

<SUPPLEMENT-II>

ENGINE MECHANICAL

EM

SECTION **EM**

## CONTENTS

TD engine

KA24DE engine

# ENGINE MECHANICAL

# SECTION **EM**

EM

### MODIFICATION NOTICE:

#### Diesel engine:

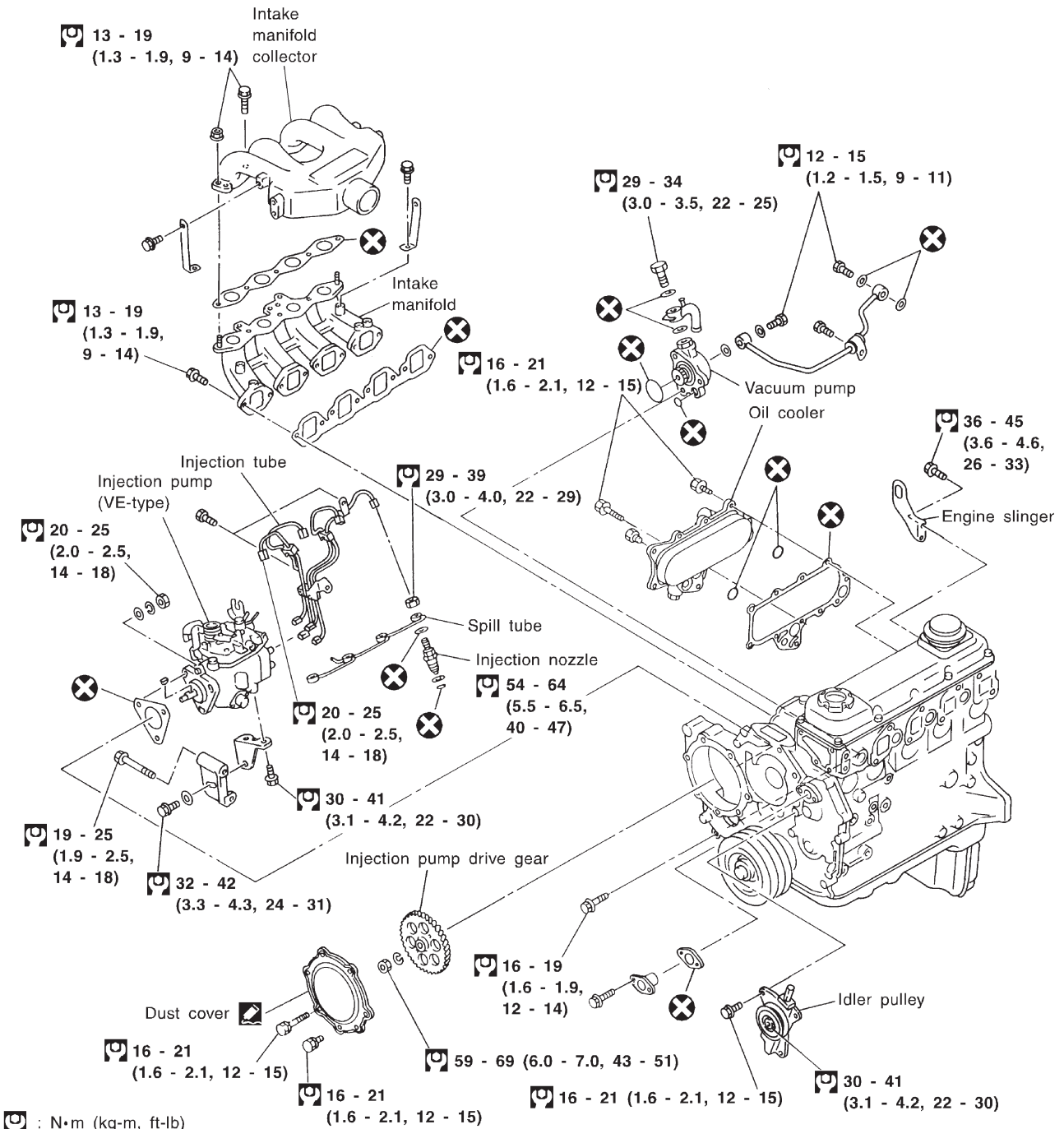
- The main bearing clearance has been changed.
- The tightening torque has been changed on bolts and nuts for the engine slinger, crankshaft pulley and flywheel.
- A washer has been added between the glow plate and the glow plug.

## CONTENTS

<input type="text"/>	TD	<input type="text"/>
<b>OUTER COMPONENT PARTS</b> .....		2002
<b>CYLINDER HEAD</b> .....		2003

<b>SERVICE DATA AND SPECIFICATIONS (SDS)</b> .....	2004
Inspection and Adjustment .....	2004

SEC. 135•140•185•186•213

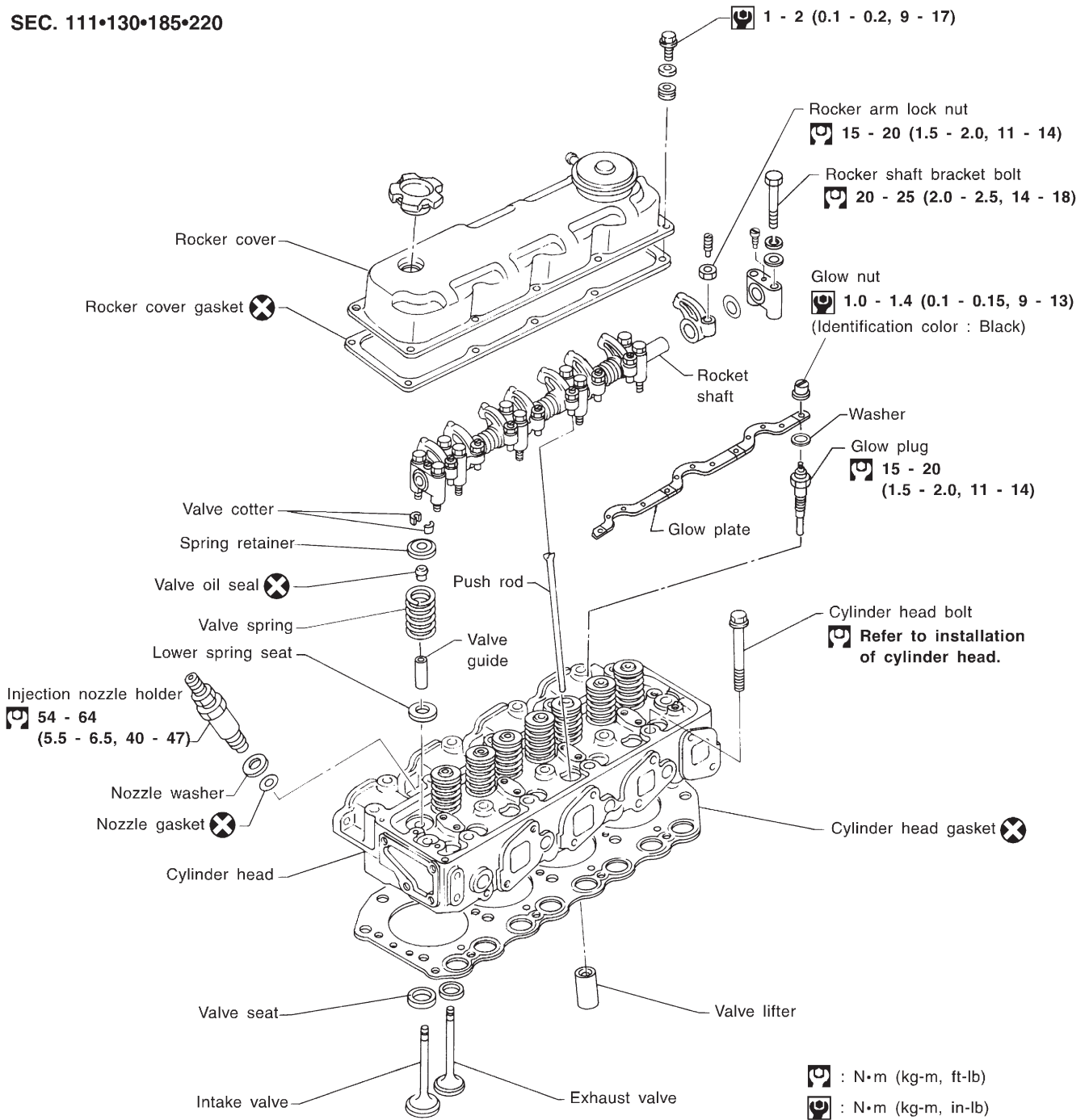


- : N•m (kg-m, ft-lb)
- : Apply recommended sealant (Nissan genuine part: KP610-00250) or equivalent.

# CYLINDER HEAD

TD

SEC. 111•130•185•220



DEM144

EM-2003

Inspection and Adjustment

AVAILABLE MAIN BEARING

Bearing clearance

Unit: mm (in)

Main bearing clearance	
Standard	0.035 - 0.083 (0.0014 - 0.0033)
Limit	0.15 (0.0059)
Connecting rod bearing clearance	
Standard	0.035 - 0.077 (0.0014 - 0.0030)
Limit	0.15 (0.0059)

# ENGINE MECHANICAL

## SECTION **EM**

EM

### MODIFICATION NOTICE:

#### Gasoline engine:

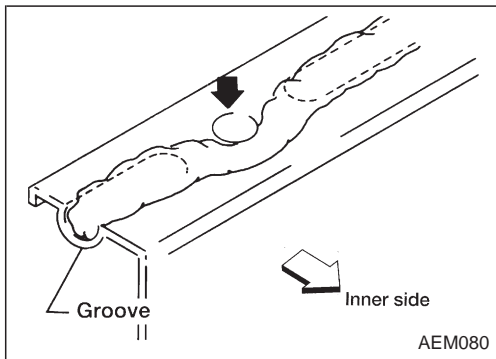
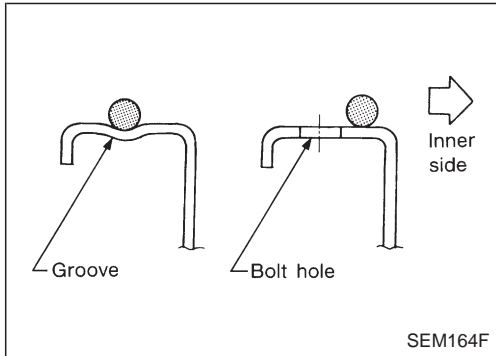
- KA24DE engine information has been added.

## CONTENTS

	KA24DE		
<b>PRECAUTIONS AND PREPARATION</b> .....			2002
Parts Requiring Angular Tightening.....			2002
Liquid Gasket Application Procedure .....			2002
Special Service Tools .....			2003
Commercial Service Tools.....			2006
<b>OUTER COMPONENT PARTS</b> .....			2007
<b>COMPRESSION PRESSURE</b> .....			2010
Measurement of Compression Pressure .....			2010
<b>OIL PAN</b> .....			2011
Removal .....			2011
Installation .....			2012
<b>TIMING CHAIN</b> .....			2013
Removal .....			2015
Inspection.....			2017
Installation .....			2018
<b>OIL SEAL REPLACEMENT</b> .....			2021
<b>CYLINDER HEAD</b> .....			2024
Removal .....			2025
Installation .....			2025
Disassembly .....			2026
Inspection.....			2026
Assembly.....			2032
Valve Clearance.....			2032
<b>ENGINE REMOVAL</b> .....			2035
Removal .....			2036
Installation .....			2037
<b>CYLINDER BLOCK</b> .....			2038
Disassembly .....			2039
Inspection.....			2039
Assembly.....			2045
<b>SERVICE DATA AND SPECIFICATIONS (SDS)</b> .....			2049
General Specifications .....			2049
Inspection and Adjustment .....			2049

### Parts Requiring Angular Tightening

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

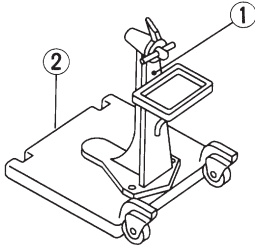
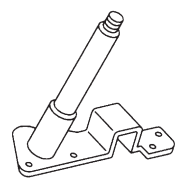
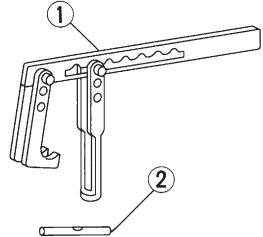
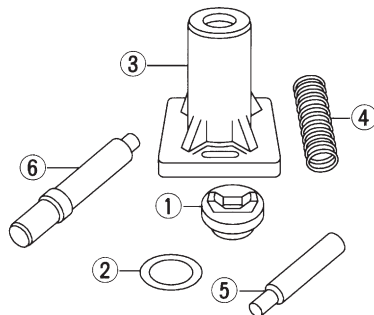
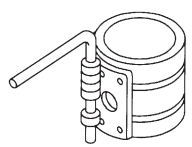


