector | |

9Y1210661ENS0080US0

(3) Cylinder Head, Valves and Oil Pan



Cylinder Head Cover

1. Remove the cylinder head cover cap nut (1).
2. Remove the cylinder head cover (2).
3. Remove the intake manifold (3).

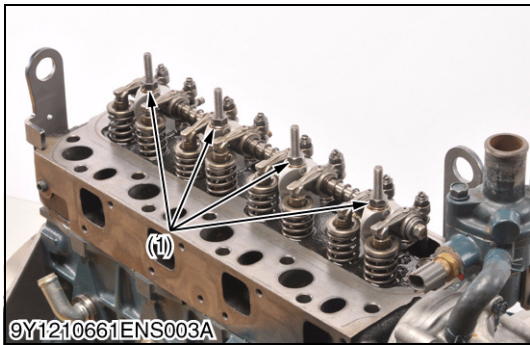
(When reassembling)

- Check to see if the cylinder head cover gasket is not defective.

Tightening torque	Cylinder head cover cap nut	6.9 to 8.8 N·m 0.71 to 0.89 kgf·m 5.1 to 6.4 lbf·ft
-------------------	-----------------------------	---

- (1) Cylinder Head Cover Cap Nut (3) Intake Manifold
(2) Cylinder Head Cover

9Y1210661ENS0081US0



Rocker Arm and Push Rod

1. Remove the rocker arm bracket nuts (1).
2. Remove the rocker arm assembly (2).
3. Remove the push rods (3).

(When reassembling)

- When putting the push rods (3) onto the tappets (4), check to see if their ends are properly engaged with the dimples.

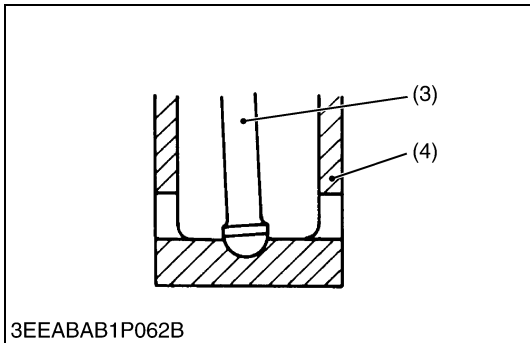
■ IMPORTANT

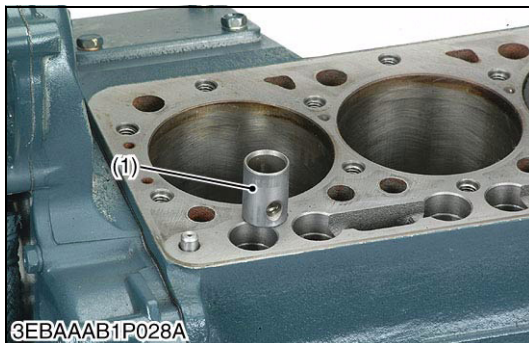
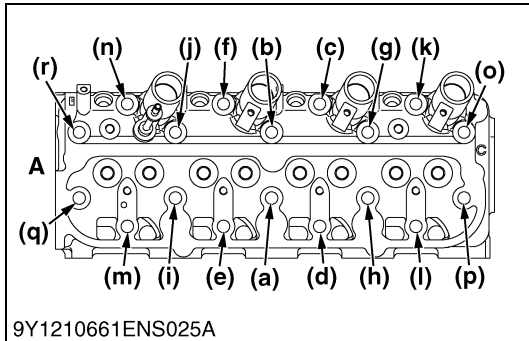
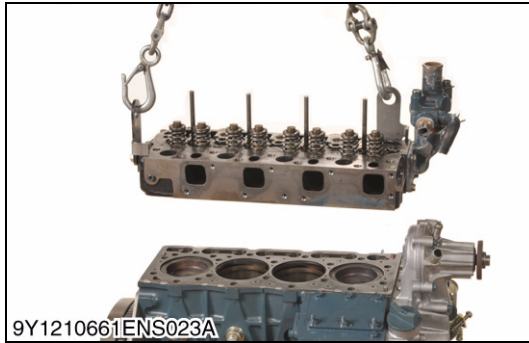
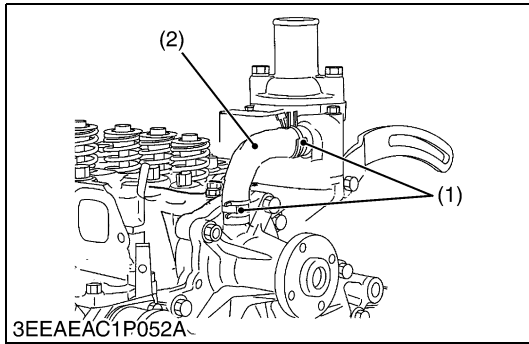
- **After installing the rocker arm, be sure to adjust the valve clearance.**

Tightening torque	Rocket arm bracket nut	21.6 to 26.5 N·m 2.21 to 2.70 kgf·m 16.0 to 19.5 lbf·ft
-------------------	------------------------	---

- (1) Rocker Arm Bracket Nut (3) Push Rod
(2) Rocker Arm Assembly (4) Tappet

9Y1210661ENS0082US0





Cylinder Head

1. Loosen the pipe clamps (2), and remove the water return hose (1).
2. Remove the cylinder head screw in the order of (r) to (a).
3. Remove the spark plug.
4. Remove the injector flange (WG1605-G-E3, WG1605-GL-E3) / ignition coil flange (WG1605-L-E3).
5. Lift up the cylinder head to detach.
6. Remove the cylinder head gasket.

(When reassembling)

- Replace the cylinder head gasket with a new one.
- Tighten the cylinder head screws after applying sufficient oil.
- Tighten the cylinder head screws in order of (a) to (r).
- Tighten them uniformly, or the head may deform in the long run.

NOTE

- injector flange (WG1605-G-E3, WG1605-GL-E3), ignition coil flange (WG1605-L-E3) mounting screw: length = 105 mm (4.13 in.)
- others: 80.5 mm (3.17 in.)

Tightening torque	Cylinder head screw	63.7 to 68.6 N·m 6.50 to 6.99 kgf·m 47.0 to 50.5 lbf·ft
	Spark plug	24.5 to 29.4 N·m 2.50 to 2.99 kgf·m 18.1 to 21.5 lbf·ft

- (1) Water Return Hose
(2) Hose Clamp

A: Gear Case Side
(r) to (a): To Loosen
(a) to (r): To Tighten

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Tappets

1. Remove the tappets (1) from the crankcase.

(When reassembling)

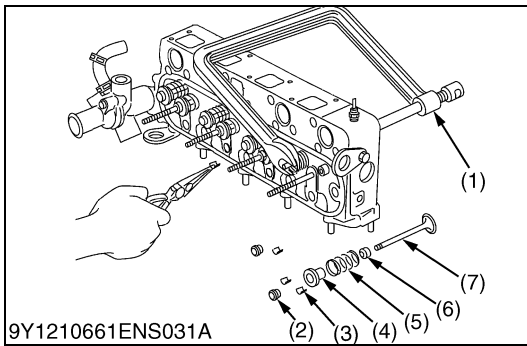
- Visually check the contact between tappets and cams for proper rotation. If defect is found, replace tappets.
- Before installing the tappets, apply engine oil thinly around them.

IMPORTANT

- Do not change the combination of tappet and tappet guide.

- (1) Tappet

9Y1210318ENS0065US0



Valves

1. Remove the valve caps (2).
2. Remove the valve spring collet (3), pushing the valve spring retainer (4) with valve spring replacer (1).
3. Remove the valve spring retainer (4), valve spring (5) and valve stem seal (6).
4. Remove the valve (7).

(When reassembling)

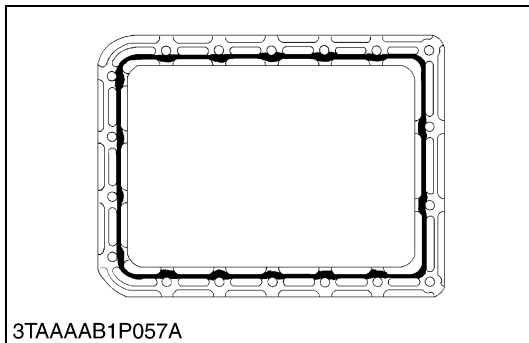
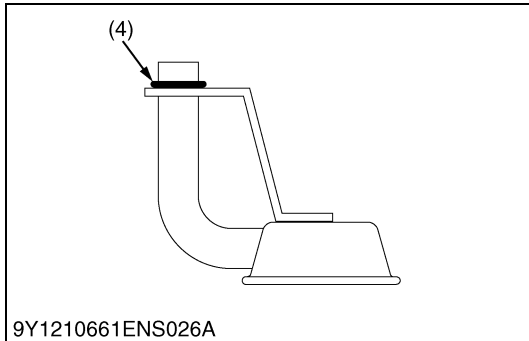
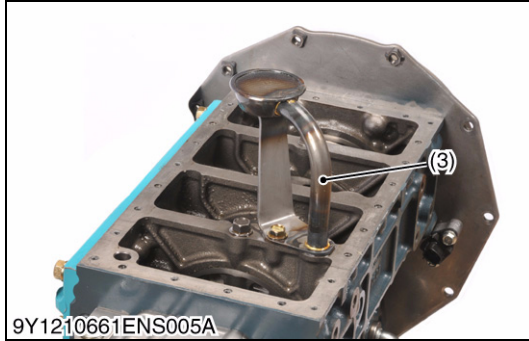
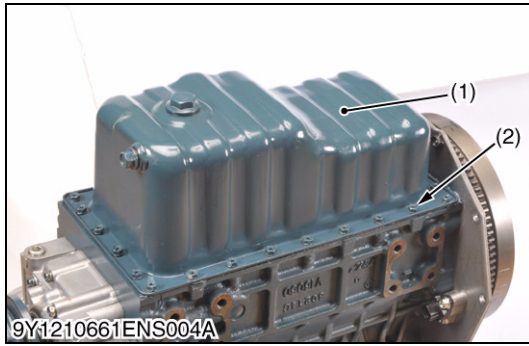
- Wash the valve stem and valve guide hole, and apply engine oil sufficiently.
- After installing the valve spring collets, lightly tap the stem to assure proper fit with a plastic hammer.

■ IMPORTANT

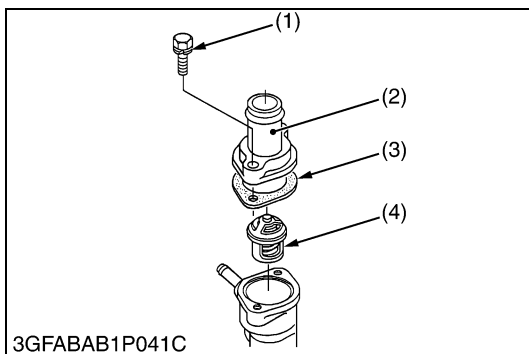
- **Do not change the combination of valve and valve guide.**

- | | |
|---------------------------|---------------------|
| (1) Valve Spring Replacer | (5) Valve Spring |
| (2) Valve Cap | (6) Valve Stem Seal |
| (3) Valve Spring Collet | (7) Valve |
| (4) Valve Spring Retainer | |

9Y1210661ENS0022US0



(4) Thermostat



Oil Pan and Oil Strainer

1. Remove the oil pan mounting screws (2).
2. Remove the oil pan (1) by lightly tapping the rim of the pan with a wooden hammer.
3. Remove the oil strainer (3).

(When reassembling)

- After cleaning the oil strainer, check to see that the filter mesh is clean, and install it.
- Visually check the O-ring (4), apply engine oil, and install it.
- Securely fit the O-ring to the oil strainer.
- To avoid uneven tightening, tighten oil pan mounting screws in diagonal order from the center.

■ **IMPORTANT**

- **Scrape off the old adhesive completely. Wipe the sealing surface clean. Now apply new adhesive 3.0 to 5.0 mm (0.12 to 0.19 in.) thick all over the contact surface. Apply the adhesive also on the center of the flange as well as on the inner wall of each bolt hole.**
- **Cut the nozzle of the "liquid gasket" (Three Bond 1207D or equivalent) container at its second notch. Apply "liquid gasket" about 5.0 mm (0.19 in.) thick. Within 20 minutes after the application of fluid sealant, reassemble the components. Wait then for about 30 minutes, and pour oil in the crankcase.**

- | | |
|----------------------------|------------------|
| (1) Oil Pan | (3) Oil Strainer |
| (2) Oil Pan Mounting Screw | (4) O-ring |

9Y1210661ENS0023US0

Thermostat Assembly

1. Remove the thermostat cover mounting screws (1), and remove the thermostat cover (2).
2. Remove the thermostat assembly (4).

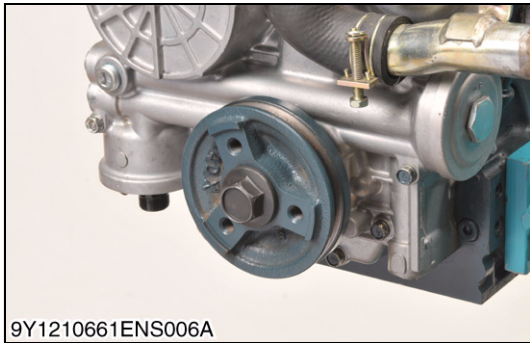
(When reassembling)

- Apply a liquid gasket (Three Bond 1215 or equivalent) only at the thermostat cover side of the gasket (3).

- | | |
|-------------------------------------|-----------------------------|
| (1) Thermostat Cover Mounting Screw | (3) Thermostat Cover Gasket |
| (2) Thermostat Cover | (4) Thermostat Assembly |

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(5) Timing Gear, Camshaft, Gear Shaft and PTO Shaft



Fan Drive Pulley

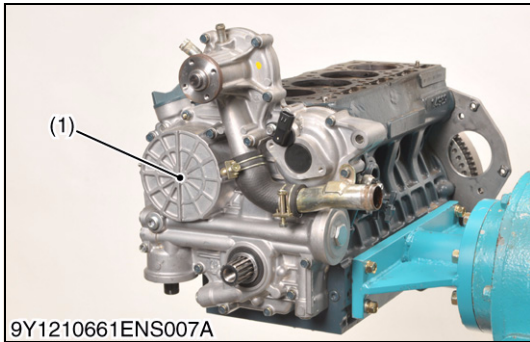
1. Secure the flywheel to keep it from turning.
2. Remove the fan drive pulley screw.
3. Draw out the fan drive pulley with a puller.

(When reassembling)

- Apply engine oil to the fan drive pulley retaining screws. And tighten it.

Tightening torque	Fan drive pulley screw	235 to 245 N·m 24.0 to 24.9 kgf·m 174 to 180 lbf·ft
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Gear Case

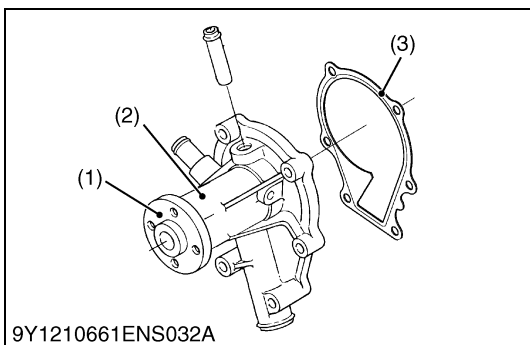
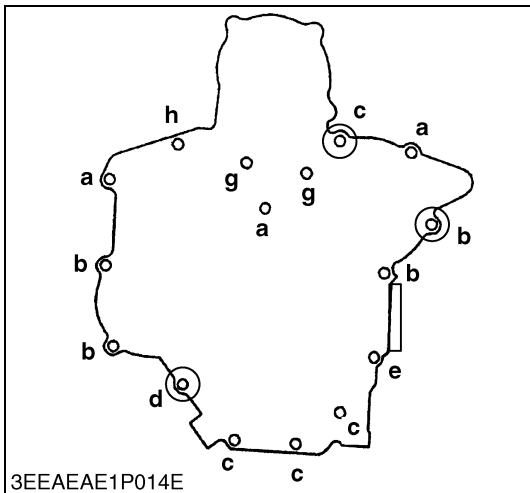
1. Remove the gear case (1).

(When reassembling)

- Apply a liquid gasket (Three Bond 1215 or equivalent) to both sides of the gear case gasket.