### Liquid Gasket Application Procedure

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

Special Service Tools

\*: Special tool or commercial equivalent

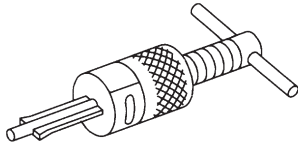
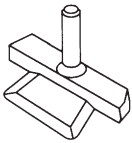
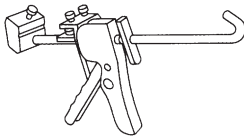
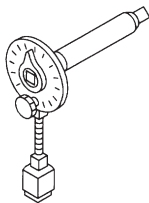
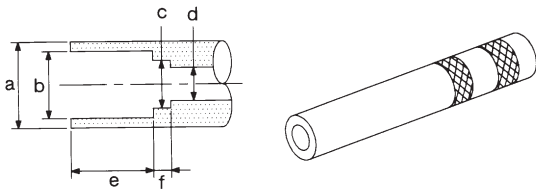
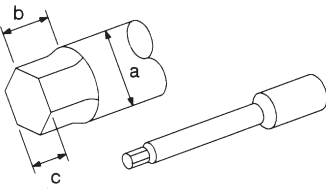
Tool number Tool name	Description
ST0501S000* Engine stand assembly ① ST05011000 Engine stand ② ST05012000 Base	 <p>Disassembling and assembling</p> <p>NT042</p>
KV10105001* Engine attachment	 <p>NT031</p>
KV101092S0* Valve spring compressor ① KV10109210 Compressor ② KV10109220 Adapter	 <p>Disassembling and assembling valve components)</p> <p>NT021</p>
KV10110300 Piston pin press stand assembly ① KV10110310 Cap ② KV10110330 Spacer ③ ST13030020 Press stand ④ ST13030030 Spring ⑤ KV10110340 Drift ⑥ KV10110320 Center shaft	 <p>Disassembling and assembling piston with connecting rod</p> <p>NT036</p>
EM03470000* Piston ring compressor	 <p>Installing piston assembly into cylinder bore</p> <p>NT044</p>



# PRECAUTIONS AND PREPARATION

KA24DE

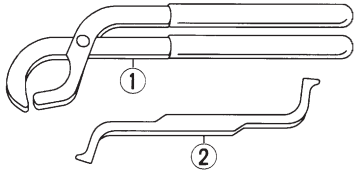
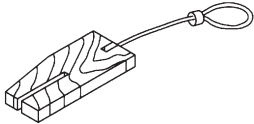
## Special Service Tools (Cont'd)

Tool number Tool name	Description	
ST16610001* Pilot bushing puller		Removing crankshaft pilot bushing
	NT045	
KV10111100 Seal cutter		Removing oil pan
	NT046	
WS39930000* Tube presser		Pressing the tube of liquid gasket
	NT052	
KV10112100 Angle wrench		Tightening bolts for bearing cap, cylinder head, etc.
	NT014	
KV10116300 Valve oil seal drift		Installing valve oil seal
	NT602	<p><b>a: 25 (0.98) dia.</b>  <b>b: 14.4 (0.567) dia.</b>  <b>c: 11.8 (0.465) dia.</b>  <b>d: 10 (0.39) dia.</b>  <b>e: 11 (0.43)</b>  <b>f: 9 (0.35)</b></p> <p style="text-align: right;">Unit: mm (in)</p>
ST10120000 Cylinder head bolt wrench		Loosening and tightening cylinder head bolt
	NT583	<p><b>a: 13 (0.51) dia.</b>  <b>b: 12 (0.47)</b>  <b>c: 10 (0.39)</b></p> <p style="text-align: right;">Unit: mm (in)</p>

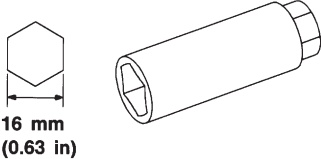
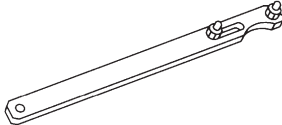
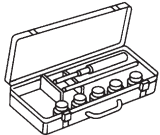
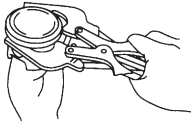
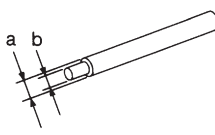
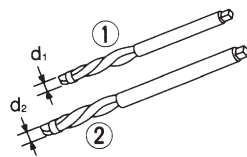
# PRECAUTIONS AND PREPARATION

KA24DE

## Special Service Tools (Cont'd)

Tool number Tool name	Description
KV101151S0 Lifter stopper set ① KV10115110 Camshaft pliers ② KV10115120 Lifter stopper	 <p>Changing valve lifter shims</p> <p>NT041</p>
KV10105800* Chain stopper	 <p>Removing and installing idler sprocket</p> <p>NT010</p>

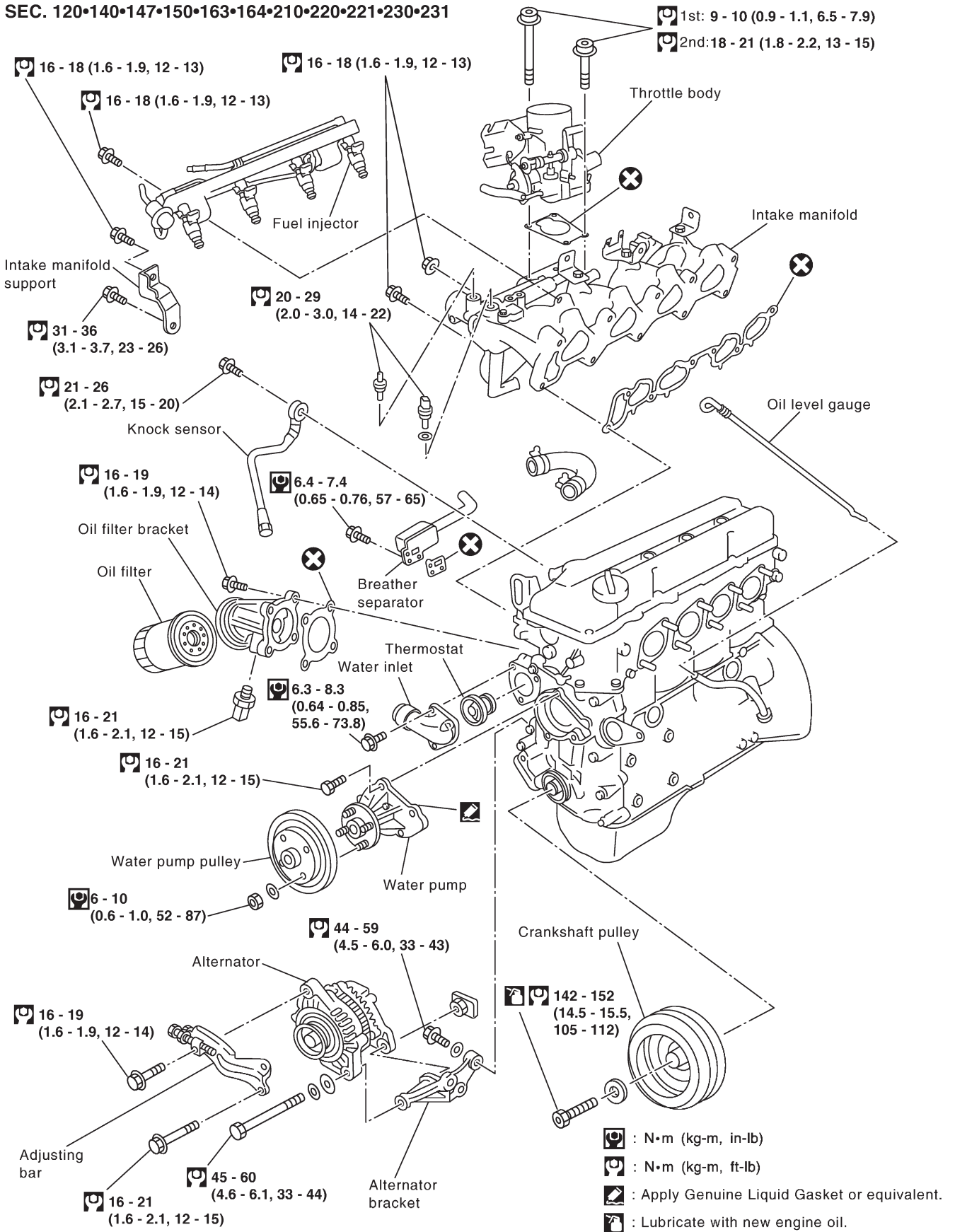
Commercial Service Tools

Tool name	Description												
Spark plug wrench	 <p>16 mm (0.63 in)</p> <p>NT047</p> <p>Removing and installing spark plug</p>												
Pulley holder	 <p>NT035</p> <p>Holding camshaft pulley while tightening or loosening camshaft bolt</p>												
Valve seat cutter set	 <p>NT048</p> <p>Finishing valve seat dimensions</p>												
Piston ring expander	 <p>NT030</p> <p>Removing and installing piston ring</p>												
Valve guide drift	 <p>NT015</p> <p>Removing and installing valve guide</p> <table border="1" data-bbox="986 1160 1479 1328"> <thead> <tr> <th colspan="2">Diameter:</th> <th>mm (in)</th> </tr> </thead> <tbody> <tr> <td colspan="2"></td> <td>Intake &amp; Exhaust</td> </tr> <tr> <td>a</td> <td></td> <td>10.5 (0.413)</td> </tr> <tr> <td>b</td> <td></td> <td>6.6 (0.260)</td> </tr> </tbody> </table>	Diameter:		mm (in)			Intake & Exhaust	a		10.5 (0.413)	b		6.6 (0.260)
Diameter:		mm (in)											
		Intake & Exhaust											
a		10.5 (0.413)											
b		6.6 (0.260)											
Valve guide reamer	 <p>NT016</p> <p>Reaming valve guide (①) or hole for over-size valve guide (②)</p> <table border="1" data-bbox="986 1444 1479 1608"> <thead> <tr> <th colspan="2">Diameter:</th> <th>mm (in)</th> </tr> </thead> <tbody> <tr> <td colspan="2"></td> <td>Intake &amp; Exhaust</td> </tr> <tr> <td>d<sub>1</sub></td> <td></td> <td>7 (0.28)</td> </tr> <tr> <td>d<sub>2</sub></td> <td></td> <td>11.175 (0.4400)</td> </tr> </tbody> </table>	Diameter:		mm (in)			Intake & Exhaust	d <sub>1</sub>		7 (0.28)	d <sub>2</sub>		11.175 (0.4400)
Diameter:		mm (in)											
		Intake & Exhaust											
d <sub>1</sub>		7 (0.28)											
d <sub>2</sub>		11.175 (0.4400)											

# OUTER COMPONENT PARTS

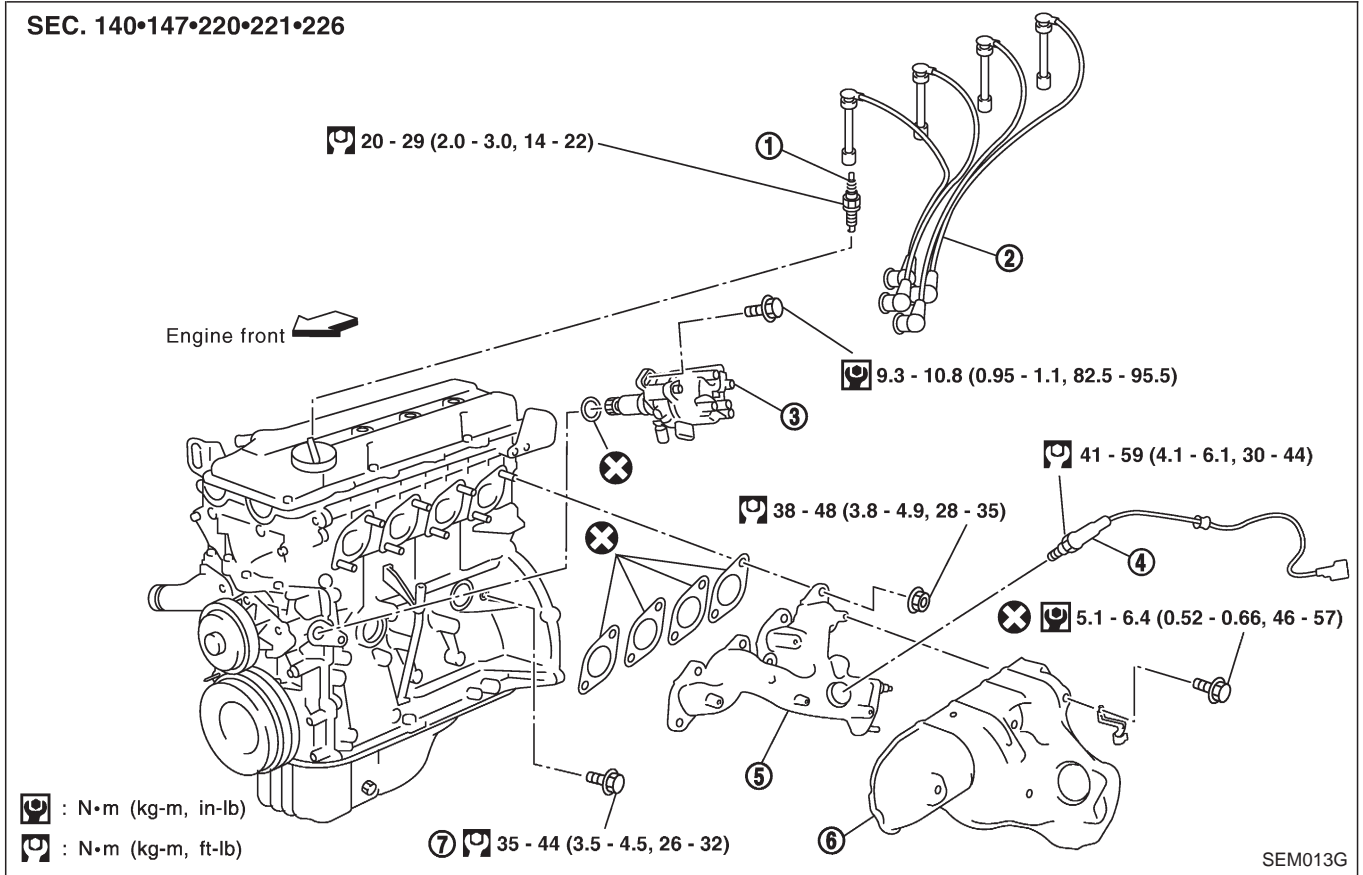
KA24DE

SEC. 120•140•147•150•163•164•210•220•221•230•231



SEM012G

SEC. 140•147•220•221•226



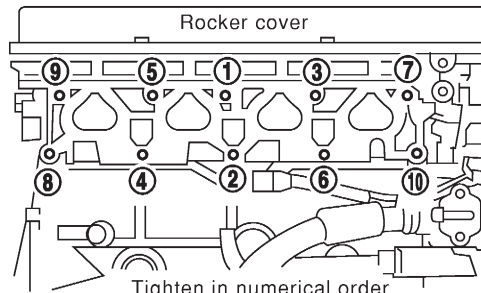
- ① Spark plug
- ② Ignition wire
- ③ Camshaft position sensor built into distributor

- ④ Heated oxygen sensor
- ⑤ Exhaust manifold


- ⑥ Exhaust manifold cover
- ⑦ Water drain plug

## Intake manifold

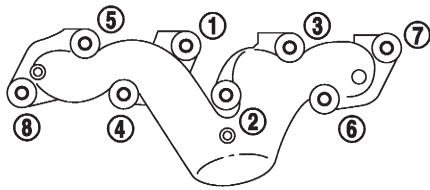
Engine front 




Tighten in numerical order.  
Loosen in reverse order.