- | | |
|---------------|----------------------------------|
| (1) Gear Case | a: Bolt Length = 45 mm (1.8 in.) |
| | b: Bolt Length = 50 mm (2.0 in.) |
| | c: Bolt Length = 55 mm (2.2 in.) |
| | d: Bolt Length = 65 mm (2.6 in.) |
| | e: Bolt Length = 68 mm (2.7 in.) |
| | g: Bolt Length = 85 mm (3.3 in.) |
| | h: Nut |

9Y1210661ENS0025US0



Water Pump Assembly

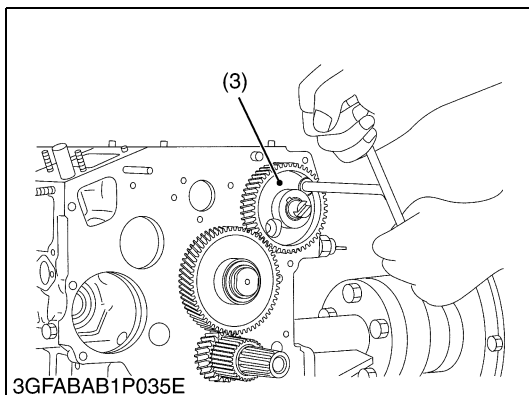
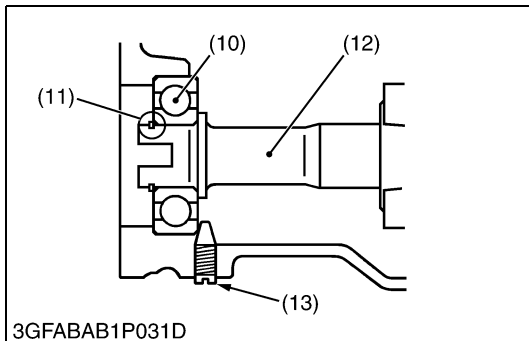
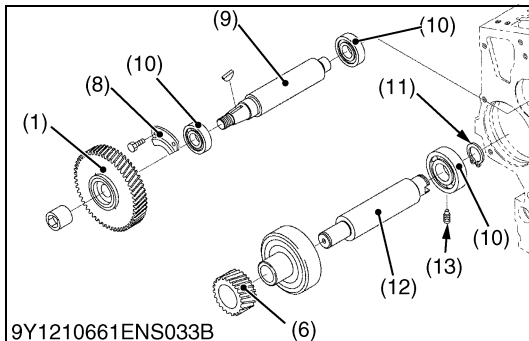
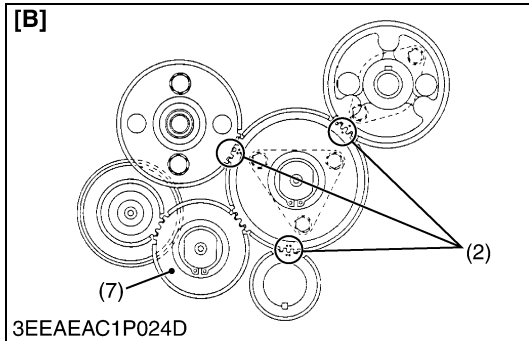
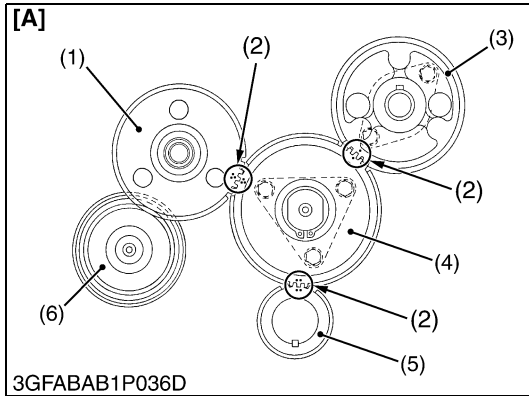
1. Remove the water pump assembly (2) from the gear case cover.

(When reassembling)

- Apply a liquid gasket (Three Bond 1215 or equivalent) to both sides of water pump gasket (3).

- | | |
|-------------------------|-----------------------|
| (1) Water Pump Flange | (3) Water Pump Gasket |
| (2) Water Pump Assembly | |

9Y1210661ENS0104US0



Cam Gear, Idle Gear 1, 2 and Governor Gear

1. Remove the idle gear 2 (7) / idle gear 1 (4).
2. Remove the fuel camshaft stopper (8).
3. Draw out the injection pump gear (1) with fuel gear shaft (9).
4. Remove the camshaft stopper bolt.
5. Remove the cam gear (3) with camshaft.
6. Remove the external snap ring (11) from the PTO shaft (12).
7. Remove the governor gear (6) with PTO shaft (12).

■ **NOTE**

- **Three-lever type fork lever**

To remove the governor shaft, follow the procedures in 5, 6 above and never remove fork lever and the max torque limiter.

(When reassembling)

- Apply engine oil thinly to the fuel camshaft before installation.
- Make sure to assemble the external snap ring of the governor shaft.
- Check the governor shaft for smooth rotation.

■ **IMPORTANT**

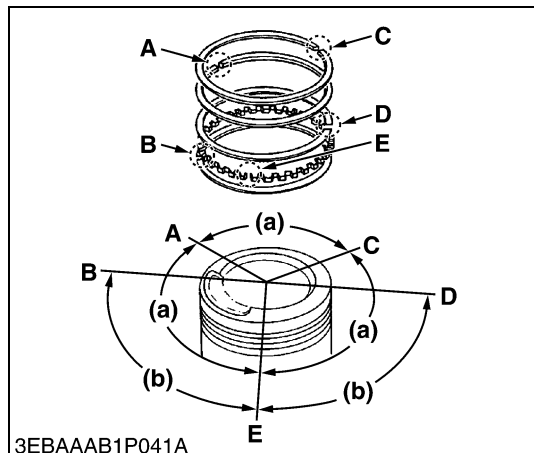
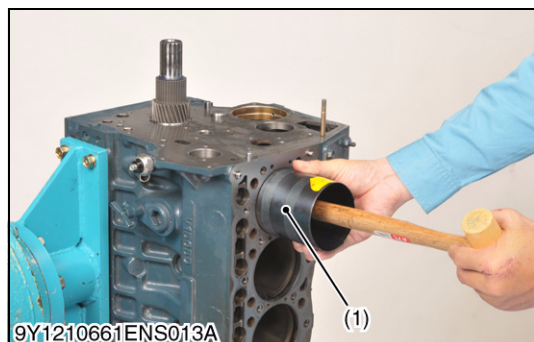
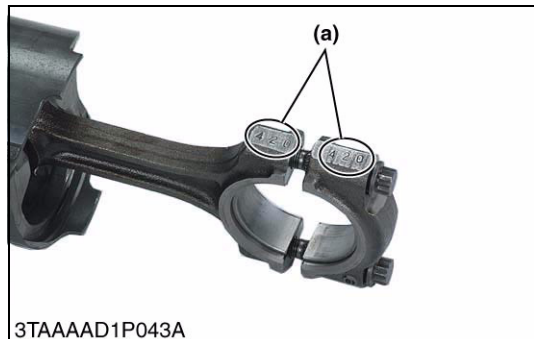
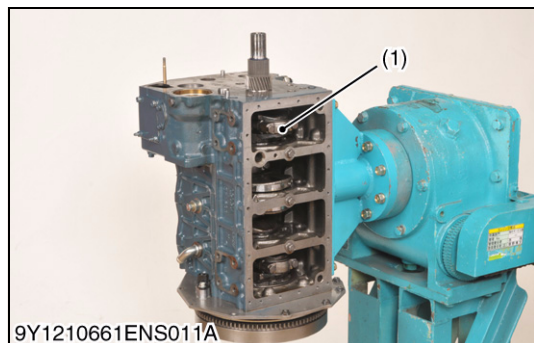
- There is a model of idle gear 1 (4) and idle gear 2 (7) by the difference of the method of transmission the power to the governor gear (6).
- When replacing the ball bearing of governor shaft, securely fit the ball bearing (10) to the crankcase, apply an adhesive (Three Bond 1324B or equivalent) to the set screw (13), and fasten the screw until its tapered part contacts the circumferential end of the ball bearing.
- When installing the idle gear, be sure to align the alignment marks on each gears.

- | | |
|---------------------------|-------------------------|
| (1) Injection Pump Gear | (9) Gear Shaft |
| (2) Alignment Mark | (10) Ball Bearing |
| (3) Cam Gear | (11) External Snap Ring |
| (4) Idle Gear 1 | (12) PTO Shaft |
| (5) Crank Gear | (13) Set Screw |
| (6) Governor Gear | |
| (7) Idle Gear 2 | |
| (8) Fuel Camshaft Stopper | |

[A] One Idle Gear Type
[B] Two Idle Gear Type

9Y1210661ENS0026US0

(6) Piston and Connecting Rod



Connecting Rod Cap

1. Remove the connecting rod caps (1) using a hexagonal 8 mm socket.

(When reassembling)

- Align the marks (a) with each other. (Face the marks toward the intake manifold.)
- Apply engine oil to the connecting rod screws and lightly screw it in by hand, then tighten it to the specified torque.
If the connecting rod screw won't be screwed in smoothly, clean the threads.
If the connecting rod screw is still hard to screw in, replace it.

Tightening torque	Connecting rod screw	41.2 to 46.1 N·m 4.21 to 4.70 kgf·m 30.4 to 34.0 lbf·ft
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(1) Connecting Rod Cap

(a) Mark

9Y1210661ENS0029US0

Piston

1. Turn the flywheel and bring the piston to top dead center.
2. Draw out the piston upward by lightly tapping it from the bottom of the crankcase with the grip of a hammer.
3. Draw out the other pistons after the same method as above.

(When reassembling)

- Before inserting the piston into the cylinder, apply enough engine oil to the piston.
- When inserting the piston into the cylinder, face the mark on the connecting rod to the fuel camshaft.
- When inserting the piston into the cylinder, place the gap "C" of the top compression ring on the opposite side of the slant portion, and stagger the gaps "A", "E" of the second compression ring and spacer making 2.09 rad (120 °) from the gap of the top compression ring. Further, stagger the gaps "D", "B" of the upper and lower side rail making 1.6 rad (90 °) from the gap of the spacer.

■ IMPORTANT

- Do not change the combination of cylinder and piston. Make sure of the position of each piston by marking. For example, mark "1" on the No. 1 piston.
- When installing the piston into the cylinder, place the gaps of all of the piston rings as shown in the figure.
- Carefully insert the piston using a piston ring compressor (1). Otherwise, their chrome-plated section may be scratched, causing trouble inside the cylinder.

(1) Piston Ring Compressor

D: Side Rail Gap

E: Spacer Gap

A: Second Compression Ring Gap

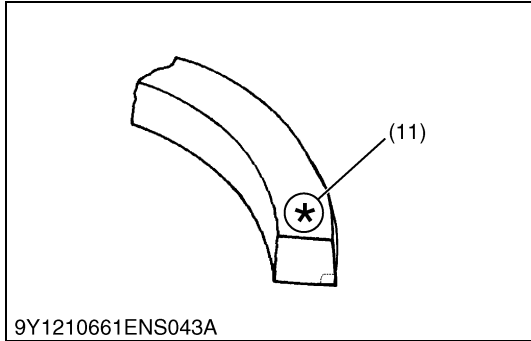
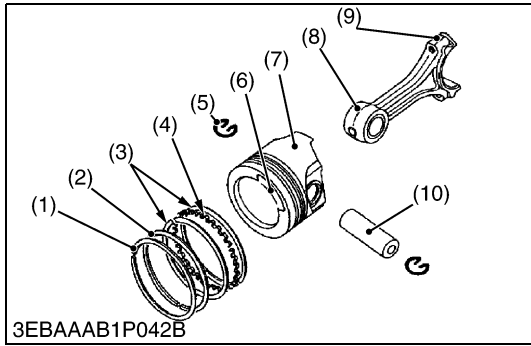
B: Side Rail Gap

C: Top Compression Ring Gap

(a) 2.09 rad (120 °)

(b) 1.6 rad (90 °)

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Piston Ring and Connecting Rod

1. Remove the piston rings using a piston ring tool.
2. Remove the piston pin (10), and separate the connecting rod (8) from the piston (7).

(When reassembling)

- When installing the second ring (2), assemble the rings so that the manufacturer's mark (11) near the gap faces the top of the piston.
- Apply engine oil to the piston pin.
- When installing the connecting rod to the piston, immerse the piston in 80 °C (176 °F) oil for 10 to 15 minutes and insert the piston pin to the piston.
- When installing the connecting rod to the piston, align the mark (9) on the connecting rod to the plug recess (6).

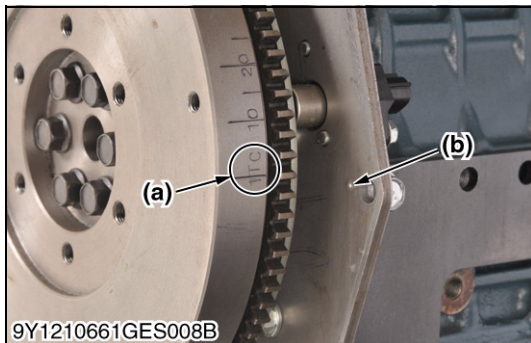
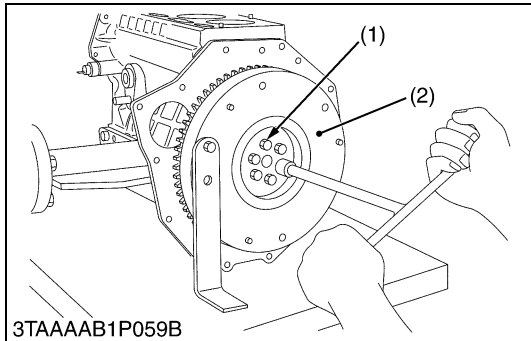
■ IMPORTANT

- **Mark the same number on the connecting rod and the piston so as not to change the combination.**

- | | |
|--------------------------|--------------------------|
| (1) Top Ring | (8) Connecting Rod |
| (2) Second Ring | (9) Mark |
| (3) Side Rail | (10) Piston Pin |
| (4) Spacer | (11) Manufacturer's Mark |
| (5) Piston Pin Snap Ring | Top Ring: 1N |
| (6) Plug Recess | Second Ring: 2N |
| (7) Piston | Oil Ring: None |

9Y1210661ENS0065US0

(7) Crankshaft



Flywheel

1. Secure the flywheel to keep it from turning using a flywheel stopper.
2. Remove all flywheel screws (1) and then remove the flywheel (2).

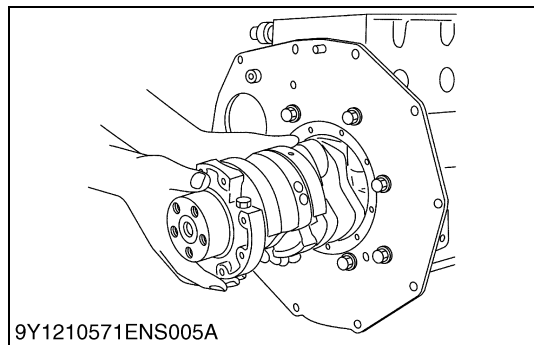
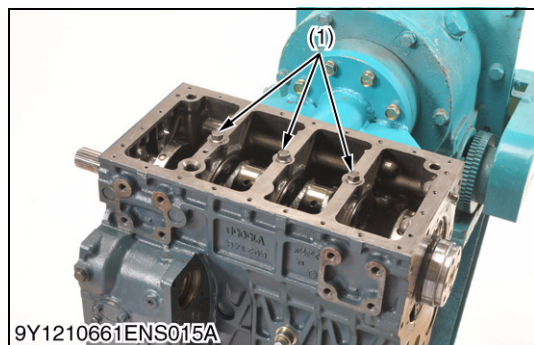
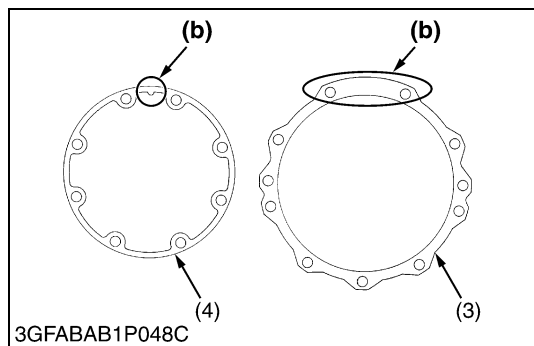
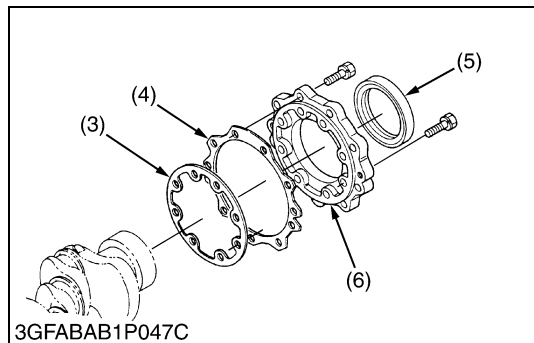
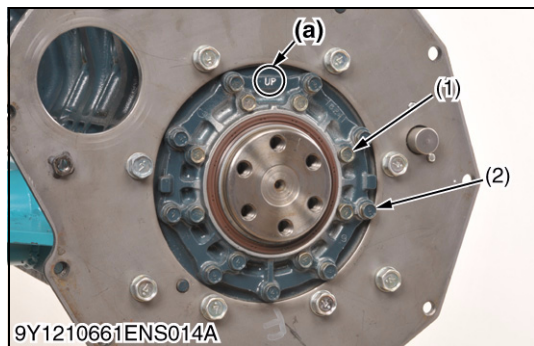
(When reassembling)

- Align the "1TC" mark (a) on the outer surface of the flywheel horizontally with the alignment mark (b) on the rear end plate. Now fit the flywheel in position.
- Apply engine oil to the threads and the undercut surface of the flywheel screw and fit the screw.