 15.7 - 18.6 (1.6 - 1.9, 11.6 - 13.7)

## Exhaust manifold

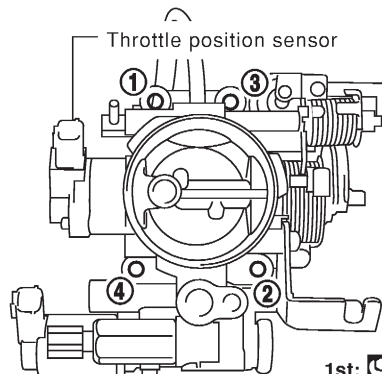


Tighten in numerical order.  
Loosen in reverse order.


 37.3 - 48.0 (3.8 - 4.9, 27.5 - 35.4)


 : N·m (kg·m, ft·lb)

## Throttle body



Tighten in numerical order.  
Loosen in reverse order.

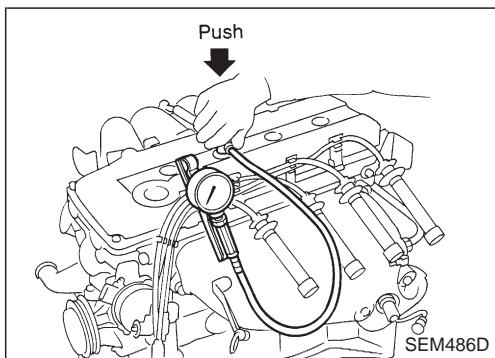
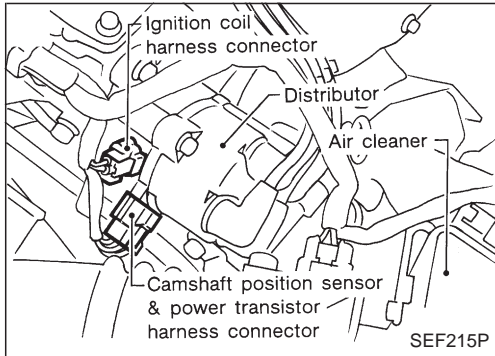
1st:  9 - 11 (0.9 - 1.1, 6.5 - 8.0)

2st:  18 - 22 (1.8 - 2.2, 13 - 16)

SEM976F

## Measurement of Compression Pressure

1. Warm up engine.
2. Turn ignition switch OFF.
3. Release fuel pressure.  
Refer to EC section ("Fuel Pressure Release", "BASIC SERVICE PROCEDURE").
4. Remove all spark plugs.
  - **Clean area around the plug with compressed air before removing the spark plug.**



5. Disconnect camshaft position sensor harness connector at the distributor.
6. Disconnect all fuel injector harness connectors.

7. Attach a compression tester to No. 1 cylinder.
8. Depress accelerator pedal fully to keep throttle valve wide open.
9. Crank engine and record highest gauge indication.
10. Repeat the measurement on each cylinder as shown above.
  - **Always use a fully-charged battery to obtain specified engine speed.**

**Compression pressure: kPa (bar, kg/cm<sup>2</sup>, psi)/rpm**

**Standard**

**1,226 (12.26, 12.5, 178)/300**

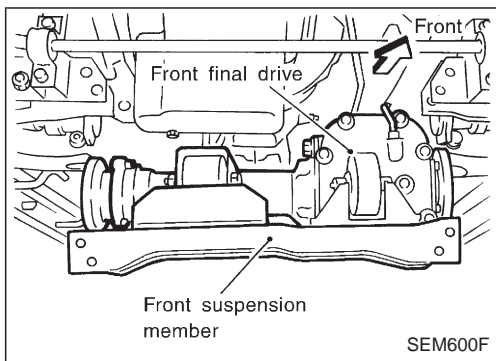
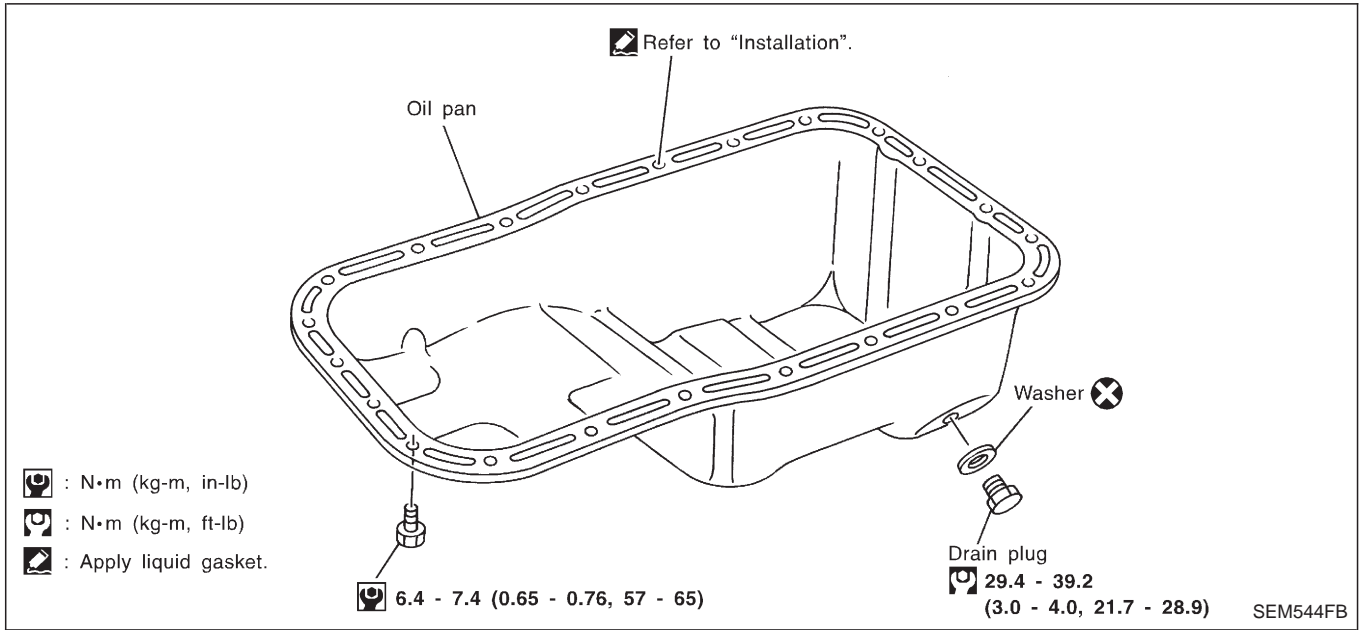
**Minimum**

**1,030 (10.30, 10.5, 149)/300**

**Difference limit between cylinders**

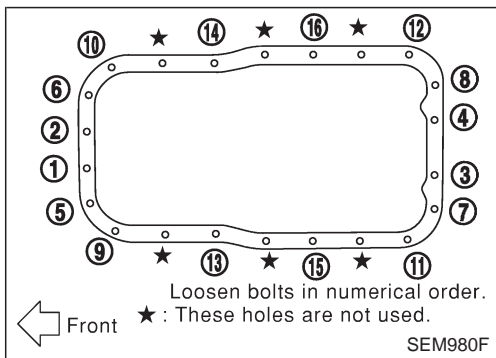
**98 (0.98, 1.0, 14)/300**

11. If compression in one or more cylinders is low:
  - a. Pour a small amount of engine oil into cylinders through spark plug holes.
  - b. Retest compression.
  - **If adding oil improves cylinder compression, piston rings may be worn or damaged. If so, replace piston rings after checking piston.**
  - **If pressure stays low, a valve may be sticking or seating improperly. Inspect and repair valve and valve seat. (Refer to SDS, EM-2049 and EM-2051.) If valve or valve seat is damaged excessively, replace it.**
  - **If compression stays low in two cylinders that are next to each other:**
    - a. **The cylinder head gasket may be leaking, or**
    - b. **Both cylinders may have valve component damage. Inspect and repair as necessary.**
12. Reconnect fuel pump fuse, all fuel injector harness connectors, and the camshaft position sensor harness connector at the distributor, and then reinstall spark plugs.

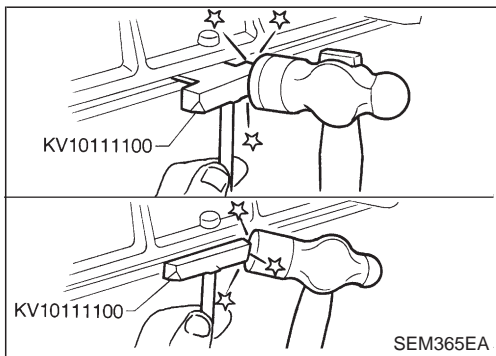


## Removal

1. Raise vehicle and support it with safety stands.
2. Remove engine under cover.
3. Drain engine oil.
4. Remove front final drive together with differential mounting member. Refer to PD section ("Removal and Installation", "Front final drive") — 4WD models only.
5. Remove front suspension member.

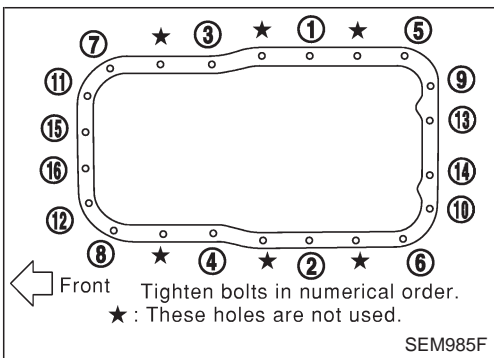
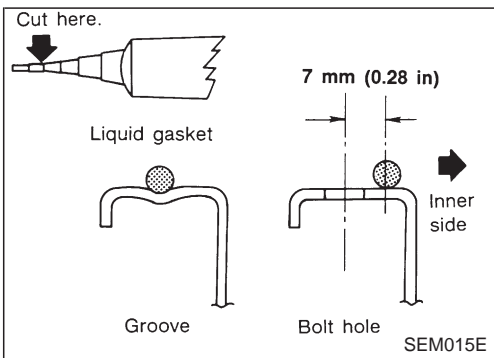
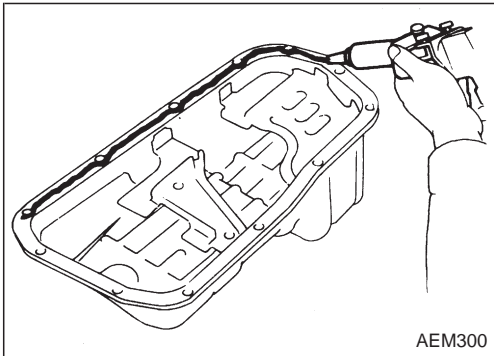
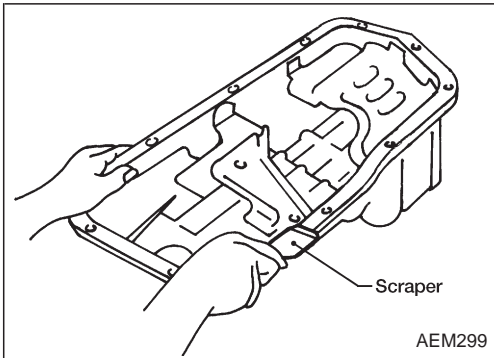


6. Remove oil pan bolts.



7. Remove oil pan.
  - a. Insert Tool between cylinder block and oil pan.
    - **Be careful not to damage aluminum mating surface.**
    - **Do not insert screwdriver, or oil pan flange will be damaged.**
  - b. Slide Tool by tapping on the side of the Tool with a hammer.
8. Pull out oil pan from front side.