Tightening torque	Flywheel screw	53.9 to 58.8 N·m 5.50 to 5.99 kgf·m 39.8 to 43.3 lbf·ft
-------------------	----------------	---

- | | |
|--------------------|--------------------|
| (1) Flywheel Screw | (a) 1TC Mark |
| (2) Flywheel | (b) Alignment Mark |

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Bearing Case Cover

1. Remove the bearing case cover mounting screws. First, remove inside screws (1) and then outside screws (2).
2. Remove the bearing case cover (6).

(When reassembling)

- Fit the bearing case gasket (3) and the bearing case cover gasket (4) with correct directions.
- Install the bearing case cover (6) to position the casting mark "UP" (a) on it upward.
- Apply engine oil to the oil seal (5) lip and take care that it is not rolled when installing.
- Tighten the bearing case cover mounting screws with even force on the diagonal line.

Tightening torque	Bearing case cover mounting screw	9.81 to 11.3 N·m 1.00 to 1.15 kgf·m 7.24 to 8.33 lbf·ft
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- (1) Bearing Case Cover Mounting Screw (Inside)
- (2) Bearing Case Cover Mounting Screw (Outside)
- (3) Bearing Case Gasket
- (4) Bearing Case Cover Gasket
- (5) Oil Seal
- (6) Bearing Case Cover
- (a) Top Mark "UP"
- (b) Upside

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Crankshaft Assembly

1. Remove the main bearing case screw 2 (1).
2. Pull out the crankshaft assembly

■ IMPORTANT

- Take care to protect crankshaft bearing 1 from scratches, caused by the crank shaft, etc.

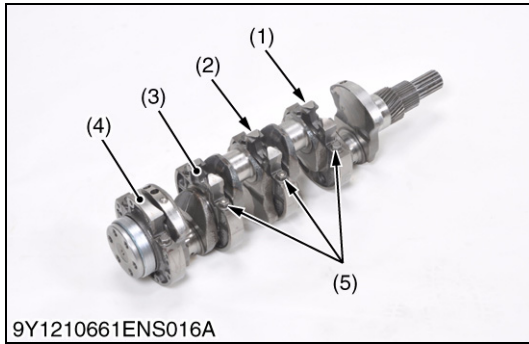
(When reassembling)

- Clean the oil passage of the crankshaft with compressed air.
- Apply oil to the main bearing case screw 2 (1).
- Install the crankshaft assembly, aligning the screw hole of main bearing case with the screw hole of crankcase.
- Clean the oil passage of the crankshaft with compressed air.

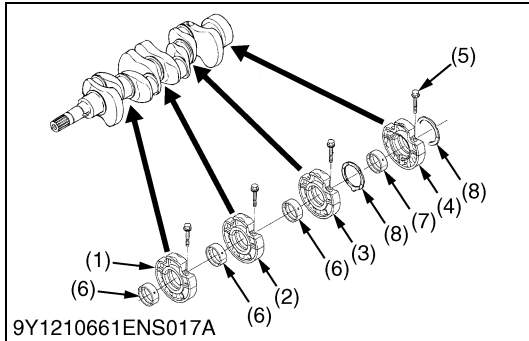
Tightening torque	Main bearing case screw 2	49.0 to 53.9 N·m 5.00 to 5.49 kgf·m 36.2 to 39.7 lbf·ft
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- (1) Main Bearing Case Screw 2

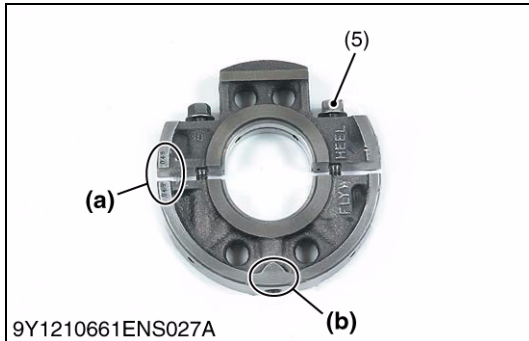
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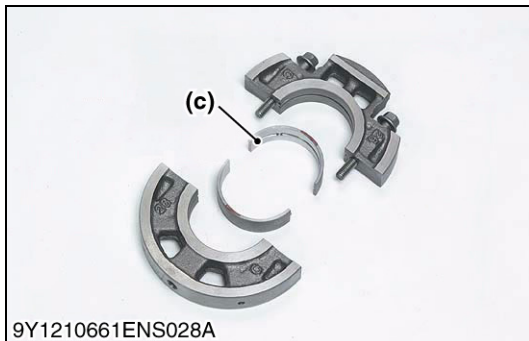
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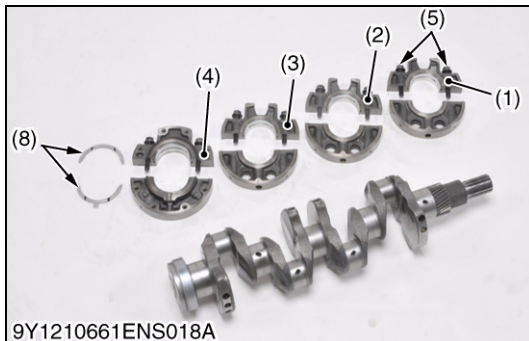
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9Y1210661ENS027A



9Y1210661ENS028A



9Y1210661ENS018A

Main Bearing Case Assembly

1. Remove the two main bearing case screws 1 (5), and remove the main bearing case assembly 1 (1), being careful with crankshaft bearing 3 (7).
2. Remove the main bearing case assembly 2 (2), the main bearing case assembly 3 (3) and the main bearing case assembly 4 (4) as above. Keep in mind, however, that the thrust bearing (8) is installed in the main bearing case assembly (4).

(When reassembling)

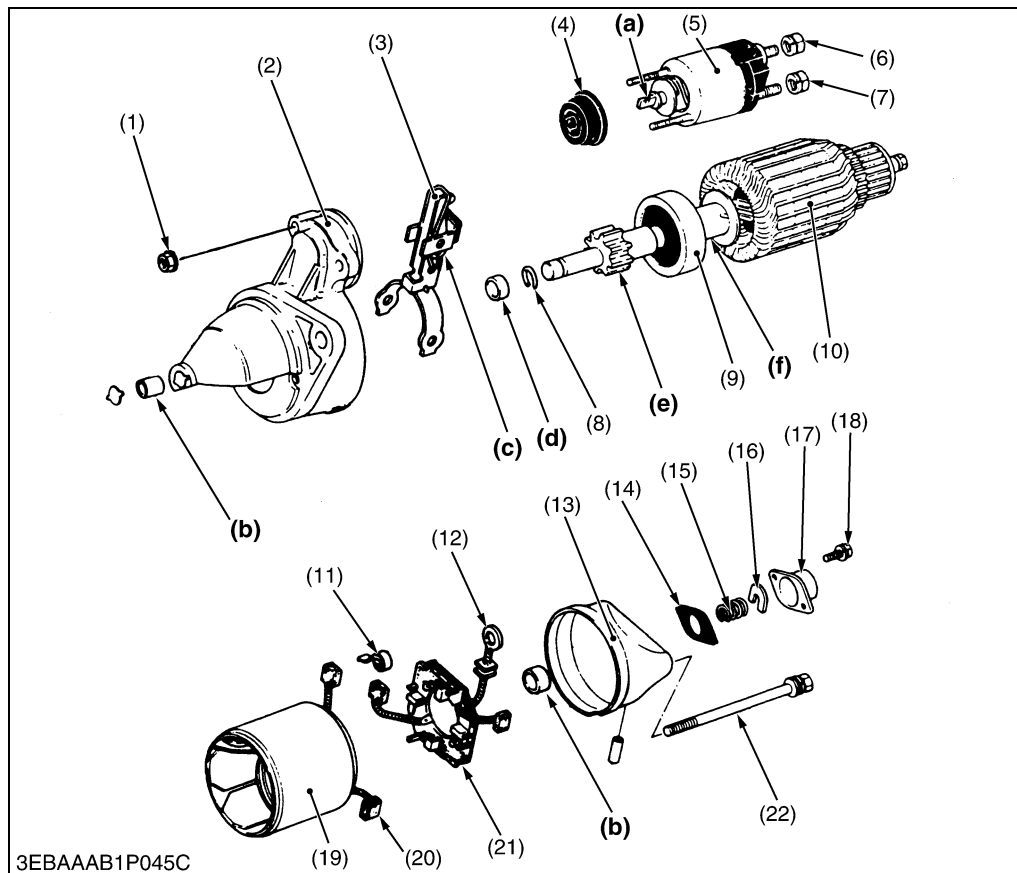
- Clean the oil passage in the main bearing cases.
- Apply clean engine oil to the bearings.
- Install the main bearing case assemblies in original positions. Since diameters of main bearing cases vary, install them in order of marking (b) from the gear case side. (Refer to the figure.)
- Be careful not to confuse the top and bottom of the crankshaft bearing 3 (7). (Install the bearing with the oil groove (c) up.)
- Match the alignment numbers (a) on the main bearing case assembly 1.
- Do the same for the main bearing case assembly 2 (2), the main bearing case assembly 3 (3) and the main bearing case assembly (4) too.
- When installing the main bearing case 1, 2 and 3, face the mark "FLYWHEEL" to the flywheel.
- Install the thrust bearing (8) with its oil groove facing outward.
- Confirm that the main bearing case moves smoothly after tightening the main bearing case screw 1 (5) to the specified torque.

Tightening torque	Main bearing case screw 1	29.4 to 34.3 N·m 3.00 to 3.49 kgf·m 21.7 to 25.2 lbf·ft
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- (1) Main Bearing Case Assembly 1
 - (2) Main Bearing Case Assembly 2
 - (3) Main Bearing Case Assembly 3
 - (4) Main Bearing Case Assembly
 - (5) Main Bearing Case Screw 1
 - (6) Crankshaft Bearing 2
 - (7) Crankshaft Bearing 3
 - (8) Thrust Bearing
- (a) Alignment Number
 - (b) Marking (A, B, C)
 - (c) Oil Groove

9Y1210661ENS0034US0

(8) Starter



- (1) Solenoid Switch Mounting Nut
- (2) Starter Drive Housing
- (3) Drive Lever
- (4) Gasket
- (5) Solenoid Switch
- (6) **B** Terminal Nut
- (7) **C** Terminal Nut
- (8) Snap Ring
- (9) Overrunning Clutch
- (10) Armature
- (11) Brush Spring
- (12) Connecting Lead
- (13) Rear End Frame
- (14) Gasket
- (15) Brake Spring
- (16) Brake Shoe
- (17) End Frame Cap
- (18) Screw
- (19) Yoke
- (20) Brush
- (21) Brush Holder
- (22) Through Bolt

1. Unscrew the **C** terminal nut (7), and disconnect the connecting lead (12).
2. Unscrew the solenoid switch mounting nuts (1), and remove the solenoid switch (5).
3. Remove the end frame cap (17).
4. Remove the brake shoe (16), brake spring (15) and gasket (14).
5. Unscrew the through bolts (22), and remove the rear end frame (13).
6. Remove the brush from the brush holder while holding the spring up.
7. Remove the brush holder (21).
8. Draw out the yoke (19) from the starter drive housing (2).
9. Draw out the armature (10) with the drive lever (3).

■ **NOTE**

- **Do not damage to the brush and commutator.**

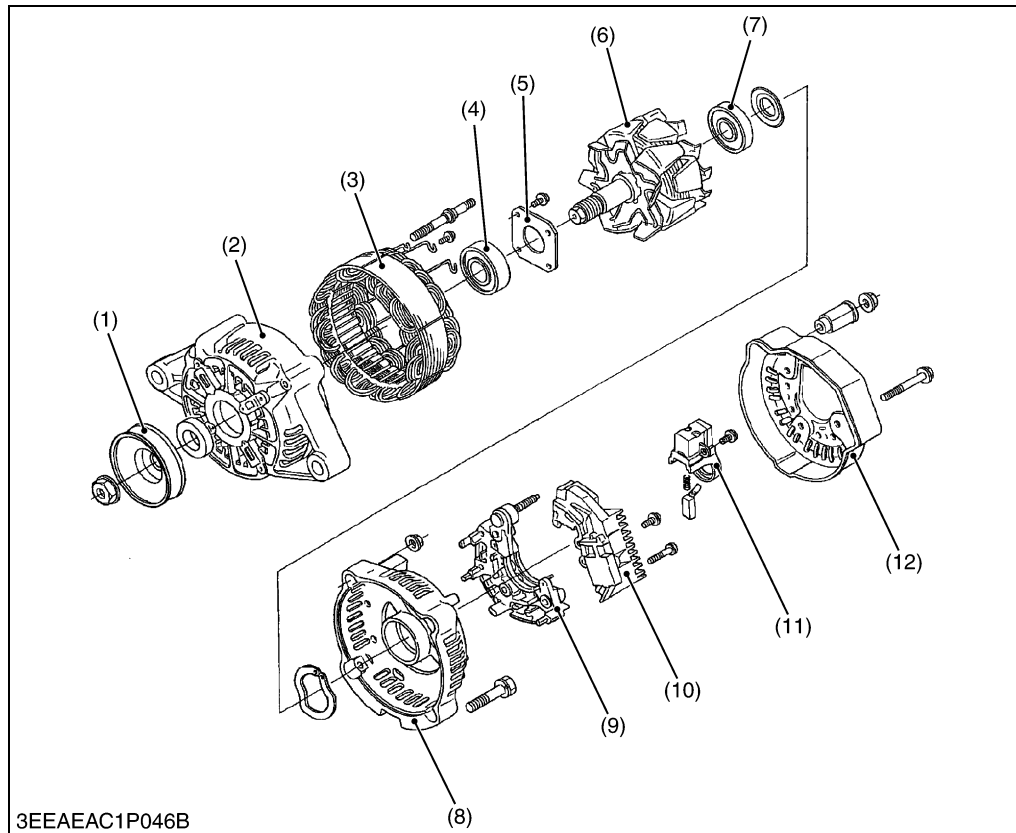
(When reassembling)

- Apply grease (DENSO.CO.LTD. No. 50 or equivalent) to the parts indicated in the figure.
 - Joint of solenoid switch **(a)**
 - Bushing **(b)**
 - Drive lever **(c)**
 - Collar **(d)**
 - Teeth of pinion gear **(e)**
 - Armature shaft **(f)**

Tightening torque	Starter's terminal B mounting nut	5.88 to 11.8 N·m 0.600 to 1.20 kgf·m 4.34 to 8.70 lbf·ft
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(9) Alternator



- (1) Pulley
- (2) Drive End Frame
- (3) Stator
- (4) Bearing
- (5) Retainer Plate
- (6) Rotor
- (7) Bearing
- (8) Rear End Frame
- (9) Rectifier
- (10) IC Regulator
- (11) Brush Holder
- (12) Rear End Cover

1. Remove the pulley (1).
2. Remove the rear end cover (12).
3. Remove the brush holder (11).
4. Remove the IC regulator (10).
5. Remove the four screws holding the stator lead wires.
6. Remove the rectifier (9).
7. Remove the rear end frame (8).
8. Press out the rotor (6) from drive end frame (2).
9. Remove the retainer plate (5).
10. Press out the bearing (4) from drive end frame (2) with a press and jig.
11. Lightly secure the rotor with a vise to prevent damage, and remove the bearing (7) with a puller.

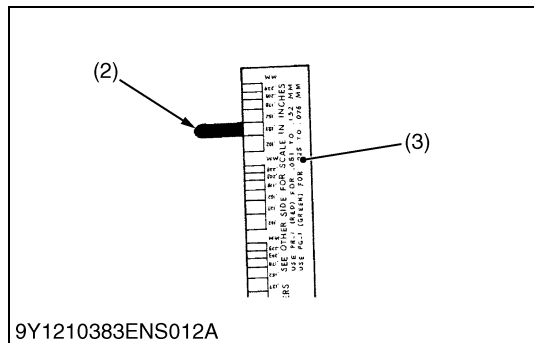
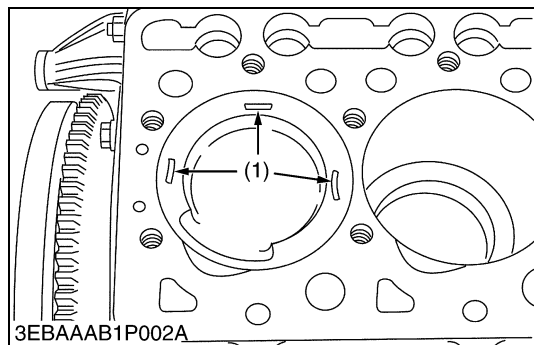
(When reassembling)

Tightening torque	Alternator's pulley nut	58.4 to 78.9 N·m 5.95 to 8.05 kgf·m 43.1 to 58.2 lbf·ft
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[3] SERVICING

(1) Cylinder Head and Valves



Top Clearance

1. Remove the cylinder head.
2. With the piston at TDC, use grease to affix three or four plastigauges (1) of a diameter 1.5 mm (0.059 in.) × 5.0 to 7.0 mm (0.20 to 0.27 in.) long to the crown of the piston; keep the gauges away from the intake valve and combustion chamber fittings.
3. Take the piston to an intermediate position, install the cylinder head and tighten the head bolts to the specified torque.
4. Turn the crankshaft so the piston goes through TDC.
5. Remove the cylinder head and compare the width of the crushed plastigauges (2) with the scale (3).
6. If they are out of spec, check the oil clearance of the crank pin, journal and piston pins.

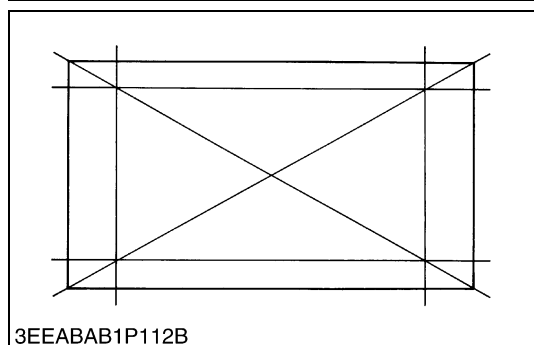
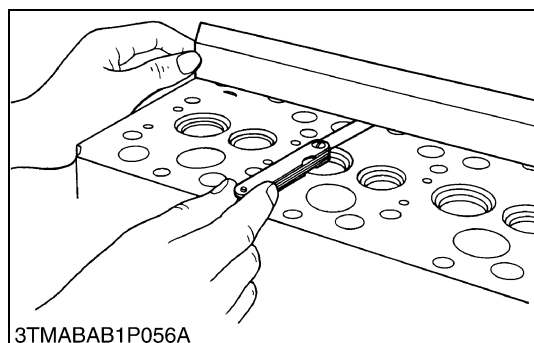
■ **NOTE**

- **Top clearance = Width of the crushed plastigauge (2).**

Top clearance	Factory specification	1.2 to 1.5 mm 0.048 to 0.059 in
Tightening torque	Cylinder head screws	63.7 to 68.6 N·m 6.50 to 6.99 kgf·m 47.0 to 50.5 lbf·ft

- (1) Plastigauge (3) Scale
(2) Crushed Plastigauge

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Cylinder Head Surface Flatness

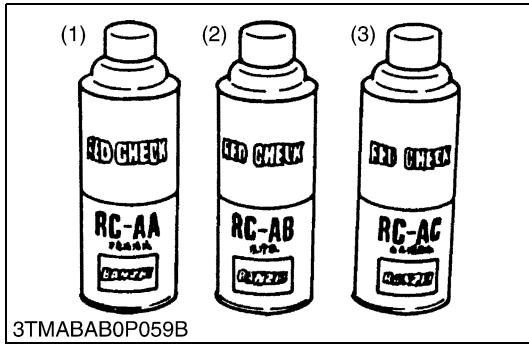
1. Clean the cylinder head surface.
2. Place a straightedge on the cylinder head's four sides and two diagonal as shown in the figure. Measure the clearance with a feeler gauge.
3. If the measurement exceeds the allowable limit, correct it with a surface grinder.

■ **IMPORTANT**

- **Be sure to check the valve recessing after correcting.**

Cylinder head surface flatness	Allowable limit	0.05 mm 0.002 in.
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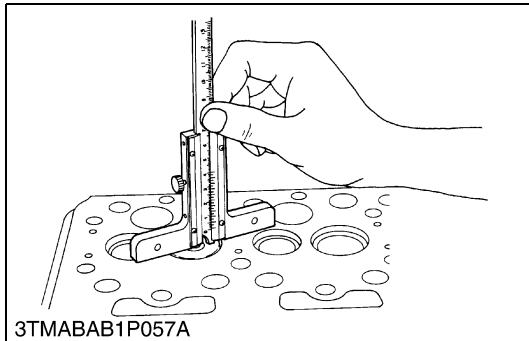


Cylinder Head Flaw

1. Prepare an air spray red check.
2. Clean the surface of the cylinder head with the detergent (2).
3. Spray the cylinder head surface with the red permeative liquid (1). Leave it five to ten minutes after spraying.
4. Wash away the red permeative liquid on the cylinder head surface with the detergent (2).
5. Spray the cylinder head surface with the white developer (3).
6. If flawed, it can be identified as red marks.

- (1) Red Permeative Liquid (3) White Developer
 (2) Detergent

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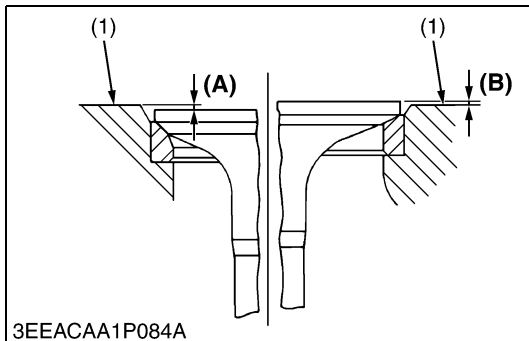
Valve Recessing

1. Clean the cylinder head, the valve face and seat.
2. Insert the valve into the valve guide.
3. Measure the valve recessing with a depth gauge.
4. If the measurement exceeds the allowable limit, replace the valve.
5. If it still exceeds the allowable limit after replacing the valve, replace the cylinder head.

Valve recessing (Intake and Exhaust)	Factory specification	0.050 (protrusion) to 0.25 (recessing) mm 0.0020 (protrusion) to 0.0098 (recessing) in.
	Allowable limit	0.40 (recessing) mm 0.016 (recessing) in.

- (1) Cylinder Head Surface (A) Recessing
 (B) Protrusion

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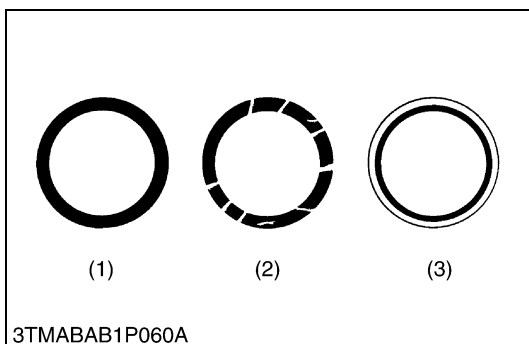
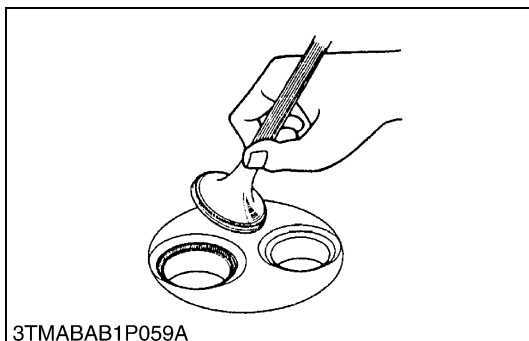
Valve Seating

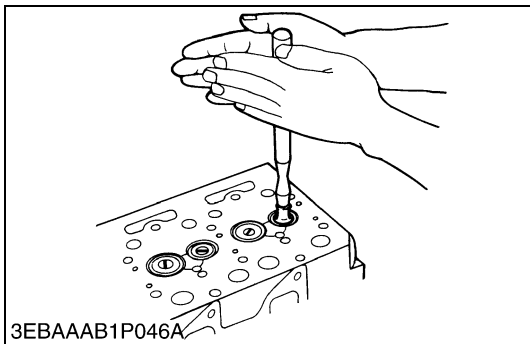
1. Coat the valve face lightly with prussian blue and put the valve on its seat to check the contact.
2. If the valve does not seat all the way around the valve seat or the valve contact is less than 70 %, correct the valve seating as follows.
3. If the valve contact does not comply with the reference value, replace the valve or correct the contact of valve seating.

Valve seat width	Factory specification	2.12 mm 0.0835 in.
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- (1) Correct (3) Incorrect
 (2) Incorrect

9Y1210318ENS0092US0





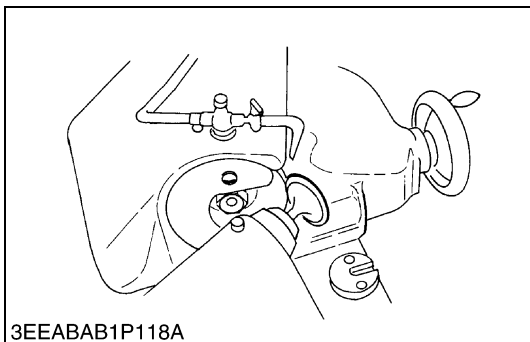
Valve Lapping

1. Apply compound evenly to the valve lapping surface.
2. Insert the valve into the valve guide. Lap the valve onto its seat with a valve flapper or screwdriver.
3. After lapping the valve, wash the compound away and apply oil, then repeat valve lapping with oil.
4. Apply prussian blue to the contact surface to check the seated rate. If it is less than 70 %, repeat valve lapping again.

■ **IMPORTANT**

- **When valve lapping is performed, be sure to check the valve recessing and adjust the valve clearance after assembling the valve.**

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Correcting Valve and Valve Seat

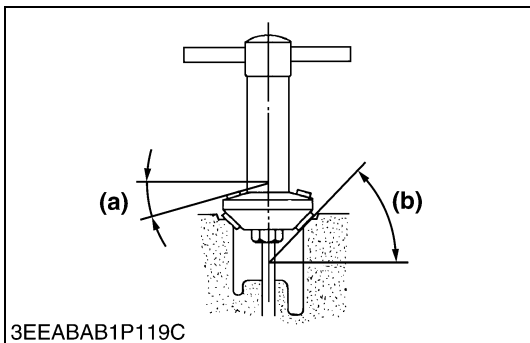
■ **NOTE**

- **Before correcting the valve and seat, check the valve stem and the I.D. of valve guide section, and repair them if necessary.**
- **After correcting the valve seat, be sure to check the valve recessing.**

1) Correcting Valve

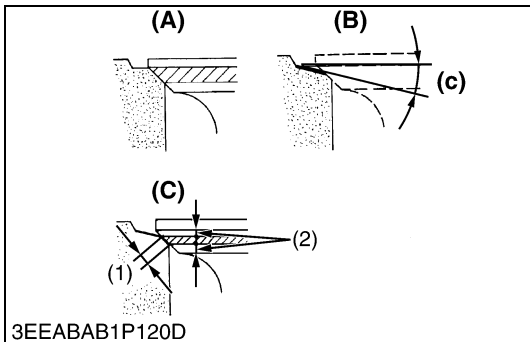
1. Correct the valve with a valve refacer.

Valve face angle	Factory specification	IN.	1.0 rad 60 °
		EX.	1.0 rad 60 °



2) Correcting Valve Seat

1. Slightly correct the seat surface with a 1.0 rad (60 °) valve seat cutter.
2. Resurface the seat surface with a 0.52 rad (30 °) valve seat cutter so that the width is close to specified valve seat width (2.12 mm, 0.0835 in.).
3. After resurfacing the seat, inspect for even valve seating, apply a thin film of compound between the valve face and valve seat, and fit them with valve lapping tool.
4. Check the valve seating with prussian blue. The valve seating surface should show good contact all the way around.

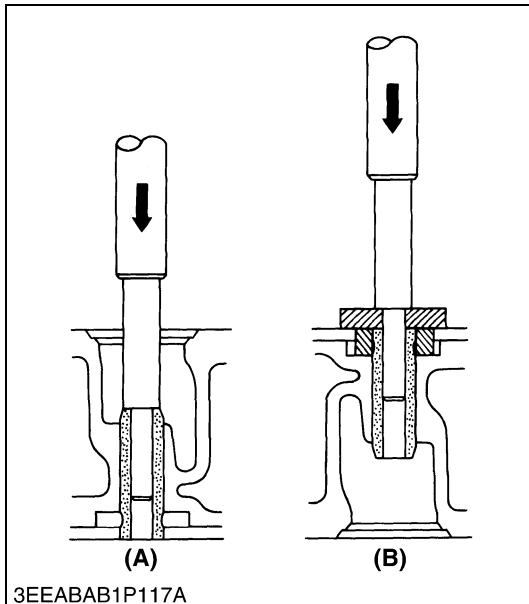
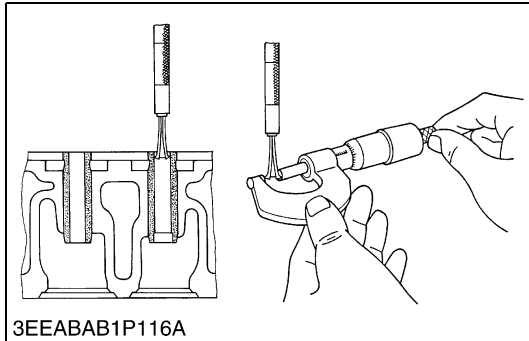
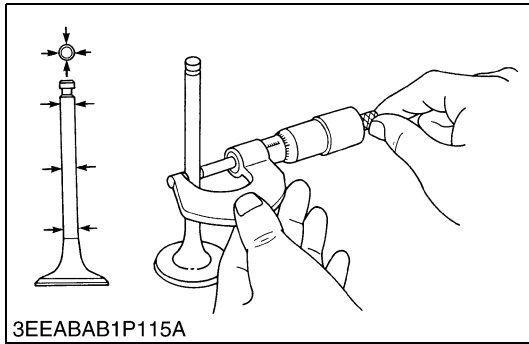


Valve seat angle	Factory specification	IN.	1.0 rad 60 °
		EX.	1.0 rad 60 °

- (1) Valve Seat Width
- (2) Identical Dimensions

- (A) Check Contact
- (B) Correct Seat Width
- (C) Check Contact
- (a) 0.52 rad (30 °)
- (b) 1.0 rad (60 °)
- (c) 0.52 rad (30 °)

9Y1210661ENS0064US0



Clearance between Valve Stem and Valve Guide

1. Remove carbon from the valve guide section.
2. Measure the valve stem O.D. with an outside micrometer.
3. Measure the valve guide I.D. with a small hole gauge, and calculate the clearance.
4. If the clearance exceeds the allowable limit, replace the valves. If it still exceeds the allowable limit, replace the valve guide.