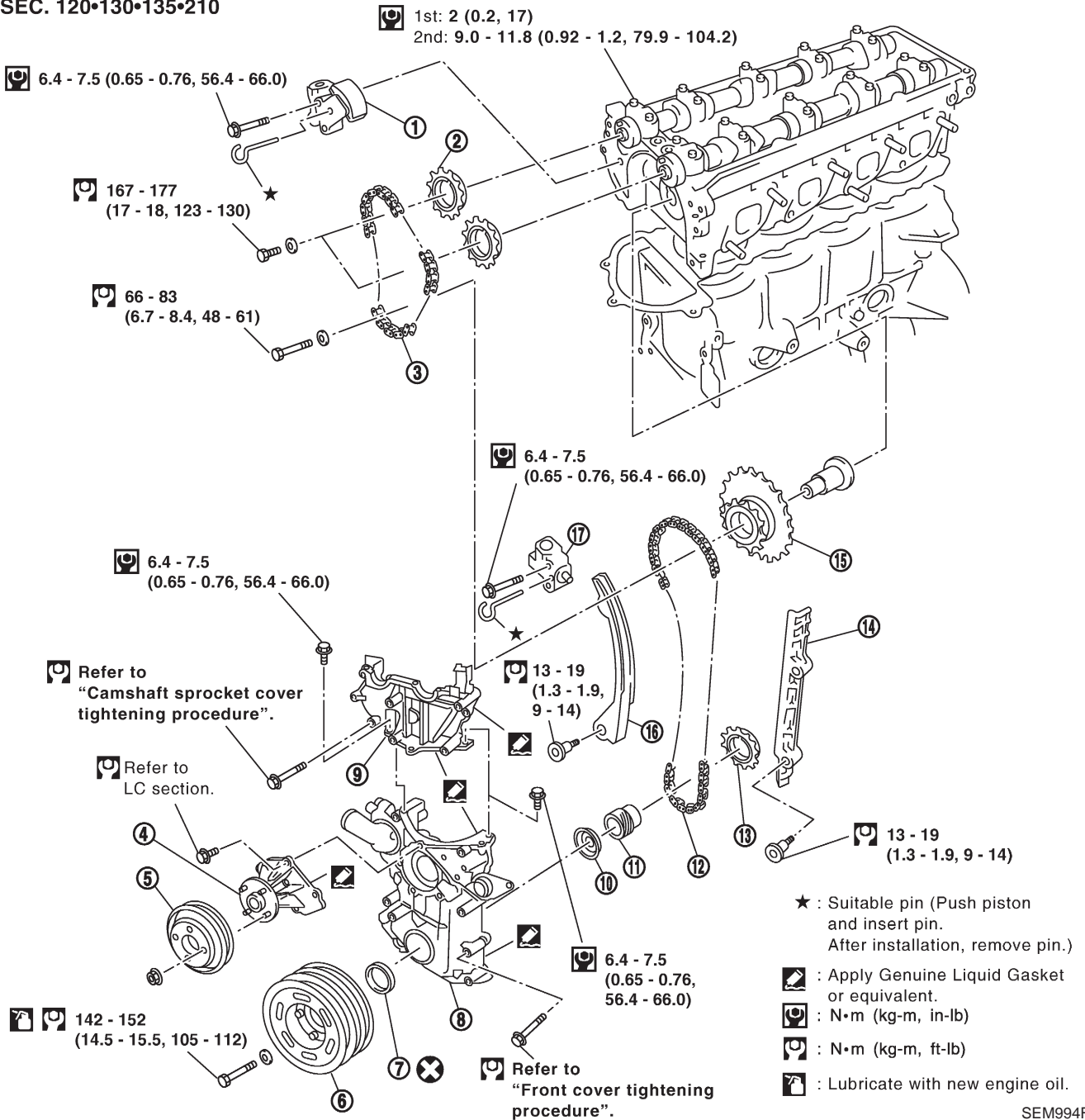
## Installation

- Use a scraper to remove old liquid gasket from mating surface of oil pan.
  - Also remove traces of liquid gasket from mating surface of cylinder block.
- Apply a continuous bead of liquid gasket to mating surface of oil pan.
  - Use Genuine Liquid Gasket or equivalent.
  - Apply to groove on mating surface.
  - Allow 7 mm (0.28 in) clearance around bolt hole.
- Be sure liquid gasket diameter is 3.5 to 4.5 mm (0.138 to 0.177 in).
- Attaching should be done within 5 minutes after coating.
- Install oil pan.
  - Tighten oil pan bolts in numerical order.
    - Ⓜ: 5.9 - 6.9 N·m (0.6 - 0.7 kg-m, 52 - 61 in-lb)
  - Wait at least 30 minutes before refilling engine oil.
- Install parts in reverse order of removal.

# TIMING CHAIN

KA24DE

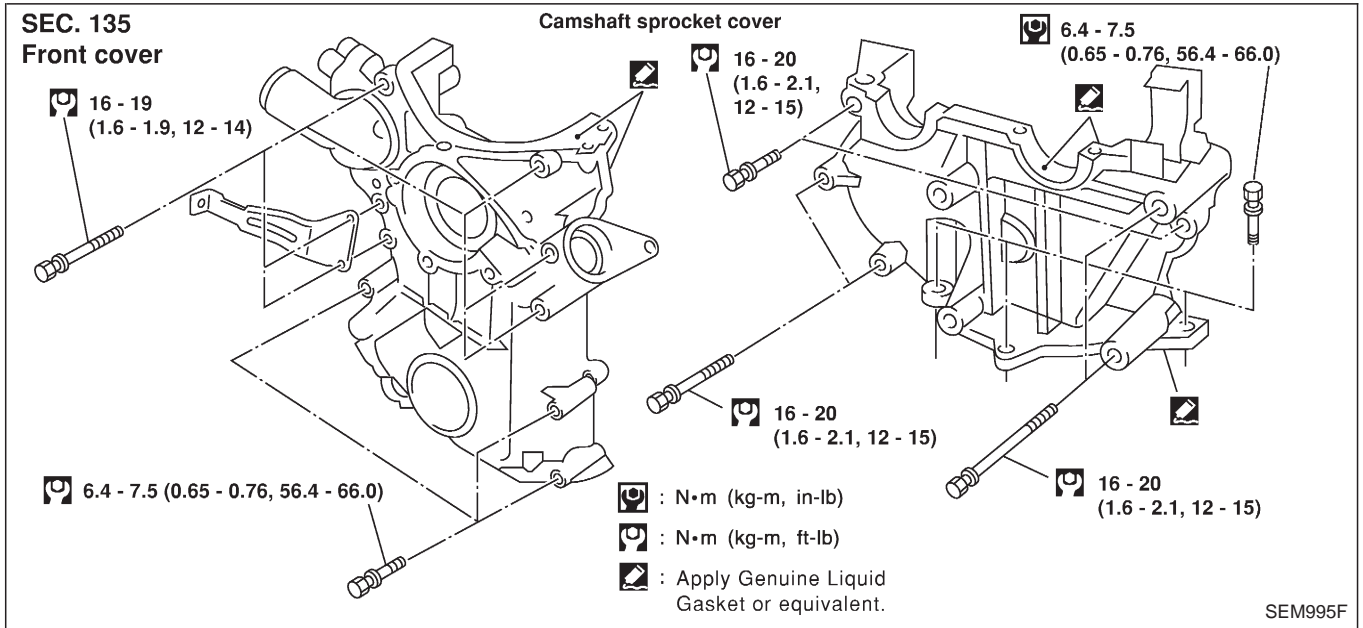
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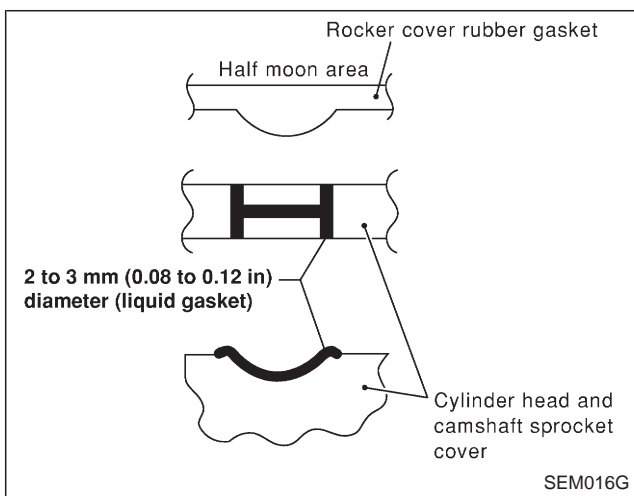
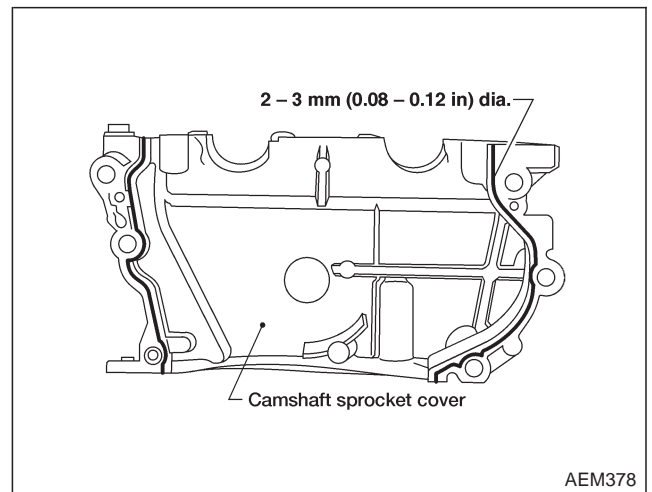
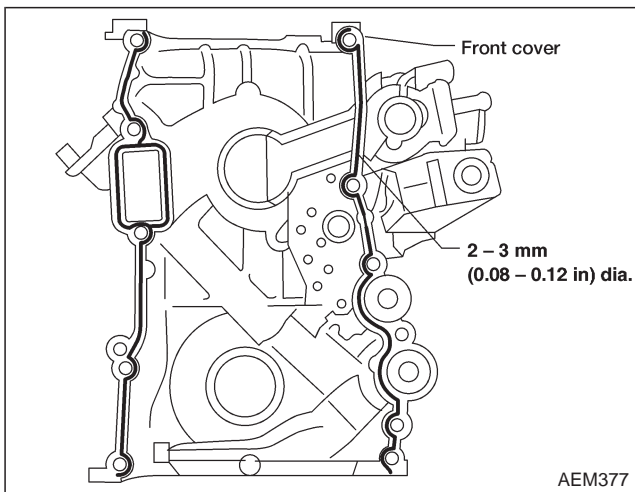
- ① Upper timing chain tensioner
- ② Cam sprocket
- ③ Upper timing chain
- ④ Water pump
- ⑤ Water pump pulley
- ⑥ Crankshaft pulley

- ⑦ Front oil seal
- ⑧ Front cover
- ⑨ Camshaft sprocket cover
- ⑩ Oil slinger
- ⑪ Oil pump drive gear
- ⑫ Lower timing chain

- ⑬ Crankshaft sprocket
- ⑭ Chain guide
- ⑮ Idler sprocket
- ⑯ Chain tension arm
- ⑰ Lower timing chain tensioner



## Liquid gasket application places



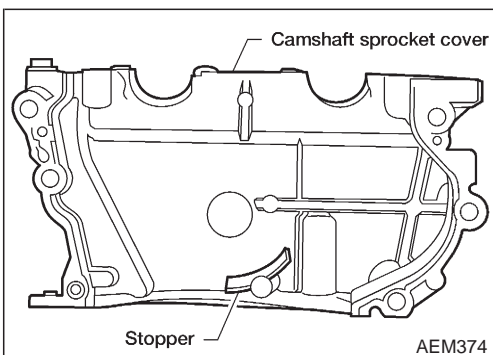
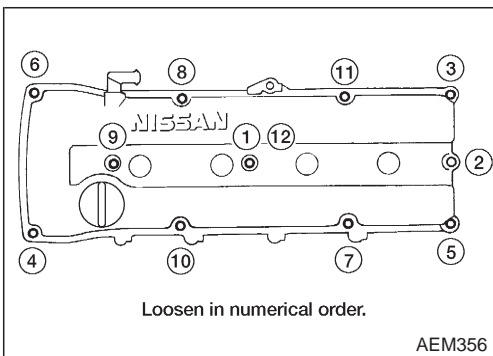
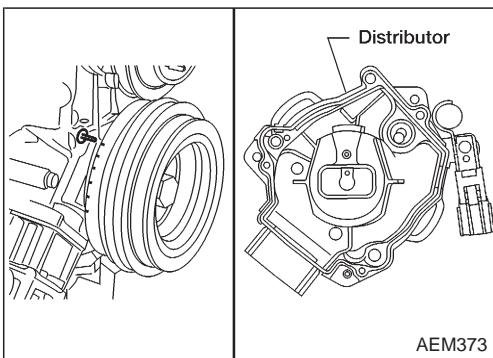
## Removal

### CAUTION:

- After removing the timing chain, do not turn crankshaft and camshaft separately, or valves will strike piston heads.
- When installing chain tensioners or other sliding parts, lubricate contacting surfaces with new engine oil.
- Apply new engine oil to bolt threads and seat surfaces when installing camshaft sprockets and crankshaft pulley.
- Do not spill engine coolant on drive belts.

### UPPER TIMING CHAIN

1. Remove air duct assembly.
2. Remove vacuum hoses, electrical harness connectors and harness clamps.
3. Remove power steering drive belt.
4. Remove power steering pump and position it to one side.
5. Remove power steering pump bracket.
6. Remove idler pulley and bracket as well.
7. Remove ignition wires and spark plugs.
8. Set No. 1 piston at TDC on its compression stroke.