Clearance between valve stem and valve guide	Factory specification	0.035 to 0.065 mm 0.0014 to 0.0025 in
	Allowable limit	0.10 mm 0.0039 in.

Valve stem O.D.	Factory specification	6.960 to 6.975 mm 0.2741 to 0.2746 in
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Valve guide I.D.	Factory specification	7.010 to 7.025 mm 0.2760 to 0.2765 in
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Replacing Valve Guide

(When removing)

1. Press out the used valve guide using a valve guide replacing tool.

(When installing)

1. Clean a new valve guide and valve guide bore, and apply engine oil to them.
2. Press in a new valve guide using a valve guide replacing tool.
3. Ream precisely the I.D. of the valve guide to the specified dimension.

Valve guide I.D. (Intake and exhaust)	Factory specification	7.010 to 7.025 mm 0.2760 to 0.2765 in
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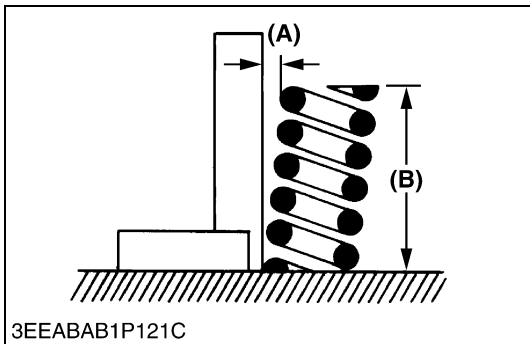
■ IMPORTANT

- Do not hit the valve guide with a hammer during replacement.

(A) When Removing

(B) When Installing

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Free Length and Tilt of Valve Spring

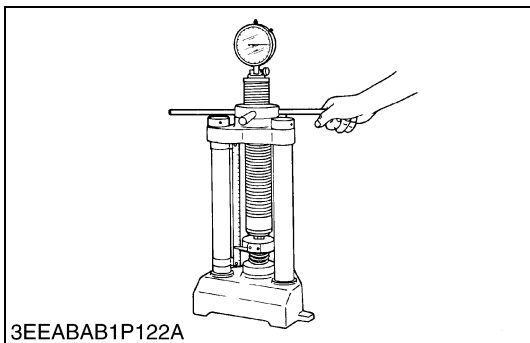
1. Measure the free length **(B)** of valve spring with vernier calipers. If the measurement is less than the allowable limit, replace it.
2. Put the spring on a surface plate, place a square on the side of the spring.
3. Check to see if the entire side is in contact with the square. Rotate the valve spring and measure the maximum tilt **(A)**. If the measurement exceeds the allowable limit, replace it.
4. Check the entire surface of the valve spring for scratches. If there is any defect, replace it.

Tilt (A)	Allowable limit	1.0 mm 0.039 in.
Free length (B)	Factory specification	35.1 to 35.6 mm 1.39 to 1.40 in
	Allowable limit	34.8 mm 1.37 in

(A) Tilt

(B) Free length

9Y1210661ENS0041US0



Valve Spring Setting Load

1. Place the valve spring on a tester and compress it to the same length it is actually compressed in the engine.
2. Read the compression load on the gauge.
3. If the measurement is less than the allowable limit, replace it.

Setting load / setting length	Factory specification	74 N / 31.0 mm 7.5 kgf / 31.0 mm 17 lbf / 1.22 in
	Allowable limit	63 N / 31.0 mm 6.4 kgf / 31.0 mm 14 lbf / 1.22 in

9Y1210661ENS0042US0



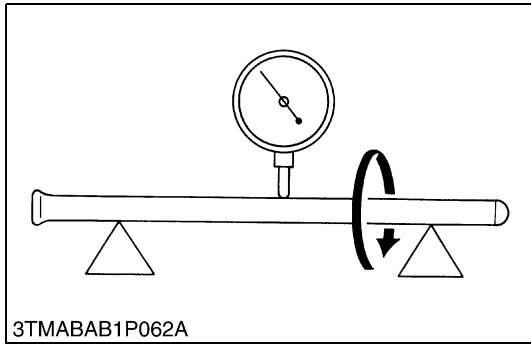
Oil Clearance between Rocker Arm and Rocker Arm Shaft

1. Measure the rocker arm shaft O.D. with an outside micrometer.
2. Measure the rocker arm I.D. with an inside micrometer, and then calculate the oil clearance.
3. If the oil clearance exceeds the allowable limit, replace the rocker arm and measure the oil clearance again. If it still exceeds the allowable limit, replace also the rocker arm shaft.

Oil clearance between rocker arm and rocker arm shaft	Factory specification	0.016 to 0.045 mm 0.00063 to 0.0017 in.
	Allowable limit	0.15 mm 0.0059 in.

Rocker arm shaft O.D.	Factory specification	11.973 to 11.984 mm 0.47138 to 0.47181 in
Rocker arm I.D.	Factory specification	12.000 to 12.018 mm 0.47244 to 0.47314 in.

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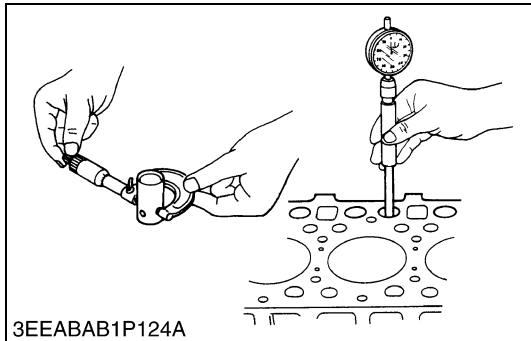


Push Rod Alignment

1. Place the push rod on V blocks.
2. Measure the push rod alignment.
3. If the measurement exceeds the allowable limit, replace the push rod.

Push rod alignment	Allowable limit	0.25 mm 0.0098 in.
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Oil Clearance between Tappet and Tappet Guide Bore

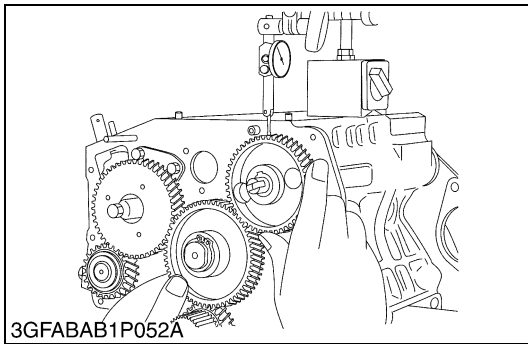
1. Measure the tappet O.D. with an outside micrometer.
2. Measure the I.D. of the tappet guide bore with a cylinder gauge, and calculate the oil clearance.
3. If the oil clearance exceeds the allowable limit or the tappet is damaged, replace the tappet.

Oil clearance between tappet and tappet guide bore	Factory specification	0.020 to 0.062 mm 0.00079 to 0.0024 in
	Allowable limit	0.07 mm 0.003 in.

Tappet O.D.	Factory specification	19.959 to 19.980 mm 0.78579 to 0.78661 in
Tappet guide bore I.D.	Factory specification	20.000 to 20.021 mm 0.78741 to 0.78822 in

9Y1210661ENS0070US0

(2) Timing Gear and Camshaft



Timing Gear Backlash

1. Set a dial indicator (lever type) with its tip on the gear tooth.
2. Move the gear to measure the backlash, holding its mating gear.
3. If the backlash exceeds the allowable limit, check the oil clearance of the shafts and the gear.
4. If the oil clearance is proper, replace the gear.

Backlash between idle gear 1 and crank gear	Factory specification	0.0320 to 0.115 mm 0.00126 to 0.00452 in.
	Allowable limit	0.15 mm 0.0059 in.

Backlash between idle gear 1 and cam gear	Factory specification	0.0360 to 0.114 mm 0.00142 to 0.00448 in.
	Allowable limit	0.15 mm 0.0059 in.

Backlash between idle gear 1 and injection pump gear	Factory specification	0.0340 to 0.116 mm 0.00134 to 0.00456 in.
	Allowable limit	0.15 mm 0.0059 in.

(equipped with idle gear 2) Backlash between idle gear 1 and idle gear 2	Factory specification	0.0330 to 0.117 mm 0.00130 to 0.00460 in.
	Allowable limit	0.15 mm 0.0059 in.

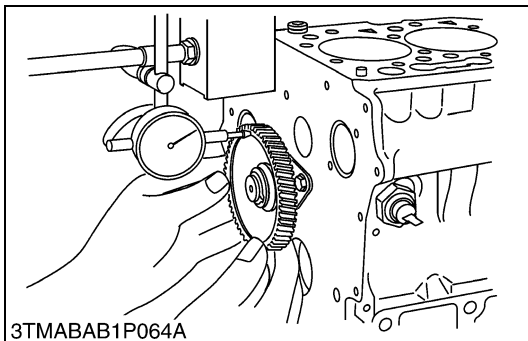
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Governor Gear Backlash

Backlash between injection pump gear and governor gear	Factory specification	0.0300 to 0.117 mm 0.00119 to 0.00460 in.
	Allowable limit	0.15 mm 0.0059 in.

(equipped with idle gear 2) idle gear 2 and governor gear	Factory specification	0.0300 to 0.117 mm 0.00119 to 0.00460 in.
	Allowable limit	0.15 mm 0.0059 in.

9Y1210661ENS0105US0

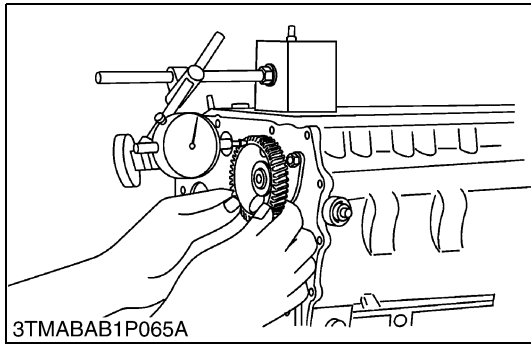


Idle Gear 1 and 2 Side Clearance

1. Set a dial indicator with its tip on the idle gear.
2. Measure the side clearance by moving the idle gear to the front and rear.
3. If the measurement exceeds the allowable limit, replace the idle gear collar.

Idle gear 1 and 2 side clearance	Factory specification	0.20 to 0.51 mm 0.0079 to 0.020 in.
	Allowable limit	0.80 mm 0.031 in.

9Y1210661ENS0046US0

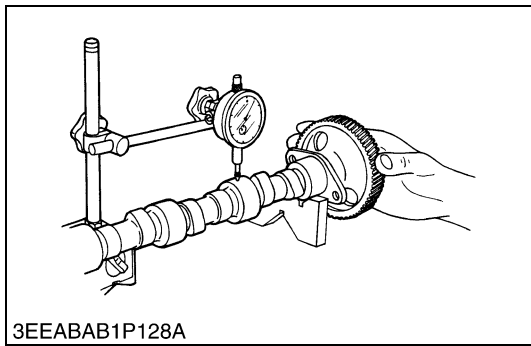


Camshaft Side Clearance

1. Set a dial indicator with its tip on the camshaft.
2. Measure the side clearance by moving the cam gear to the front and rear.
3. If the measurement exceeds the allowable limit, replace the camshaft stopper.

Camshaft side clearance	Factory specification	0.0700 to 0.220 mm 0.00276 to 0.00866 in
	Allowable limit	0.30 mm 0.012 in.

9Y1210661ENS0072US0

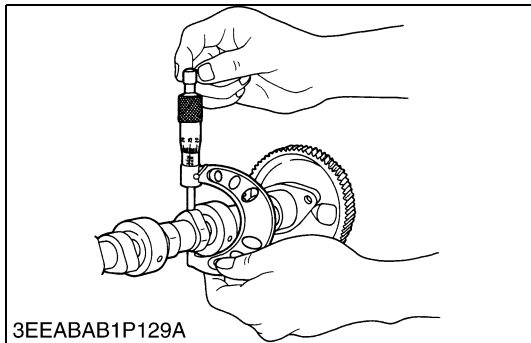


Camshaft Alignment

1. Support the camshaft with V blocks on the surface plate at both end journals.
2. Set a dial indicator with its tip on the intermediate journal.
3. Measure the camshaft alignment.
4. If the measurement exceeds the allowable limit, replace the camshaft.

Camshaft alignment	Allowable limit	0.01 mm 0.0004 in.
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9Y1210318ENS0103US0

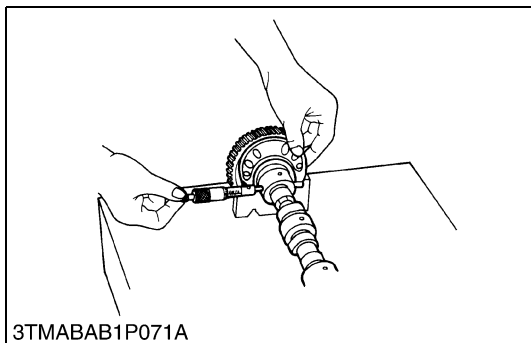


Cam Height

1. Measure the height of the cam at its highest point with an outside micrometer.
2. If the measurement is less than the allowable limit, replace the camshaft.

Cam height	Factory specification	IN.	28.80 mm 1.134 in.
		EX.	29.00 mm 1.142 in
	Allowable limit	IN.	28.75 mm 1.132 in.
		EX.	28.95 mm 1.140 in.

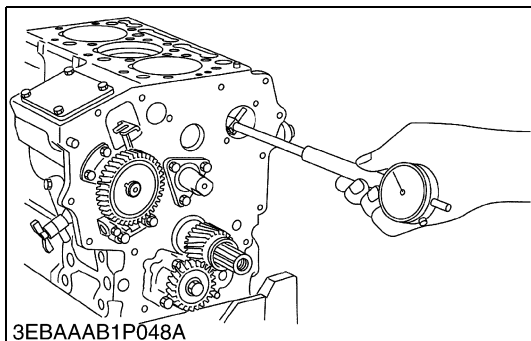
9Y1210661ENS0073US0



Oil Clearance of Camshaft Journal

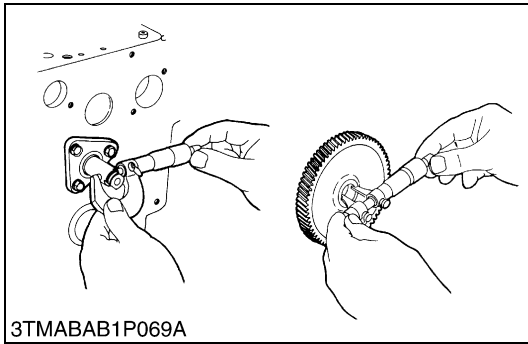
1. Measure the camshaft journal O.D. with an outside micrometer.
2. Measure the cylinder block bore I.D. for camshaft with a inside micrometer, and calculate the oil clearance.
3. If the clearance exceeds the allowable limit, replace the camshaft.

Oil clearance of camshaft journal	Factory specification	0.050 to 0.091 mm 0.0020 to 0.0035 in.
	Allowable limit	0.15 mm 0.0059 in.



Camshaft journal O.D.	Factory specification	35.934 to 35.950 mm 1.4148 to 1.4153 in
Camshaft bearing I.D. (Cylinder block bore I.D.)	Factory specification	36.000 to 36.025 mm 1.4174 to 1.4183 in

9Y1210661ENS0048US0



3TMABAB1P069A

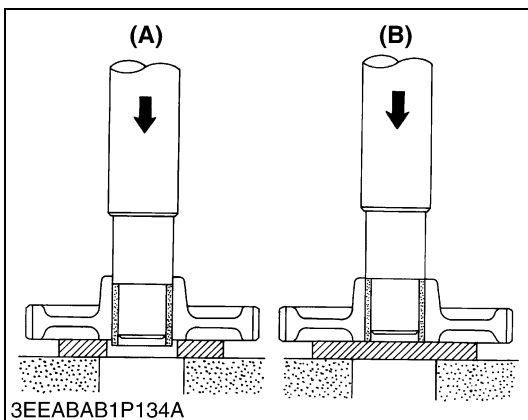
Oil Clearance between Idle Gear Shaft 1 and 2 and Idle Gear Bushing

1. Measure the idle gear shaft O.D. with an outside micrometer.
2. Measure the idle gear bushings I.D. with an inside micrometer, and calculate the oil clearance.
3. If the oil clearance exceeds the allowable limit, replace the bushing.
4. If it still exceeds the allowable limit, replace the idle gear shaft.