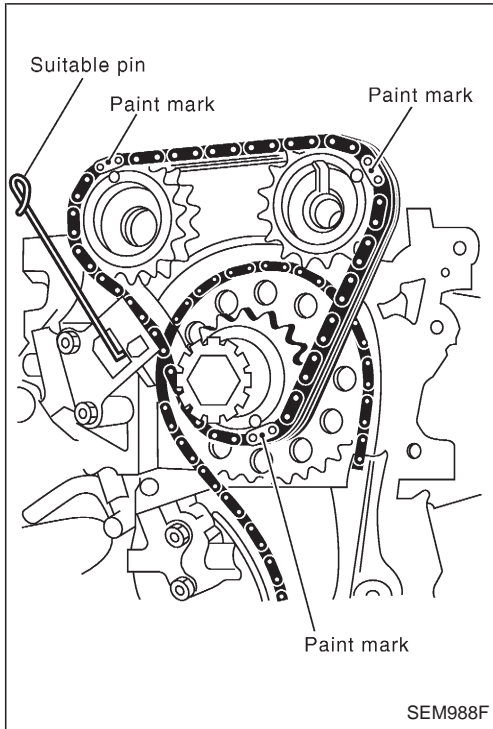


9. Remove rocker cover.  
**Remove in numerical order as shown.**

10. Remove camshaft sprocket cover.

## TIMING CHAIN

### Removal (Cont'd)

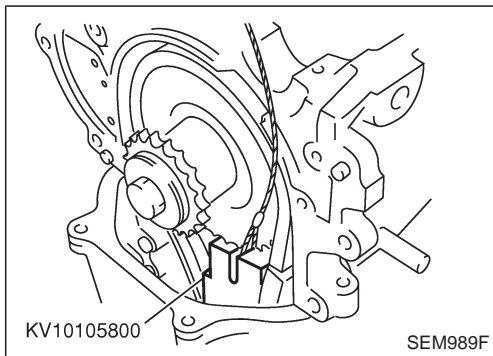


11. Remove upper chain tensioner.

(Push in piston and insert a suitable pin into the pin hole.)

12. Wipe off the links of the timing chain next to the timing marks on the sprockets. Put paint marks on the timing chain, matching them with the timing marks on the cam sprockets and idler sprocket.

13. Remove cam sprocket bolts, cam sprockets and upper timing chain.



### IDLER SPROCKET

1. Remove upper timing chain.

Refer to "Removal", "Upper Timing Chain", EM-2015.

2. Support lower timing chain by using a suitable tool to avoid chain tensioner spring from coming out.

● **This step is only to be applied when the lower cover is not being removed.**

3. Remove idler sprocket.

### LOWER TIMING CHAIN

1. Drain coolant by removing the cylinder block drain plug and opening the radiator drain cock. Refer to MA section of the Service Manual.

2. Drain engine oil from drain plug of oil pan.

3. Remove the following parts.

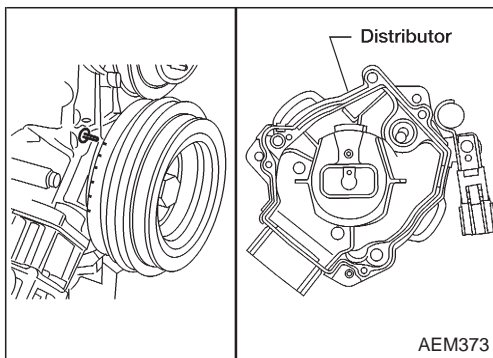
- Alternator drive belt
- A/C compressor drive belt
- Cooling fan with coupling
- Radiator shroud

4. Remove A/C compressor and position it to the side. Remove the idler pulley and bracket as well.

5. Set No. 1 piston to TDC on its compression stroke.

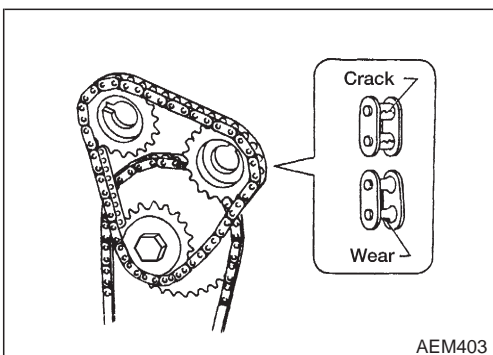
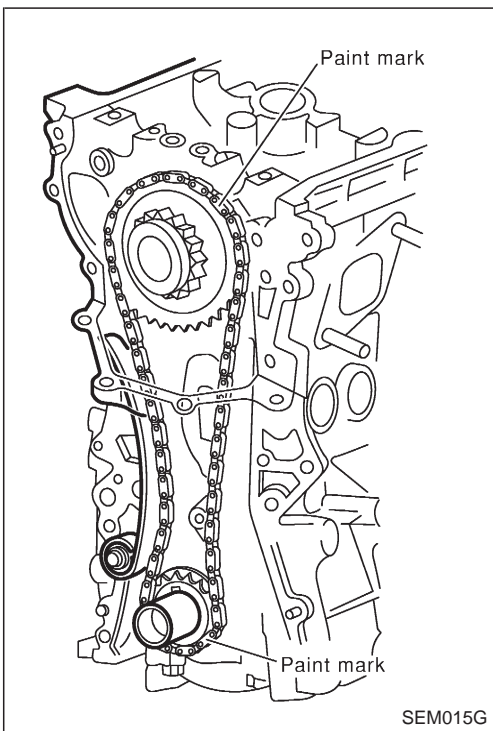
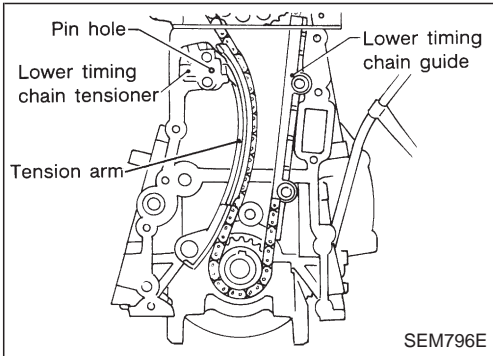
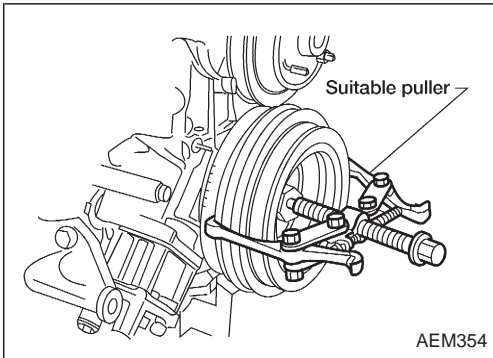
6. Remove distributor.

7. Remove the crankshaft pulley.



## TIMING CHAIN

### Removal (Cont'd)



8. Remove oil pan.
  - Refer to "Removal" in "OIL PAN" (EM-2011).
9. Remove the oil pump and distributor drive shaft, then the oil pickup strainer.
10. Remove the front cover.

#### CAUTION:

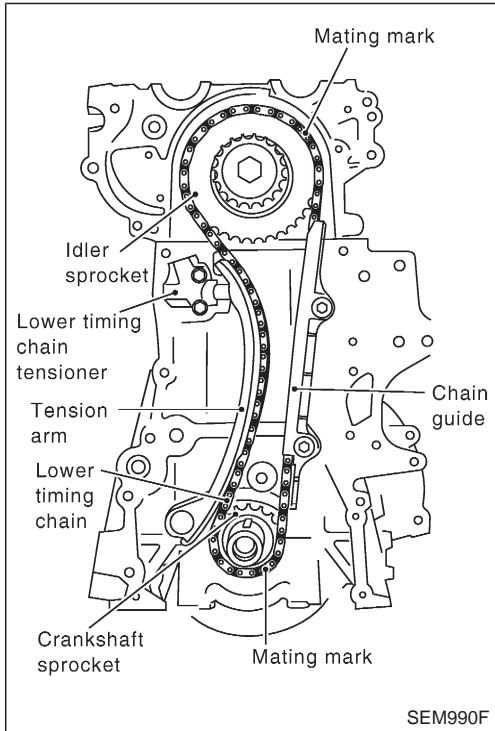
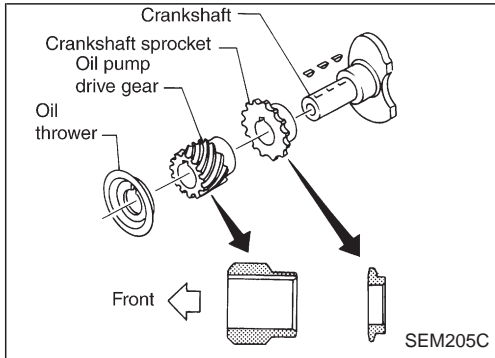
Be careful not to tear or damage the cylinder head gasket.

11. Remove the following parts.
  - Lower timing chain tensioner (Push piston and insert a suitable pin into pin hole.)
  - Chain tension arm
  - Lower timing chain guide
12. Remove the upper timing chain and idler sprocket.
  - Refer to "UPPER TIMING CHAIN" (EM-2015) and "IDLER SPROCKET" (EM-2016) in "Removal".

13. Wipe off the links of the timing chain next to the timing marks on the sprockets. Put paint marks on the timing chain, matching them with the timing marks on the crankshaft sprocket and idler sprocket.
14. Remove the lower timing chain and sprocket.

### Inspection

Check for cracks and excessive wear at roller links. Replace chain if necessary.



## Installation

### LOWER TIMING CHAIN

1. Install crankshaft sprocket, oil pump drive gear and oil thrower.
  - **Make sure that mating marks of crankshaft sprocket face front of engine.**
2. Install the idler sprocket and lower timing chain using the mating marks and the paint marks made during the removal process.

#### CAUTION:

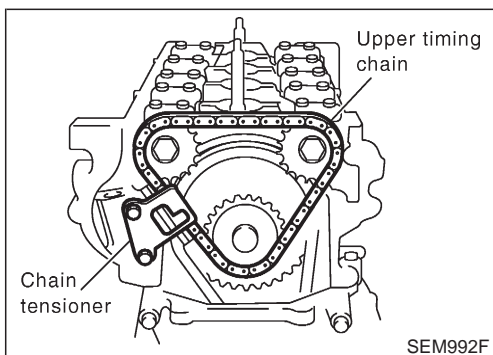
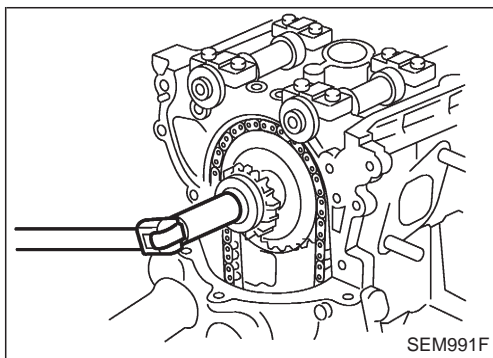
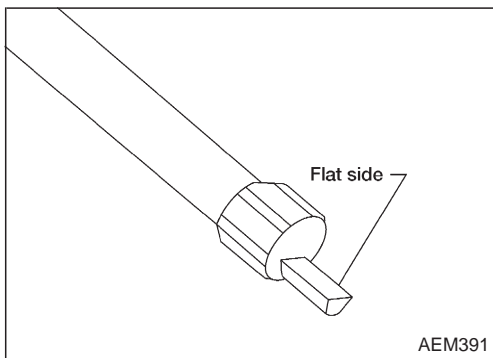
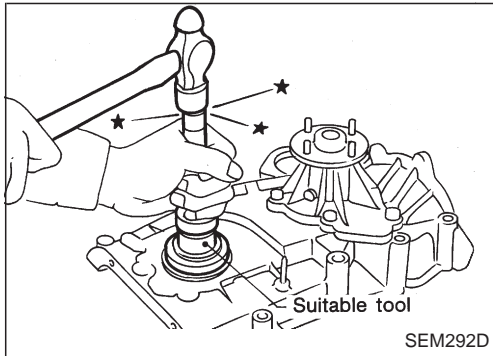
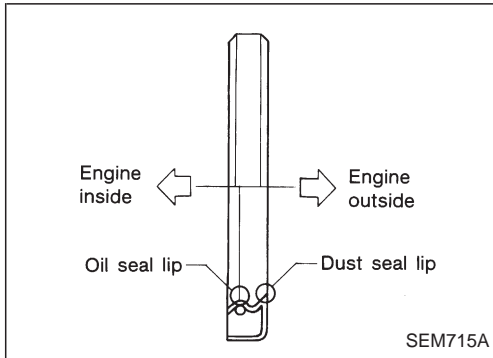
**Be careful not to tear or damage the cylinder head gasket.**

3. Install chain guide and chain tension arm.
4. Install lower chain tensioner and remove the pin securing the piston into the tensioner body.



## TIMING CHAIN

### Installation (Cont'd)



5. Install front cover.

- Using a scraper or other suitable tool remove all traces of liquid gasket from the cylinder block and front cover mating surfaces.
  - Install new front oil seal in front cover.
  - **Apply a continuous bead of liquid gasket to front cover (Refer to EM-2014).**
  - **Use Genuine Liquid Gasket or equivalent.**
  - **Be sure to install new front oil seal. Refer to EM-2021.**
  - Also place Liquid Gasket on the head gasket surface.
  - Install the front cover to the engine.
6. Install oil strainer and oil pan. Refer to "Installation" in "OIL PAN".

7. Install the oil pump and distributor drive shaft.

- **Make sure the flat side of the distributor drive shaft is facing the engine. Failure to do so will result in the distributor being out of time.**
8. Install the following parts:
- Crankshaft pulley
  - A/C compressor and idler pulley bracket

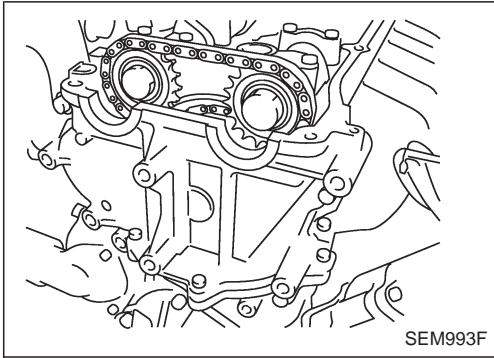
### IDLER SPROCKET

1. Install lower timing chain.
  - **Refer to "LOWER TIMING CHAIN" (EM-2018) in "Installation".**
2. Install idler sprocket and bolt.