Oil clearance between idle gear shaft (1 and 2) and idle gear bushing	Factory specification	0.020 to 0.054 mm 0.00079 to 0.0021 in
	Allowable limit	0.10 mm 0.0039 in.

Idle gear shaft 1 and 2 O.D.	Factory specification	25.967 to 25.980 mm 1.0224 to 1.0228 in
Idle gear bushing 1 and 2 I.D.	Factory specification	26.000 to 26.021 mm 1.0237 to 1.0244 in

9Y1210661ENS0049US0



3EEABAB1P134A

Replacing Idle Gear Bushing

(When removing)

1. Press out the used idle gear bushing using an idle gear bushing replacing tool.

(When installing)

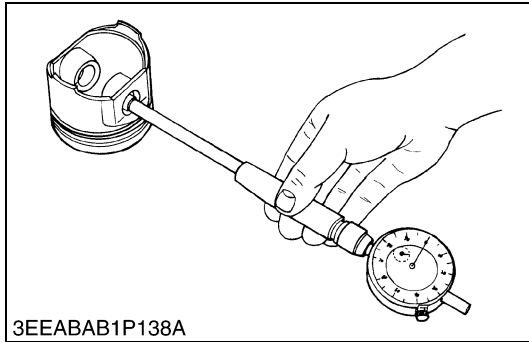
1. Clean a new idle gear bushing and idle gear bore, and apply engine oil to them.
2. Press in a new bushing using an idle gear bushing replacing tool, until it is flush with the end of the idle gear.

(A) When Removing

(B) When Installing

9Y1210318ENS0107US0

(3) Piston and Connecting Rod

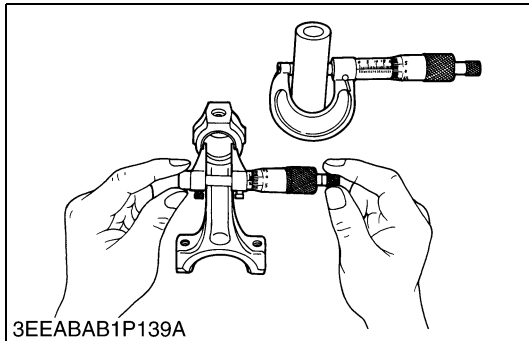


Piston Pin Bore I.D.

1. Measure the piston pin bore I.D. in both the horizontal and vertical directions with a cylinder gauge.
2. If the measurement exceeds the allowable limit, replace the piston.

Piston pin bore I.D.	Factory specification	22.000 to 22.013 mm 0.86615 to 0.86665 in
	Allowable limit	22.03 mm/0.8673 in.

9Y1210661ENS0050US0



Oil Clearance between Piston Pin and Small End Bushing

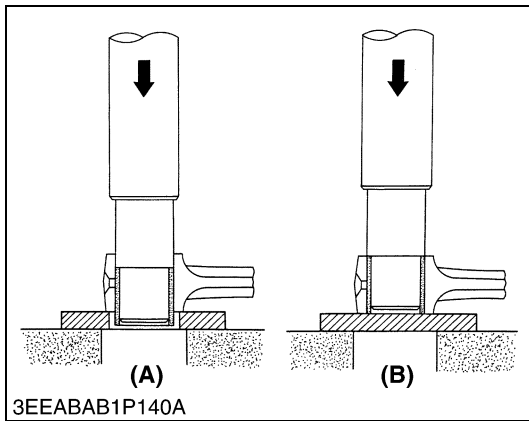
1. Measure the O.D. of the piston pin where it contacts the bushing with an outside micrometer.
2. Measure the small end bushing I.D. with an inside micrometer, and calculate the oil clearance.
3. If the oil clearance exceeds the allowable limit, replace the bushing. If it still exceeds the allowable limit, replace the piston pin.

Oil clearance between piston pin and small end bushing	Factory specification	0.014 to 0.038 mm 0.00056 to 0.0014 in.
	Allowable limit	0.10 mm 0.0039 in.

Piston pin O.D.	Factory specification	22.002 to 22.011 mm 0.86622 to 0.86657 in
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Small end bushing I.D.	Factory specification	22.025 to 22.040 mm 0.86713 to 0.86771 in
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9Y1210661ENS0074US0



Replacing Small End Bushing

(When removing)

1. Press out the used bushing using a small end bushing replacing tool. (Refer to "5. SPECIAL TOOLS" on page G-24.)

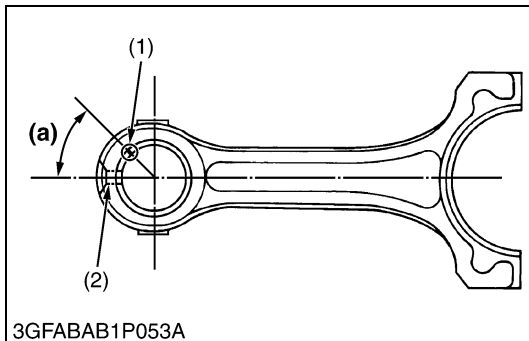
(When installing)

1. Clean a new small end bushing and bore, and apply engine oil to them.
2. Using a small end bushing replacing tool, press in a new bushing (service parts) taking due care to see that the connecting rod hole matches the bushing hole.

[Servicing parts dimension]

Oil clearance between piston pin and small end bushing (Spare parts)	Factory specification	0.014 to 0.038 mm 0.00056 to 0.0014 in
	Allowable limit	0.15 mm 0.0059 in.

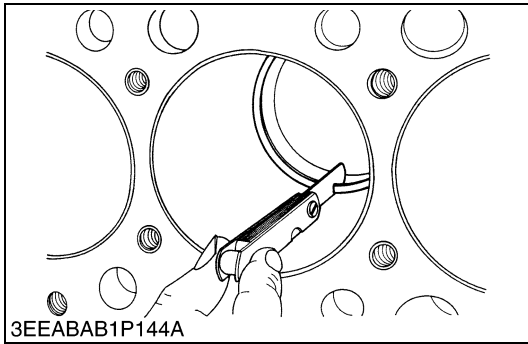
Small end bushing I.D. (Spare parts)	Factory specification	22.076 to 22.146 mm 0.86914 to 0.87188 in.
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- (1) Seam
- (2) Oil Hole

- (A) When Removing**
- (B) When Installing**
- (a) 0.79 rad (45°)**

9Y1210661ENS0075US0

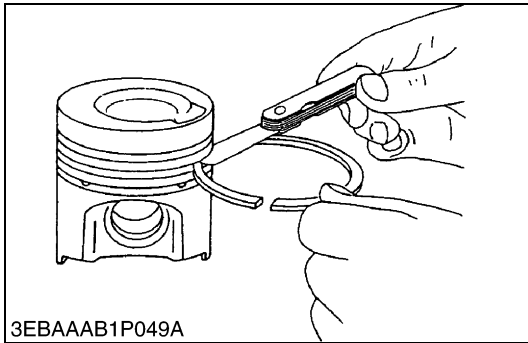


Piston Ring Gap

1. Insert the piston ring into the lower part of the cylinder (the least worn out part) with a piston ring compressor and piston.
2. Measure the ring gap with a feeler gauge.
3. If the measurement exceeds the allowable limit, replace the piston ring.

Piston ring gap	Top ring	Factory specification	0.30 to 0.45 mm 0.012 to 0.017 in
		Allowable limit	1.25 mm 0.0492 in.
	Second ring	Factory specification	0.30 to 0.45 mm 0.012 to 0.017 in.
		Allowable limit	1.25 mm 0.0492 in.
	Oil ring	Factory specification	0.20 to 0.70 mm 0.0079 to 0.027 in.
		Allowable limit	1.25 mm 0.0492 in.

9Y1210661ENS0053US0

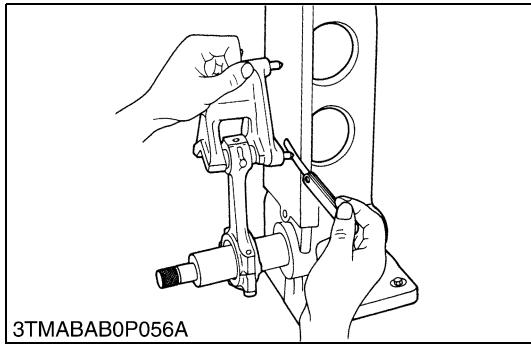


Clearance between Piston Ring and Piston Ring Groove

1. Clean the rings and the ring grooves, and install each ring in its groove.
2. Measure the clearance between the ring and the groove with a thickness gauge.
3. If the clearance exceeds the allowable limit, replace the piston ring.
4. If the clearance still exceeds the allowable limit with new ring, replace the piston.

Clearance between piston ring and piston ring groove	Top ring	Factory specification	0.040 to 0.080 mm 0.0016 to 0.0031 in
		Allowable limit	0.2 mm 0.008 in.
	Second ring	Factory specification	0.030 to 0.070 mm 0.0012 to 0.0027 in
		Allowable limit	0.2 mm 0.008 in.
	Oil ring	Factory specification	0.020 to 0.19 mm 0.00079 to 0.0074 in.
		Allowable limit	0.2 mm 0.008 in.

9Y1210661ENS0054US0



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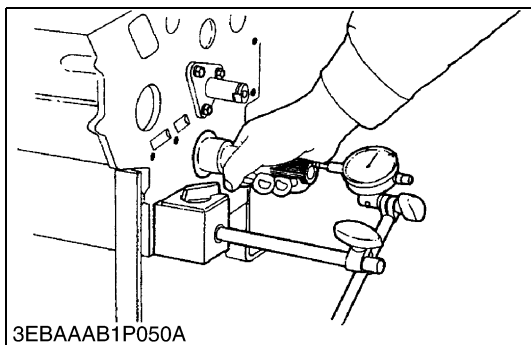
Connecting Rod Alignment

1. Remove the crankpin bearing, and install the connecting rod cap.
2. Install the piston pin in the connecting rod.
3. Install the connecting rod on the connecting rod alignment tool.
4. Put a gauge over the piston pin, and move it against the face plate.
5. If the gauge does not fit squarely against the face plate, measure the space between the pin of the gauge and the face plate.
6. If the measurement exceeds the allowable limit, replace the connecting rod.

Space between gauge pin face plate	Allowable limit	0.05 mm 0.002 in.
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9Y1210318ENS0113US0

(4) Crankshaft

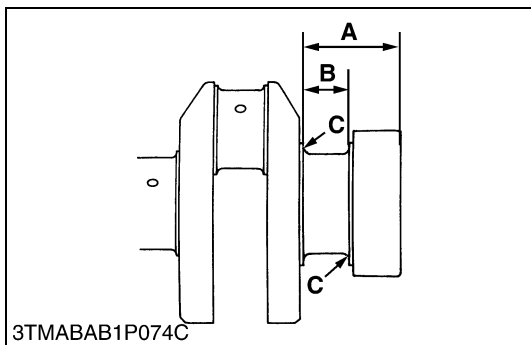


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Crankshaft Side Clearance

1. Set a dial indicator with its tip on the end of the crankshaft.
2. Measure the side clearance by moving the crankshaft to the front and rear.
3. If the measurement exceeds the allowable limit, replace the thrust bearings.
4. If the same size bearing is useless because of the crankshaft journal wear, replace it with an oversize one referring to the table and figure.

Crankshaft side clearance	Factory specification	0.15 to 0.31 mm 0.0059 to 0.012 in.
	Allowable limit	0.50 mm 0.020 in.



3TMABAB1P074C

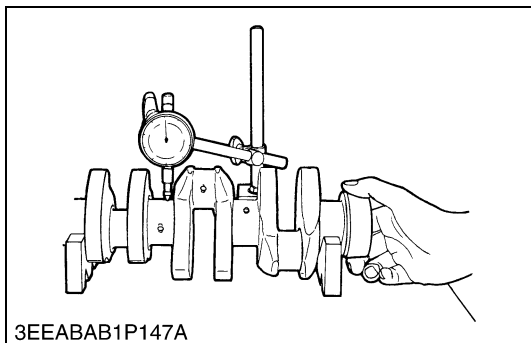
(Reference)

- Oversize dimensions of crankshaft journal

Oversize	0.2 mm 0.008 in.	0.4 mm 0.02 in.
Dimension A	51.50 to 51.70 mm 2.028 to 2.035 in.	51.60 to 51.80 mm 2.032 to 2.039 in.
Dimension B	28.20 to 28.25 mm 1.111 to 1.112 in.	28.40 to 28.45 mm 1.119 to 1.120 in.
Dimension C	2.3 to 2.7 mm radius 0.091 to 0.10 in. radius	2.3 to 2.7 mm radius 0.091 to 0.10 in. radius

The crankshaft journal must be fine-finished to higher than Rmax = 0.8S

9Y1210661ENS0055US0



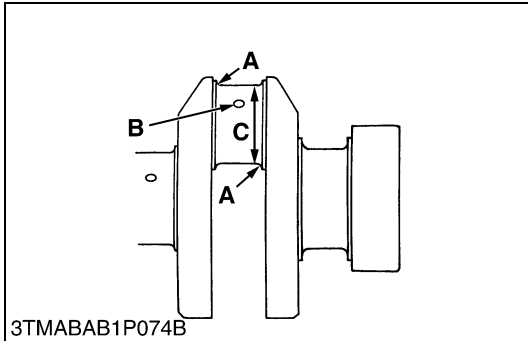
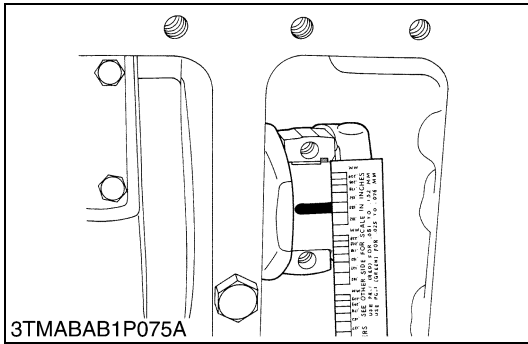
3EEABAB1P147A

Crankshaft Alignment

1. Support the crankshaft with V blocks on the surface plate at both end journals.
2. Set a dial indicator with its tip on the intermediate journal.
3. Measure the crankshaft alignment.
4. If the measurement exceeds the allowable limit, replace the crankshaft.

Crankshaft alignment	Allowable limit	0.02 mm 0.0008 in.
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9Y1210318ENS0115US0



Oil Clearance between Crankpin and Crankpin Bearing

1. Clean the crankpin and crankpin bearing.
2. Put a strip of plastigauge on the center of the crankpin.
3. Install the connecting rod cap and tighten the connecting rod screws to the specified torque, and remove the cap again.
4. Measure the amount of the flattening with the scale, and get the oil clearance.
5. If the oil clearance exceeds the allowable limit, replace the crankpin bearing.
6. If the same size bearing is useless because of the crankpin wear, replace it with an undersize one referring to the table and figure.

■ **NOTE**

- **Never insert the plastigauge into the crankpin oil hole.**
- **Be sure not to move the crankshaft while the connecting rod screws are tightened.**

Oil clearance between crankpin and crankpin bearing	Factory specification	0.065 to 0.091 mm 0.0026 to 0.0035 in
	Allowable limit	0.15 mm 0.0059 in.

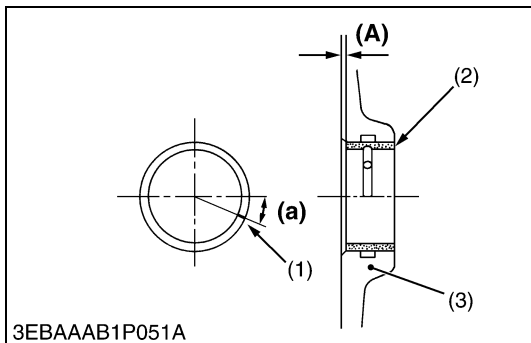
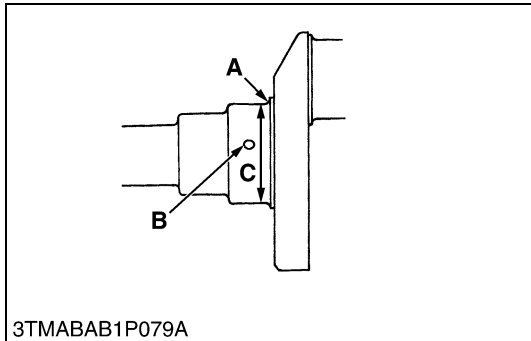
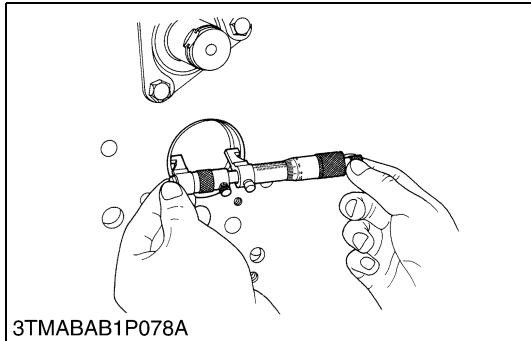
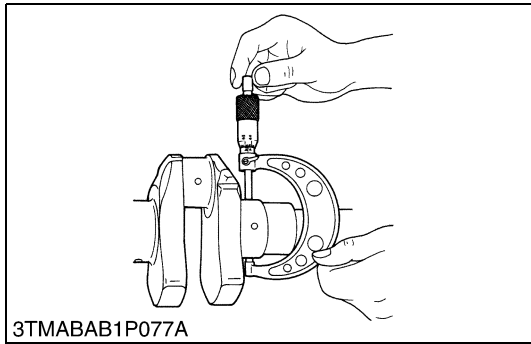
Crankpin O.D.	Factory specification	39.959 to 39.975 mm 1.5732 to 1.5738 in
Crankpin bearing I.D.	Factory specification	40.040 to 40.050 mm 1.5764 to 1.5767 in

(Reference)

- Undersize dimensions of crankpin

Undersize	0.2 mm 0.008 in.	0.4 mm 0.02 in.
Dimension A	2.8 to 3.2 mm radius 0.11 to 0.12 in. radius	2.8 to 3.2 mm radius 0.11 to 0.12 in. radius
*Dimension B	1.0 to 1.5 mm relief 0.040 to 0.059 in. relief	1.0 to 1.5 mm relief 0.040 to 0.059 in. relief
Dimension C	39.759 to 39.775 mm dia. 1.5654 to 1.5659 in. dia.	39.559 to 39.575 mm dia. 1.5575 to 1.5580 in. dia.
The crankpin journal must be fine-finished to higher than Rmax = 0.8S *Holes to be de-burred and edges rounded with 1.0 to 1.5 mm (0.040 to 0.059 in.) relief.		

9Y1210661ENS0056US0



Oil Clearance between Crankshaft Journal and Crankshaft Bearing 1

1. Measure the O.D. of the crankshaft front journal with an outside micrometer.
2. Measure the I.D. of the crankshaft bearing 1 with an inside micrometer, and calculate the oil clearance.
3. If the oil clearance exceeds the allowable limit, replace the crankshaft bearing 1.
4. If the same size bearing is useless because of the crankshaft journal wear, replace it with an undersize one referring to the table and the figure.

Oil Clearance between crankshaft journal and crankshaft bearing 1	Factory specification	0.0340 to 0.114 mm 0.00134 to 0.00448 in
	Allowable limit	0.20 mm 0.0079 in.

Crankshaft journal O.D.	Factory specification	47.934 to 47.950 mm 1.8872 to 1.8877 in
Crankshaft bearing 1 I.D.	Factory specification	47.984 to 48.048 mm 1.8892 to 1.8916 in

(Reference)

- Undersize dimensions of crankshaft journal

Undersize	0.2 mm 0.008 in.	0.4 mm 0.02 in.
Dimension A	2.3 to 2.7 mm radius 0.091 to 0.10 in. radius	2.3 to 2.7 mm radius 0.091 to 0.10 in. radius
*Dimension B	1.0 to 1.5 mm relief 0.040 to 0.059 in. relief	1.0 to 1.5 mm relief 0.040 to 0.059 in. relief
Dimension C	47.734 to 47.750 mm dia. 1.8793 to 1.8799 in. dia.	47.534 to 47.550 mm dia. 1.8715 to 1.8720 in. dia.

The crankshaft journal must be fine-finished to higher than Rmax = 0.8S
 *Holes to be de-burred and edges rounded with 1.0 to 1.5 mm (0.040 to 0.059 in.) relief.

9Y1210661ENS0057US0

Replacing Crankshaft Bearing 1

(When removing)

1. Press out the used crankshaft bearing 1 using a crankshaft bearing 1 replacing tool.

(When installing)

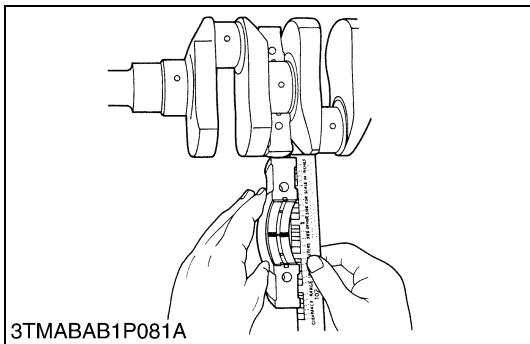
1. Clean a new crankshaft bearing 1 and crankshaft journal bore, and apply engine oil to them.
2. Using a crankshaft bearing 1 replacing tool, press in a new bearing 1 (2) so that its seam (1) directs toward the exhaust manifold side. (See figure.)

Dimension (A)	Factory specification	0 to 0.3 mm 0 to 0.01 in.
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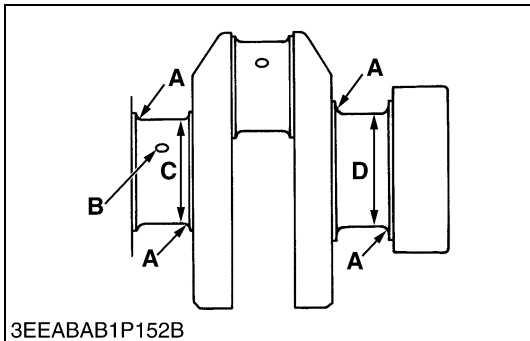
- (1) Seam
- (2) Crankshaft Bearing 1
- (3) Cylinder Block

(A) Dimension
(a) 0.37 rad (21 °)

9Y1210318ENS0118US0



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3EEABAB1P152B

Oil Clearance between Crankshaft Journal and Crankshaft Bearing 2 (Crankshaft Bearing 3)

1. Put a strip of plastigauge on the center of the journal.
2. Install the bearing case and tighten the bearing case screws 1 to the specified torque, and remove the bearing case again.
3. Measure the amount of the flattening with the scale, and get the oil clearance.
4. If the oil clearance exceeds the allowable limit, replace the crankshaft bearing 2 (crankshaft bearing 3).
5. If the same size bearing is useless because of the crankshaft journal wear, replace it with an undersize one referring to the table and figure.

■ **NOTE**

- **Be sure not to move the crankshaft while the bearing case screws are tightened.**

Oil clearance between crankshaft journal and crankshaft bearing 2	Factory specification	0.034 to 0.095 mm 0.0014 to 0.0037 in
	Allowable limit	0.20 mm 0.0079 in.

Crankshaft journal O.D. (Flywheel side)	Factory specification	47.934 to 47.950 mm 1.8872 to 1.8877 in
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Crankshaft bearing 2 I.D.	Factory specification	47.984 to 48.029 mm 1.8892 to 1.8909 in
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Oil clearance between crankshaft journal and crankshaft bearing 3	Factory specification	0.0340 to 0.103 mm 0.00134 to 0.00405 in
	Allowable limit	0.20 mm 0.0079 in.

Crankshaft journal O.D. (Intermediate)	Factory specification	51.921 to 51.940 mm 2.0442 to 2.0448 in
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Crankshaft bearing 3 I.D.	Factory specification	51.974 to 52.024 mm 2.0463 to 2.0481 in
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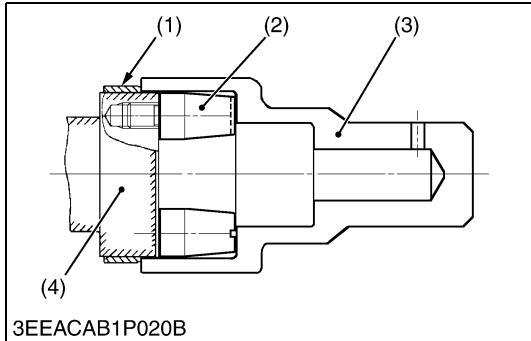
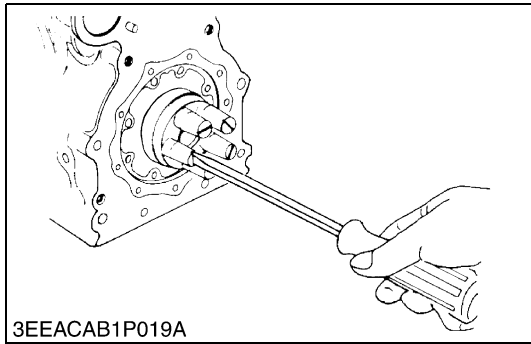
(Reference)

- Undersize dimensions of crankshaft journal

Undersize	0.2 mm 0.008 in.	0.4 mm 0.02 in.
Dimension A	2.3 to 2.7 mm radius 0.091 to 0.10 in. radius	2.3 to 2.7 mm radius 0.091 to 0.10 in. radius
*Dimension B	1.0 to 1.5 mm relief 0.040 to 0.059 in. relief	1.0 to 1.5 mm relief 0.040 to 0.059 in. relief
Dimension C	47.734 to 47.750 mm dia. 1.8793 to 1.8799 in. dia.	47.534 to 47.550 mm dia. 1.8715 to 1.8720 in. dia.
Dimension D	51.721 to 51.740 mm dia. 2.0362 to 2.0370 in. dia.	51.521 to 51.540 mm dia. 2.0284 to 2.0291 in. dia.

The crankshaft journal must be fine-finished to higher than Rmax = 0.8S
 *Holes to be de-burred and edges rounded with 1.0 to 1.5 mm (0.040 to 0.059 in.) relief.

9Y1210661ENS0058US0



Replacing Crankshaft Sleeve

1. Remove the used crankshaft sleeve.
2. Set the sleeve guide (2) to the crankshaft.
3. Heat a new sleeve to a temperature between 150 and 200 °C (302 and 392 °F), and fix the sleeve to the crankshaft as shown in figure.
4. Press fit the sleeve using the auxiliary socket for pushing (3).

■ **NOTE**

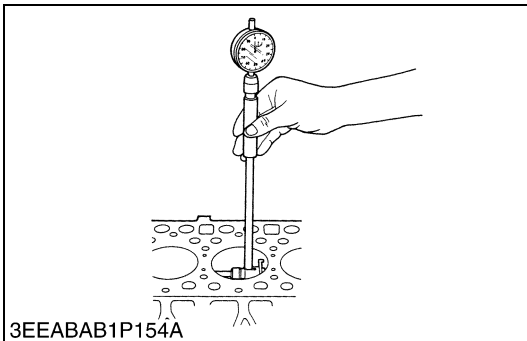
- **Mount the sleeve with its largely chamfered surface facing outward.**
- **Should heating is not enough, a sleeve might stop halfway, so careful.**

- (1) Crankshaft Sleeve
- (2) Sleeve Guide

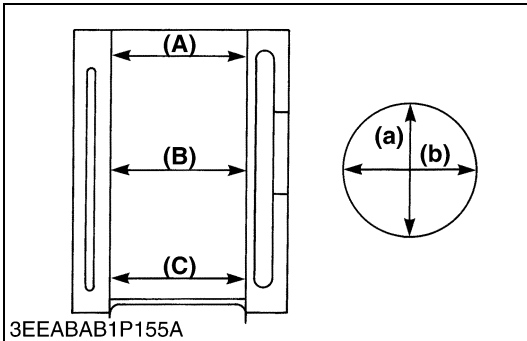
- (3) Auxiliary Socket for Pushing
- (4) Crankshaft

9Y1210661ENS0106US0

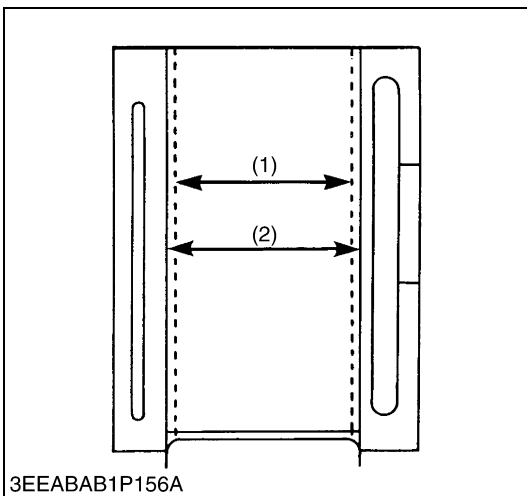
(5) Cylinder



3EEABAB1P154A



3EEABAB1P155A



3EEABAB1P156A

Cylinder Wear

1. Measure the I.D. of the cylinder at the six positions (see figure) with a cylinder gauge to find the maximum and minimum I.D.'s.
2. Get the difference (Maximum wear) between the maximum and the minimum I.D.'s.

Cylinder I.D.	Factory specification	79.000 to 79.019 mm 3.1103 to 3.1109 in
	Allowable limit	79.15 mm 3.116 in.

- (A) Top (a) Right-Angled to Piston Pin
 (B) Middle (b) Piston Pin Direction
 (C) Bottom (Skirt)

9Y1210661ENS0076US0

Correcting Cylinder (Oversize)

1. When the cylinder is worn beyond the allowable limit, bore and hone it to the specified dimension.

Cylinder liner I.D.	Factory specification	79.500 to 79.519 mm 3.1300 to 3.1306 in
	Allowable limit	79.65 mm 3.136 in.
Finishing	Hone to 2.2 to 3.0 μmRz (87 to 110 $\mu\text{in.Rz}$)	

2. Replace the piston and piston rings with oversize ones.
 Oversize: 0.5 mm (0.02 in.)
 Marking: 05

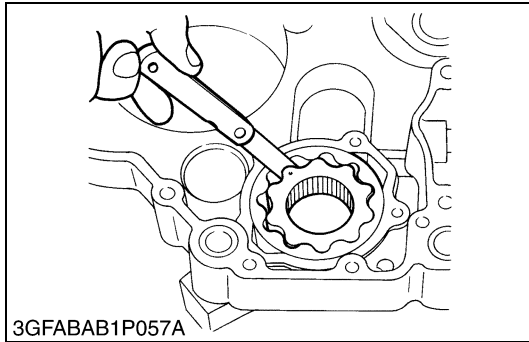
■ **NOTE**

- When the oversize cylinder is worn beyond the allowable limit, replace the cylinder block with a new one.

- (1) Cylinder I.D. (Before Correction) (2) Cylinder I.D. (Oversize)

9Y1210661ENS0077US0

(6) Oil Pump



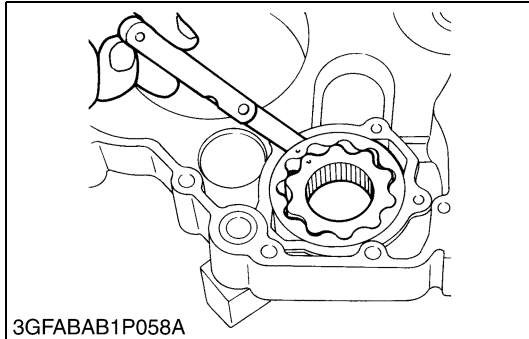
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Rotor Lobe Clearance

1. Measure the clearance between lobes of the inner rotor and the outer rotor with a feeler gauge.
2. If the clearance exceeds the factory specifications, replace the oil pump rotor assembly.

Rotor lobe clearance	Factory specification	0.060 to 0.18 mm 0.0024 to 0.0071 in.
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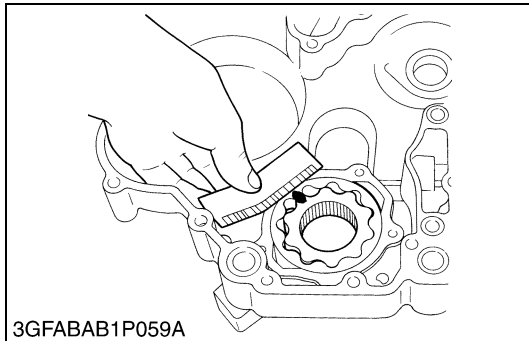
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Clearance between Outer Rotor and Pump Body

1. Measure the clearance between the outer rotor and the pump body with a feeler gauge.
2. If the clearance exceeds the factory specifications, replace the oil pump rotor assembly.