### UPPER TIMING CHAIN

1. Install lower timing chain and idler sprocket.
  - **Refer to "LOWER TIMING CHAIN" (EM-2018) and "IDLER SPROCKET" (EM-2019) in "Installation".**
2. Install upper timing chain and sprockets, the painted reference marks made during removal.
3. Install chain tensioner. Remove the pin holding the tensioner piston in the bore of the tensioner.

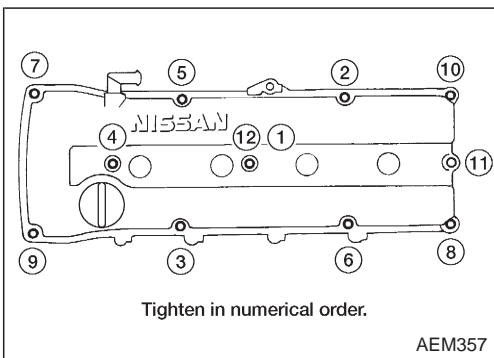


**Installation (Cont'd)**

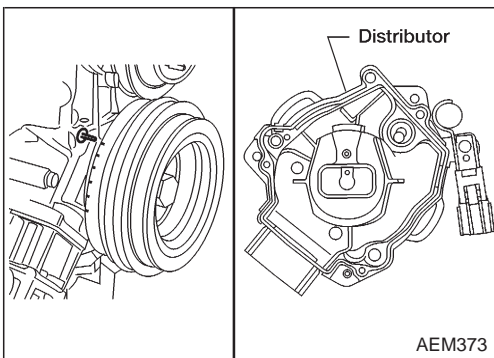
4. Install camshaft sprocket cover.
  - Use a scraper to remove all traces of liquid gasket from mating surfaces of the engine block and camshaft sprocket cover.
  - Apply a continuous bead of Liquid Gasket to the cover. Refer to EM-2014.
  - Also place Liquid Gasket on the head gasket surface.
  - **Use Genuine Liquid Gasket or equivalent.**

**CAUTION:**

- **Be careful not to tear or damage the cylinder head gasket.**
  - **Be careful upper timing chain does not slip or jump when installing camshaft sprocket cover.**
5. Install rocker cover gasket.
    - Apply liquid gasket to cylinder head and camshaft sprocket cover. Refer to EM-2014.



6. Install rocker cover. Tighten bolts in numerical order.
  - **8 - 11 N·m (0.8 - 1.1 kg-m, 69 - 95 in-lb)**



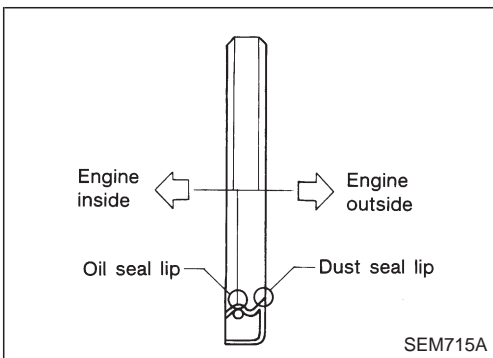
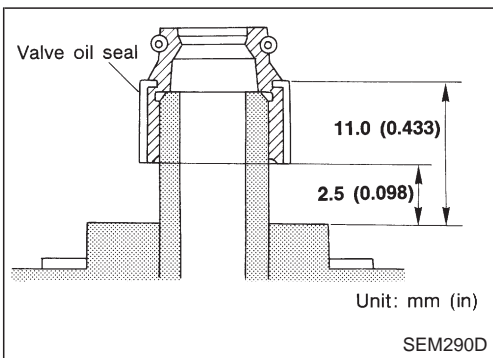
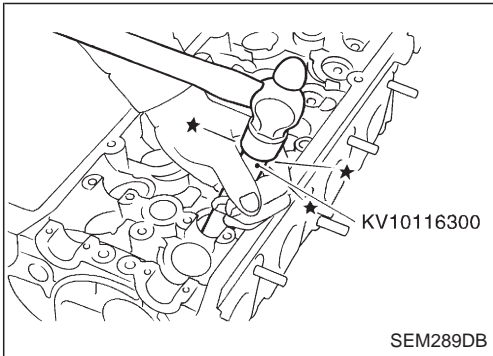
7. Install distributor, aligning as shown.
8. Install vacuum hoses, electrical harnesses connectors and harness clamps.
9. Install in reverse order of removal.

## VALVE OIL SEAL

1. Remove rocker cover.
2. Remove camshaft. Refer to "TIMING CHAIN" (EM-2013).
3. Remove valve spring and valve oil seal with Tool or a suitable tool.

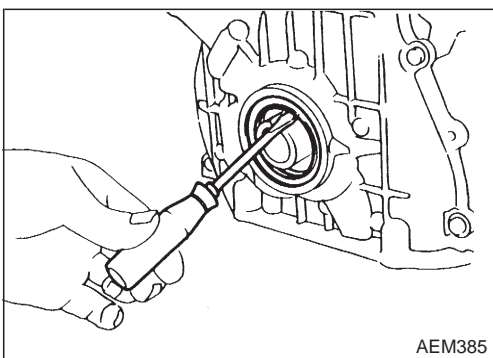
**Piston concerned should be set at TDC to prevent valve from falling.**

4. Apply engine oil to new valve oil seal and install it with Tool.



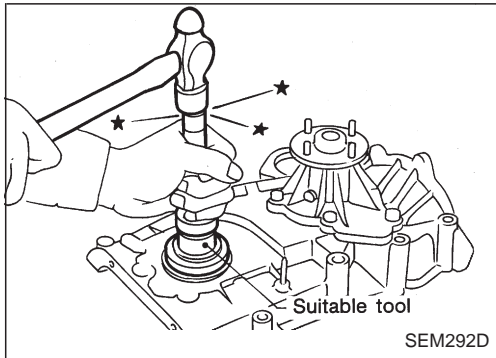
## OIL SEAL INSTALLING DIRECTION

- Install new oil seal in the direction shown.

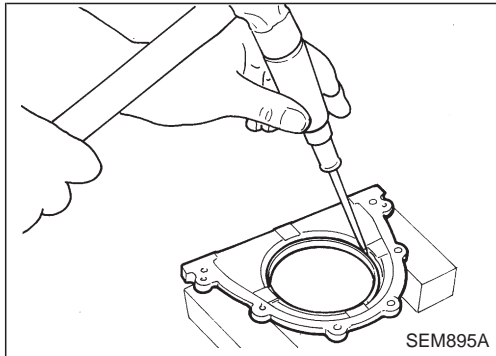


## FRONT OIL SEAL

1. Remove radiator shroud and crankshaft pulley.
  2. Remove front oil seal.
- **Be careful not to scratch front cover.**

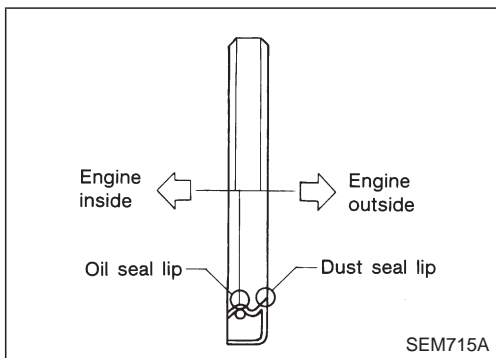


3. Apply engine oil to new oil seal and install it using a suitable tool.

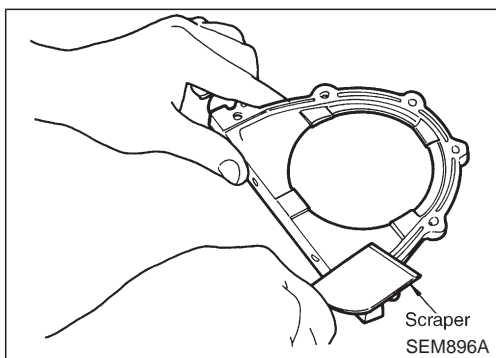
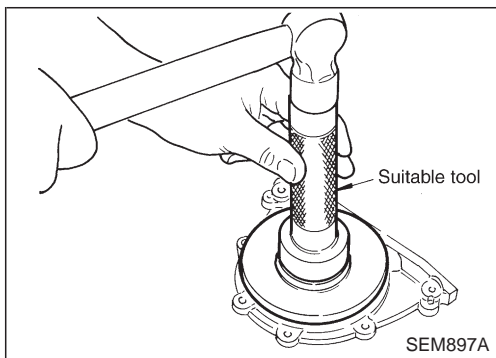


## REAR OIL SEAL

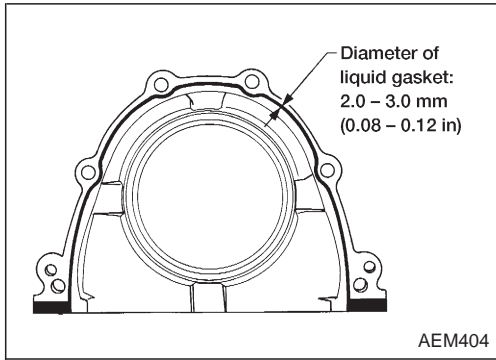
1. Remove flywheel or drive plate.
2. Remove rear oil seal retainer.
3. Remove rear oil seal from retainer.
- **Be careful not to scratch rear oil seal retainer.**



4. Apply engine oil to new oil seal and install it using suitable tool.
- **Install new oil seal in the direction shown.**



5. Install rear oil seal retainer.
  - a. Before installing rear oil seal retainer, remove all traces of liquid gasket from mating surface using a scraper.
  - **Also remove traces of liquid gasket from mating surface of cylinder block.**

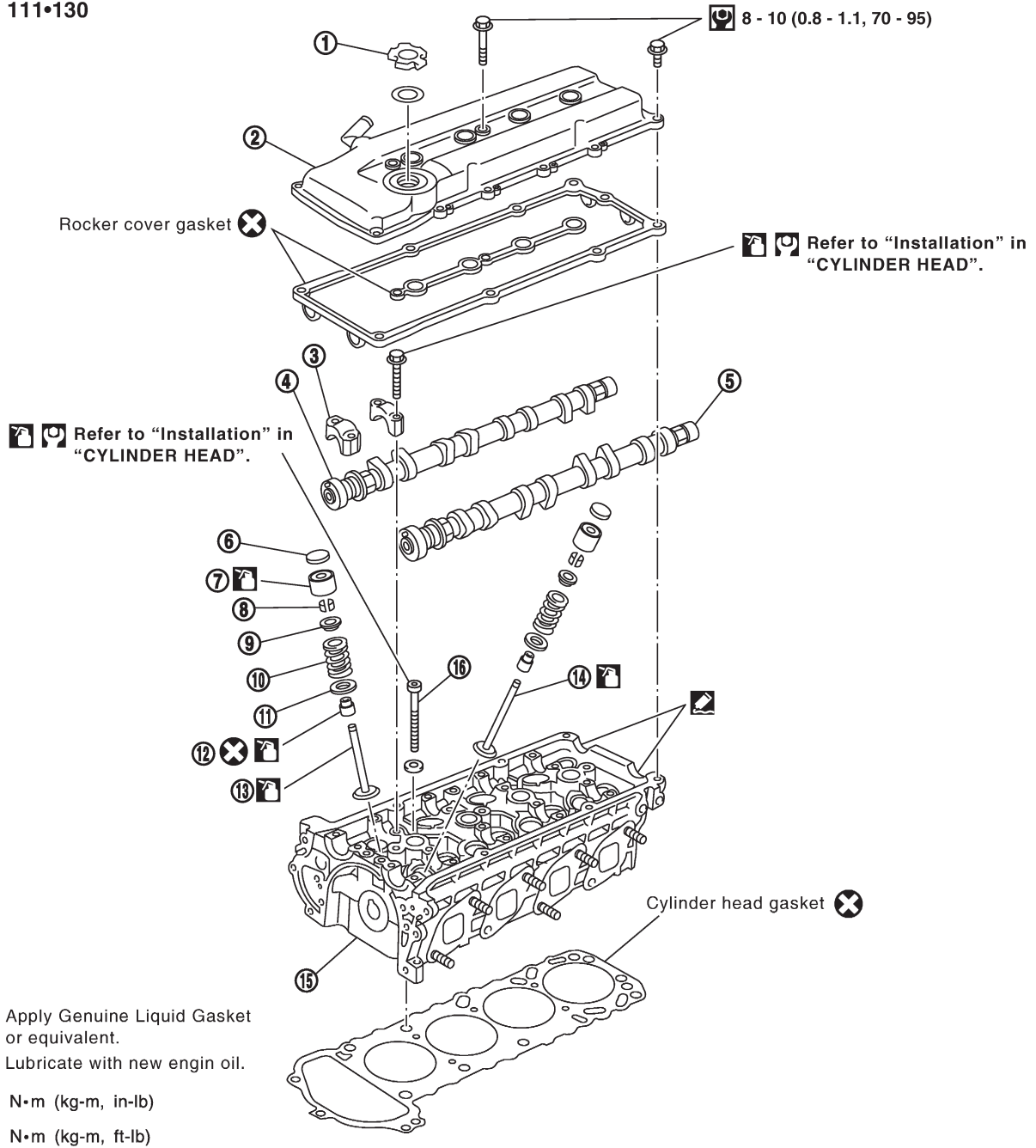


- b. Apply a continuous bead of liquid gasket to mating surface of rear oil seal retainer.
- **Use Genuine Liquid Gasket or equivalent.**
  - **Apply around inner side of bolt holes.**