Clearance between outer rotor and pump body	Factory specification	0.100 to 0.180 mm 0.00394 to 0.00708 in.
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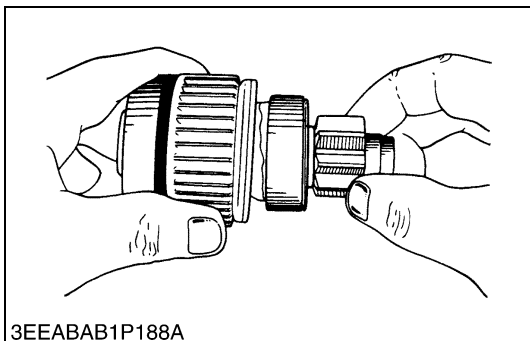
Clearance between Rotor and Cover

1. Put a strip of plastic onto the rotor face with grease.
2. Install the cover and tighten the screws.
3. Remove the cover carefully, and measure the amount of the flattening with the scale and get the clearance.
4. If the clearance exceeds the factory specifications, replace the oil pump rotor assembly.

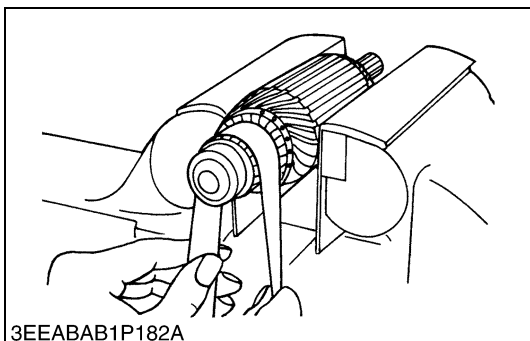
Clearance between rotor and cover	Factory specification	0.025 to 0.075 mm 0.00099 to 0.0029 in.
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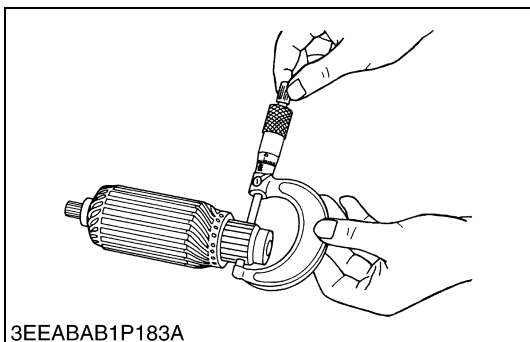
(7) Starter



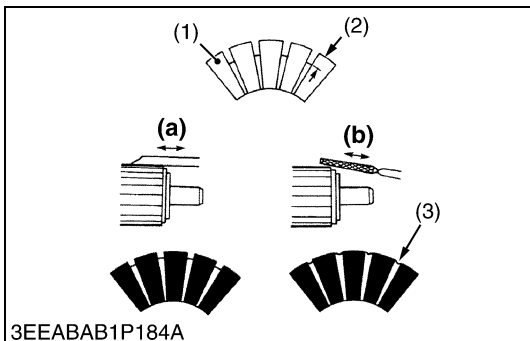
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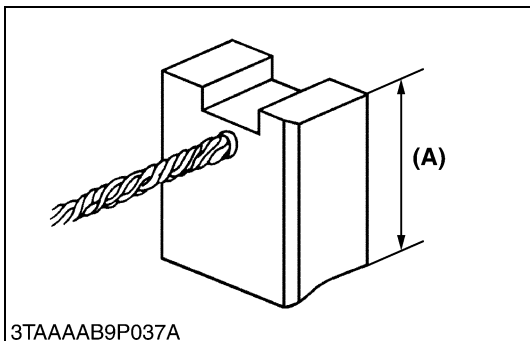
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3EEABAB1P183A



3EEABAB1P184A



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Overrunning Clutch

1. Inspect the pinion for wear or damage.
2. If there is any defect, replace the overrunning clutch assembly.
3. Check that the pinion turns freely and smoothly in the overrunning direction and does not slip in the cranking direction.
4. If the pinion slips or does not rotate in the both directions, replace the overrunning clutch assembly.

9Y1210318ENS0125US0

Commutator and Mica

1. Check the contact face of the commutator for wear, and grind the commutator with emery paper if it is slightly worn.
2. Measure the commutator O.D. with an outside micrometer at several points.
3. If the minimum O.D. is less than the allowable limit, replace the armature.
4. If the difference of the O.D.'s exceeds the allowable limit, correct the commutator on a lathe to the factory specification.
5. Measure the mica undercut.
6. If the undercut is less than the allowable limit, correct it with a saw blade and chamfer the segment edges.

Commutator O.D.	Factory specification	28.0 mm 1.10 in.
	Allowable limit	27.0 mm 1.06 in.

Difference of O.D.'s	Factory specification	Less than 0.05 mm 0.002 in.
	Allowable limit	0.4 mm 0.02 in.

Mica undercut	Factory specification	0.50 to 0.80 mm 0.020 to 0.031 in.
	Allowable limit	0.20 mm 0.0079 in.

- | | |
|--------------|----------|
| (1) Segment | (a) Good |
| (2) Undercut | (b) Bad |
| (3) Mica | |

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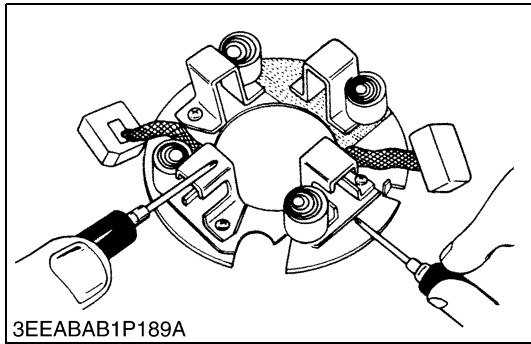
Brush Wear

1. If the contact face of the brush is dirty or dusty, clean it with emery paper.
2. Measure the brush length (A) with vernier calipers.
3. If the length is less than the allowable limit, replace the yoke assembly and brush holder.

Brush length (A)	Factory specification	16.0 mm 0.630 in.
	Allowable limit	10.5 mm 0.413 in.

(A) Brush Length

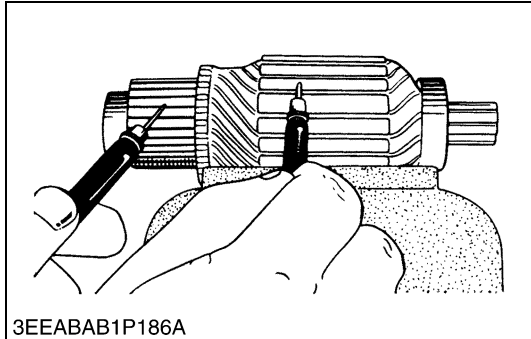
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Brush Holder

1. Check the continuity across the brush holder and the holder support with an ohmmeter.
2. If it conducts, replace the brush holder.

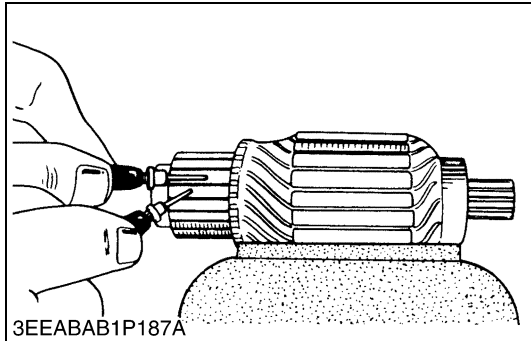
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Armature Coil

1. Check the continuity across the commutator and armature coil core with an ohmmeter.
2. If it conducts, replace the armature.
3. Check the continuity across the segments of the commutator with an ohmmeter.
4. If it does not conduct, replace the armature.

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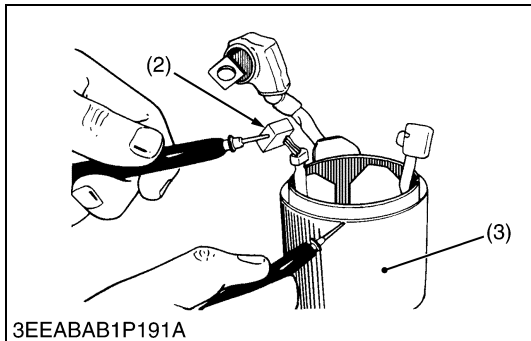
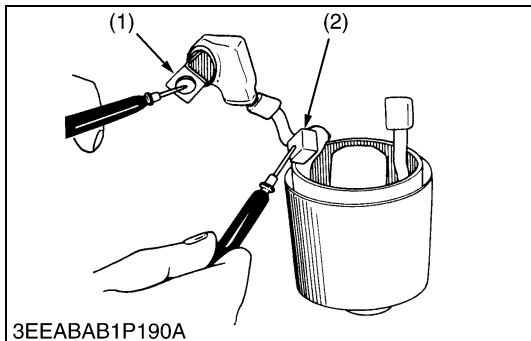


Field Coil

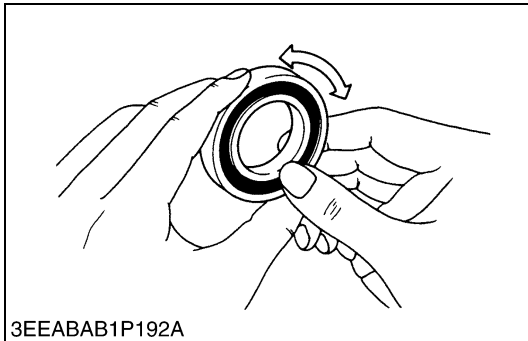
1. Check the continuity across the lead (1) and brush (2) with an ohmmeter.
2. If it does not conduct, replace the yoke assembly.
3. Check the continuity across the brush (2) and yoke (3) with an ohmmeter.
4. If it conducts, replace the yoke assembly.

- (1) Lead
- (2) Brush
- (3) Yoke

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(8) Alternator

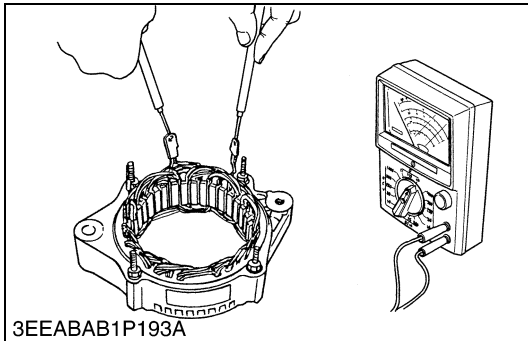


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Bearing

1. Check the bearing for smooth rotation.
2. If it does not rotate smoothly, replace it.

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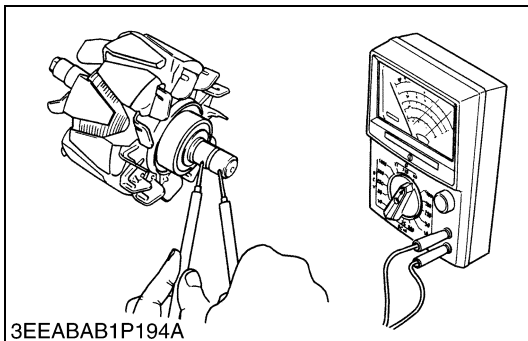
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Stator

1. Measure the resistance across each lead of the stator coil with resistance range of circuit tester.
2. If the measurement is not within factory specification, replace it.
3. Check the continuity across each stator coil lead and core with resistance range of circuit tester.
4. If infinity is not indicated, replace it.

Resistance	Factory specification	Less than 1.0 Ω
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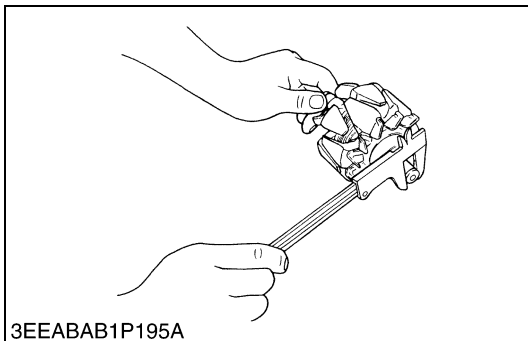
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Rotor

1. Measure the resistance across the slip rings.
2. If the resistance is not the factory specification, replace it.
3. Check the continuity across the slip ring and core with resistance range of circuit tester.
4. If infinity is not indicated, replace it.

Resistance	Factory specification	2.9 Ω
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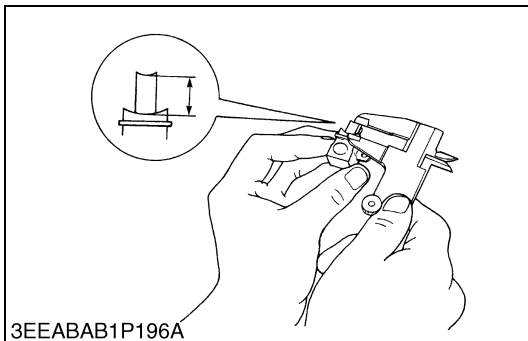
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Slip Ring

1. Check the slip ring for score.
2. If scored, correct with an emery paper or on a lathe.
3. Measure the O.D. of slip ring with vernier calipers.
4. If the measurement is less than the allowable limit, replace it.

Slip ring O.D.	Factory specification	14.4 mm 0.567 in.
	Allowable limit	14.0 mm 0.551 in.

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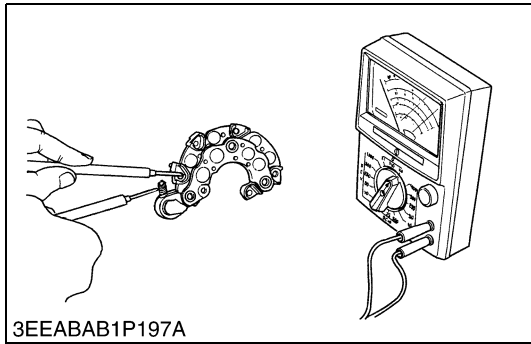
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Brush Wear

1. Measure the brush length with vernier calipers.
2. If the measurement is less than allowable limit, replace it.
3. Make sure that the brush moves smoothly.
4. If the brush is defective, replace it.

Brush length	Factory specification	10.0 mm 0.394 in.
	Allowable limit	8.4 mm 0.33 in.

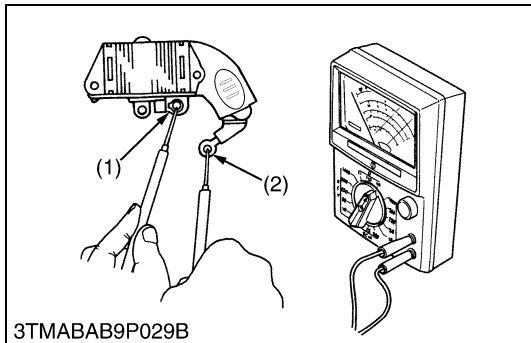
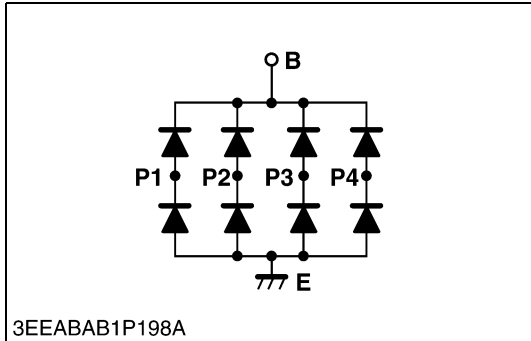
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Rectifier

1. Check the continuity across each diode of rectifier with resistance range of circuit tester.
2. The rectifier is normal if the diode in the rectifier conducts in one direction and does not conduct in the reverse direction.

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IC Regulator

1. Check the continuity across the **B** terminal (2) and the **F** terminal (1) of IC regulator with resistance range of circuit tester.
2. The IC regulator is normal if the conducts in one direction and does not conduct in the reverse direction.

(1) **F** Terminal

(2) **B** Terminal

9Y1210318ENS0137US0

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