# CYLINDER HEAD

KA24DE

SEC. 111•130



SEM996F

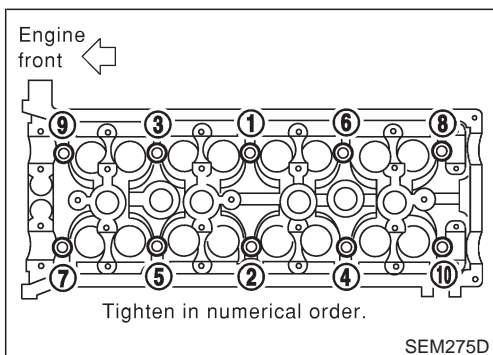
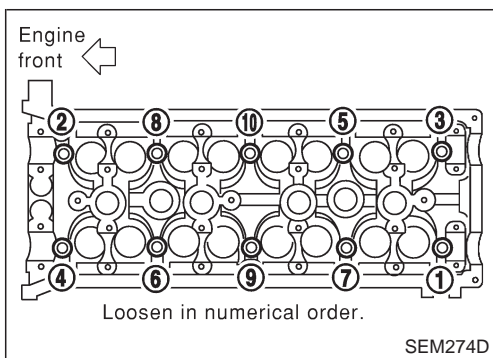
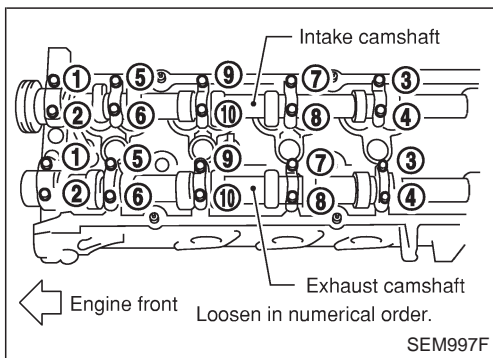
- |                    |                   |                      |
|--------------------|-------------------|----------------------|
| ① Oil filler cap   | ⑦ Valve lifter    | ⑫ Valve oil seal     |
| ② Rocker cover     | ⑧ Valve cotter    | ⑬ Intake valve       |
| ③ Camshaft bracket | ⑨ Spring retainer | ⑭ Exhaust valve      |
| ④ Intake camshaft  | ⑩ Valve spring    | ⑮ Cylinder head      |
| ⑤ Exhaust camshaft | ⑪ Spring seat     | ⑯ Cylinder head bolt |
| ⑥ Shim             |                   |                      |

**CAUTION:**

- When installing camshafts, chain tensioners, oil seals, or other sliding parts, lubricate contacting surfaces with new engine oil.
- Apply new engine oil to threads and seat surfaces when installing cylinder head, camshaft sprocket, crankshaft pulley, and camshaft bracket.
- Attach tags to valve lifters so as not to mix them up.
- Before removing camshaft and idler sprockets, apply paint marks to them for retiming.

**Removal**

1. Drain coolant from radiator and cylinder block. Refer to MA section (“Changing Engine Coolant”, “ENGINE MAINTENANCE”).
2. Remove upper timing chain and idler sprocket.
  - Refer to “UPPER TIMING CHAIN” (EM-2015) and “IDLER SPROCKET” (EM-2016), “Removal”, “TIMING CHAIN”.
  - For retiming during cylinder head removal/installation, apply paint marks to camshaft sprockets, upper timing chain, lower timing chain and idler sprocket.
3. Remove camshaft brackets and camshafts.
  - Mark the original positions of these parts for reassembly.

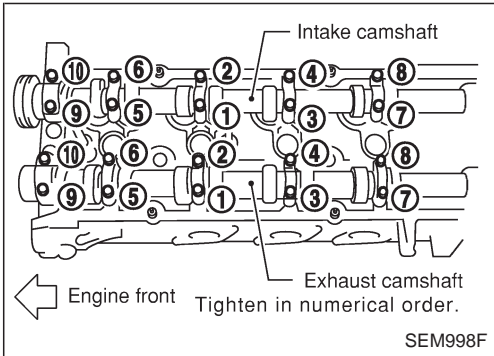
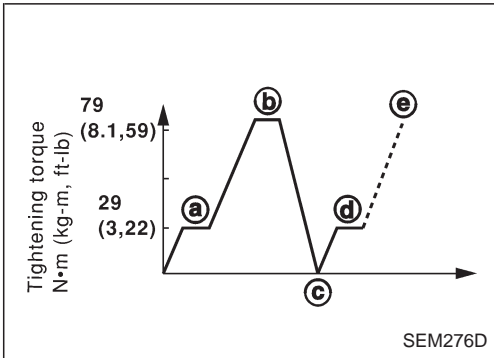


4. Remove cylinder head bolts in numerical order.
  - Removing bolts in incorrect order could result in a warped or cracked cylinder head.
  - Loosen cylinder head bolts in two or three steps.
5. Remove cylinder head and cylinder head gasket.

**Installation**

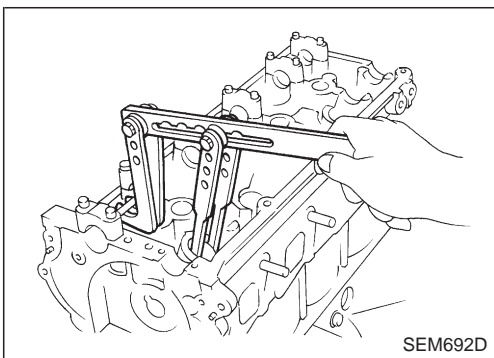
1. Tighten cylinder head bolts in numerical order using the following procedure:
  - a. Tighten all bolts to 29 N·m (3.0 kg-m, 22 ft-lb).
  - b. Tighten all bolts to 79 N·m (8.1 kg-m, 59 ft-lb).

**Installation (Cont'd)**



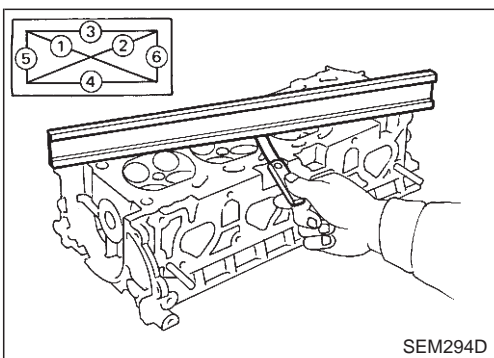
- c. Loosen all bolts completely.
- d. Tighten all bolts to 25 to 34 N·m (2.5 to 3.5 kg-m, 18 to 25 ft-lb).
- e. Turn all bolts 86 to 91° clockwise. If angle wrench is not available, mark all cylinder head bolts on the side facing engine front. Then, turn each cylinder head bolt 86 to 91° clockwise.

- 2. Install camshafts and camshaft brackets in the order shown using the following procedure:
  - a. Set camshafts and camshaft brackets.
  - b. Tighten all bolts to 2 N·m (0.2 kg-m, 17 in-lb).
  - c. Tighten all bolts to 9.1 to 11.7 N·m (0.92 to 1.2 kg-m, 80 to 104 in-lb).
    - Apply new engine oil to bolt threads and seat surfaces.
  - 3. Install upper timing chain and idler sprocket.
    - Refer to "UPPER TIMING CHAIN" (EM-2019) and "IDLER SPROCKET" (EM-2019), "Installation", "TIMING CHAIN".
  - 4. Refill engine coolant. Refer to MA section ("Changing Engine Coolant", "ENGINE MAINTENANCE").



**Disassembly**

- 1. Remove intake manifold and exhaust manifold. Refer to "OUTER COMPONENT PARTS" (EM-2007).
- 2. Remove valve components.
- 3. Remove valve oil seal with a suitable tool.



**Inspection**

**CYLINDER HEAD DISTORTION**

Clean surface of cylinder head.  
Use a reliable straightedge and feeler gauge to check the flatness of cylinder head surface.  
Check along six positions shown in the figure.

**Head surface flatness:**

**Standard** Less than 0.03 mm (0.0012 in)  
**Limit** 0.1 mm (0.004 in)

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

**Resurfacing limit:**

**EM-2026**

**Inspection (Cont'd)**

The limit of cylinder head resurfacing is determined by the cylinder block resurfacing.

Amount of cylinder head resurfacing is "A".

Amount of cylinder block resurfacing is "B".

The maximum limit:

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

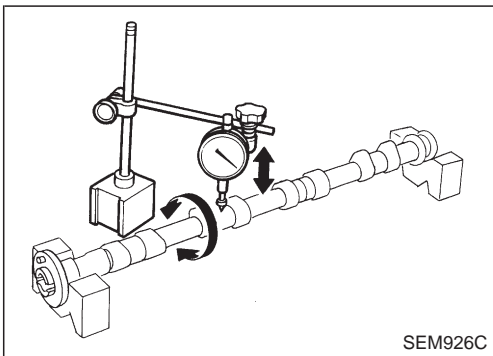
After resurfacing cylinder head, check that camshaft rotates freely by hand. If resistance is felt, cylinder head must be replaced.

**Nominal cylinder head height:**

$$126.3 - 126.5 \text{ mm (4.972 - 4.980 in)}$$

**CAMSHAFT VISUAL CHECK**

Check camshaft for scratches, seizure and wear.

**CAMSHAFT RUNOUT**

1. Measure camshaft runout at the center journal.

**Runout (Total indicator reading):**

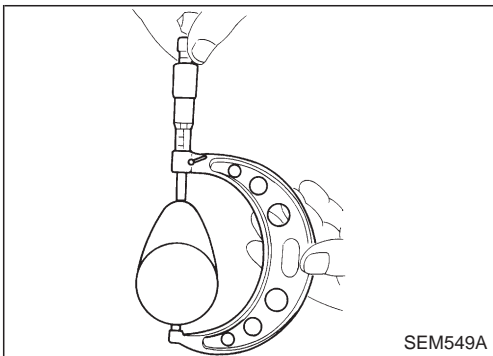
**Standard**

**Less than 0.02 mm (0.0008 in)**

**Limit**

**0.04 mm (0.0016 in)**

2. If it exceeds the limit, replace camshaft.

**CAMSHAFT CAM HEIGHT**

1. Measure camshaft cam height.

**Standard cam height:**

**Intake 42.505 - 42.695 mm (1.673 - 1.681 in)**

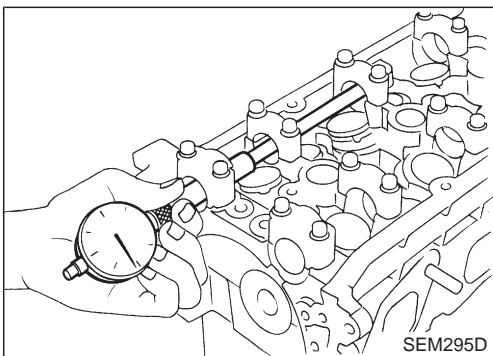
**Exhaust 40.905 - 41.095 mm (1.610 - 1.618 in)**

**Cam height wear limit:**

**Intake & Exhaust**

**0.2 mm (0.008 in)**

2. If wear is beyond the limit, replace camshaft.

**CAMSHAFT JOURNAL CLEARANCE**

1. Install camshaft bracket and tighten bolts to the specified torque.
2. Measure inner diameter of camshaft bearing.

**Standard inner diameter:**

**#1 to #5 journals**

**28.000 - 28.025 mm (1.1024 - 1.1033 in)**



**Inspection (Cont'd)**

3. Measure outer diameter of camshaft journal.

**Standard outer diameter:**

**#1 to #5 journals**

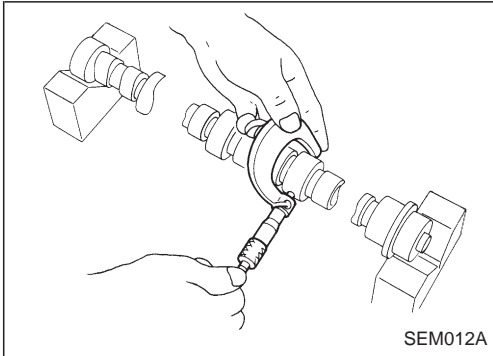
**27.935 - 27.955 mm (1.0998 - 1.1006 in)**

4. If clearance exceeds the limit, replace camshaft and/or cylinder head.

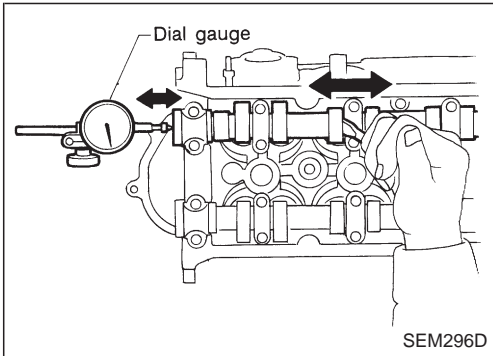
**Camshaft journal clearance:**

**Standard 0.045 - 0.090 mm (0.0018 - 0.0035 in)**

**Limit 0.12 mm (0.0047 in)**



SEM012A



SEM296D

**CAMSHAFT END PLAY**

1. Install camshaft in cylinder head.

2. Measure camshaft end play.

**Camshaft end play:**

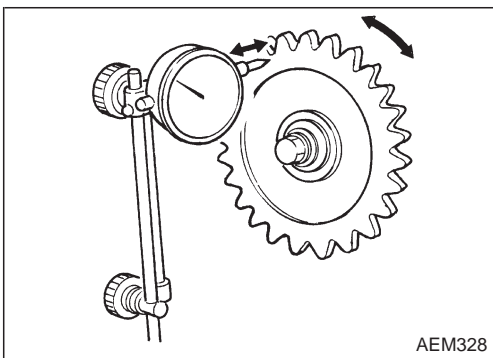
**Standard**

**0.070 - 0.148 mm (0.0028 - 0.0058 in)**

**Limit**

**0.2 mm (0.008 in)**

3. If end play exceeds the limit, replace camshaft and remeasure camshaft end play.
4. If end play still exceeds the limit after replacing camshaft, replace cylinder head.



AEM328

**CAMSHAFT SPROCKET RUNOUT**

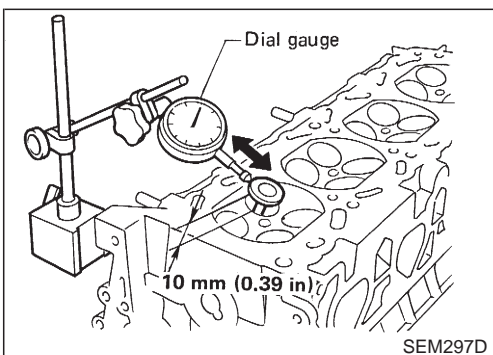
1. Install sprocket on camshaft.

2. Measure camshaft sprocket runout.

**Runout (Total indicator reading):**

**Limit 0.15 mm (0.0059 in)**

3. If it exceeds the limit, replace camshaft sprocket.



SEM297D

**VALVE GUIDE CLEARANCE**

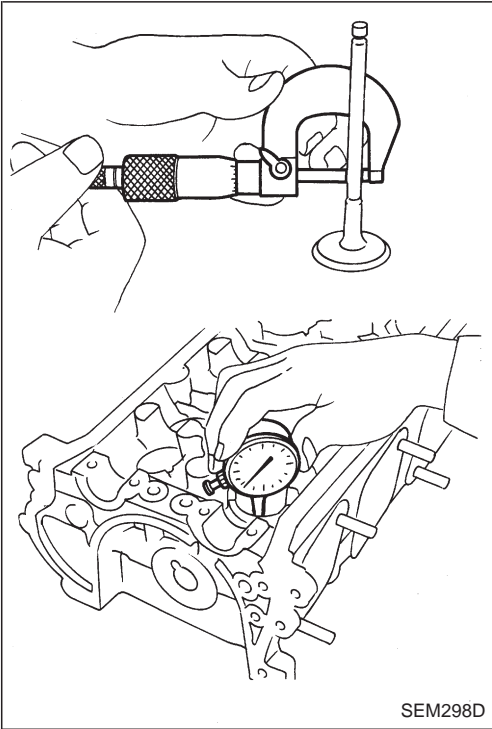
1. Measure valve deflection as shown in figure. (Valve and valve guide mostly wear in this direction.)

**Valve deflection limit (Dial gauge reading):**

**Intake & Exhaust**

**0.2 mm (0.008 in)**

## Inspection (Cont'd)



SEM298D

2. If it exceeds the limit, check valve to valve guide clearance.
  - a. Measure valve stem diameter and valve guide inner diameter.
  - b. Check that clearance is within specification.

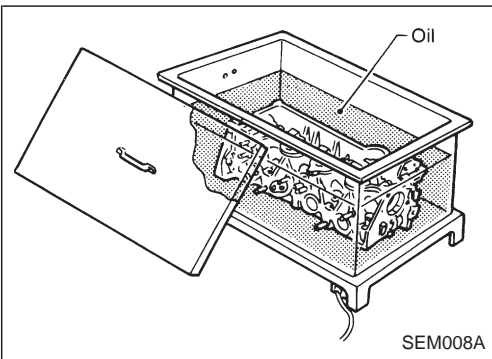
**Valve to valve guide clearance = Valve guide inner diameter - Valve stem diameter:**

Unit: mm (in)

	Standard	Limit
Intake	0.020 - 0.053 (0.0008 - 0.0021)	0.08 (0.0031)
Exhaust	0.040 - 0.073 (0.0016 - 0.0029)	0.1 (0.004)

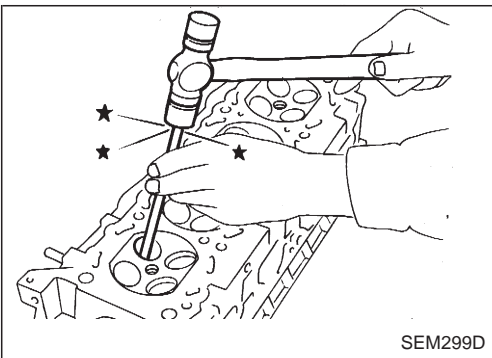
- c. If it exceeds the limit, replace valve and remeasure clearance.
  - If clearance still exceeds the limit after replacing valve, replace the valve guide.

## VALVE GUIDE REPLACEMENT



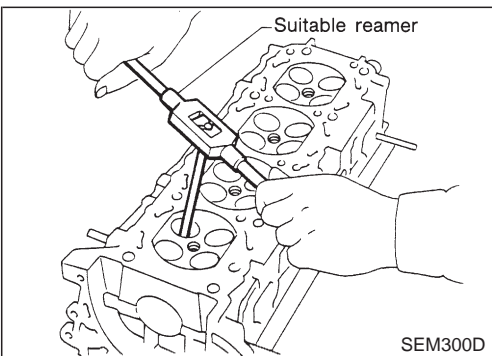
SEM008A

1. To remove valve guide, heat cylinder head to 120 to 140°C (248 to 284°F) by soaking in heated oil.



SEM299D

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



SEM300D

3. Ream cylinder head valve guide hole.

**Valve guide hole diameter**

**(for service parts):**

**Intake & Exhaust**

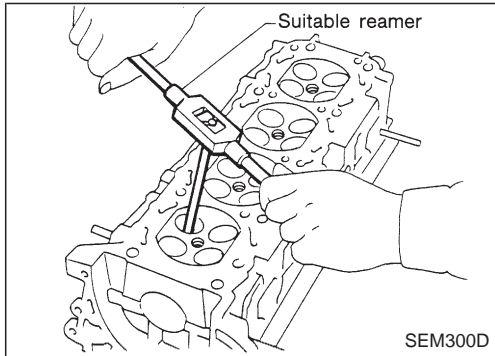
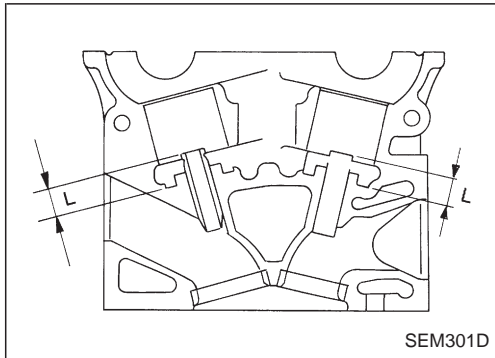
**11.175 - 11.196 mm (0.4400 - 0.4408 in)**

**Inspection (Cont'd)**

- Heat cylinder head to 120 to 140°C (248 to 284°F) and press service valve guide onto cylinder head.

**Projection "L":**

**13.3 - 13.9 mm (0.524 - 0.547 in)**

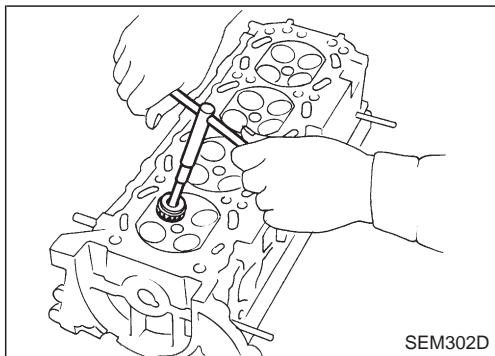


- Ream valve guide.

**Finished size:**

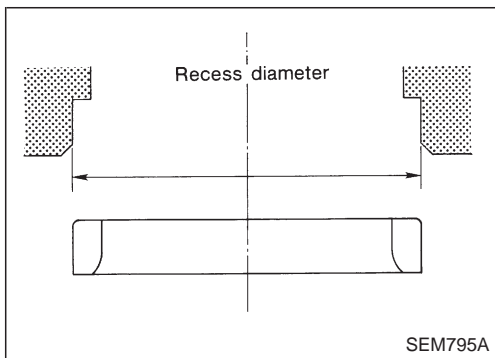
**Intake & Exhaust**

**7.000 - 7.018 mm (0.2756 - 0.2763 in)**

**VALVE SEATS**

Check valve seats for pitting at contact surface. Resurface or replace if excessively worn.

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

**REPLACING VALVE SEAT FOR SERVICE PARTS**

- Bore out old seat until it collapses. Boring should not continue beyond the bottom face of the seat recess in cylinder head. Set the machine depth stop to ensure this.
- Ream cylinder head recess.

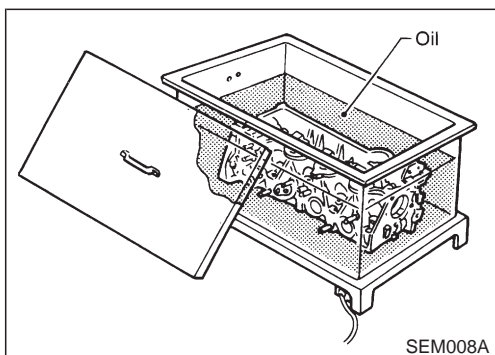
**Reaming bore for service valve seat**

**Oversize [0.5 mm (0.020 in)]:**

**Intake 38.000 - 38.016 mm (1.4961 - 1.4967 in)**

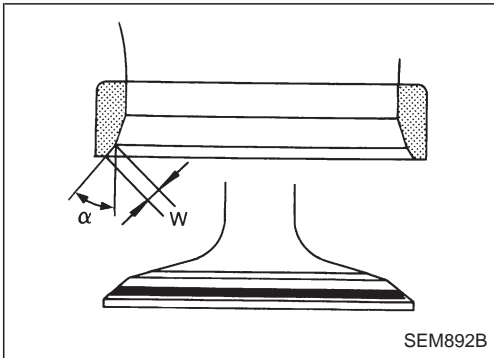
**Exhaust 32.700 - 32.716 mm (1.2874 - 1.2880 in)**

**Use the valve guide center for reaming to ensure valve seat will have the correct fit.**



- Heat cylinder head to 120 to 140°C (248 to 284°F).
- Press fit valve seat until it seats on the bottom.

## Inspection (Cont'd)



5. Cut or grind valve seat using suitable tool to the specified dimensions as shown in SDS.
6. After cutting, lap valve seat with abrasive compound.
7. Check valve seating condition.

**Seat face angle " $\alpha$ ":**

**45°15' - 45°45' deg.**

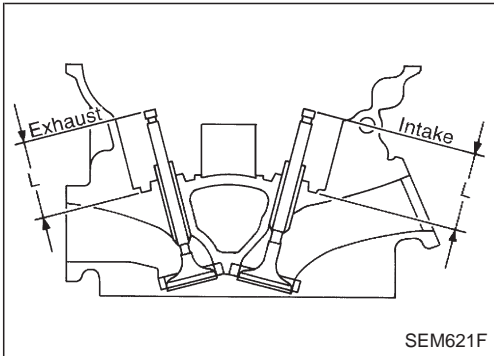
**Contacting width " $W$ ":**

**Intake**

**1.48 - 1.63 mm (0.0583 - 0.0642 in)**

**Exhaust**

**1.8 - 2.0 mm (0.071 - 0.079 in)**

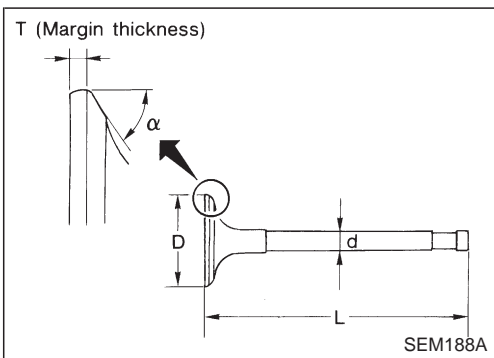


8. Use a depth gauge to measure the distance between the mounting surface of the cylinder head spring seat and the valve stem end. If the distance is shorter than specified, repeat step 5 above to adjust it. If it is longer, replace the valve seat with a new one.

**Valve seat resurface limit " $L$ ":**

**Intake 42.02 - 42.52 mm (1.6543 - 1.6740 in)**

**Exhaust 42.03 - 42.53 mm (1.6547 - 1.6744 in)**

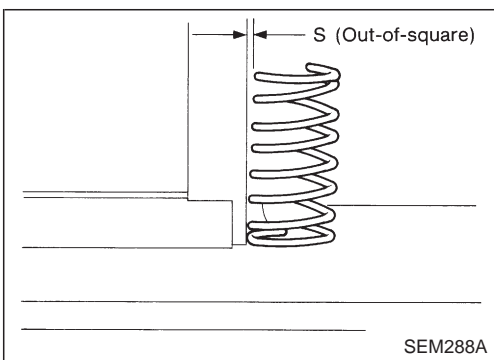


## VALVE DIMENSIONS

Check dimensions of each valve. For dimensions, refer to SDS (EM-2049).

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

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



## VALVE SPRING

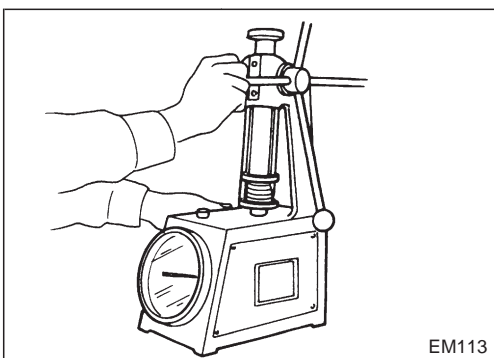
### Squareness

1. Measure dimension " $S$ ".

**Out-of-square " $S$ ":**

**Less than 2.2 mm (0.087 in)**

2. If it exceeds the limit, replace spring.



### Pressure

Check valve spring pressure at specified spring height.

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

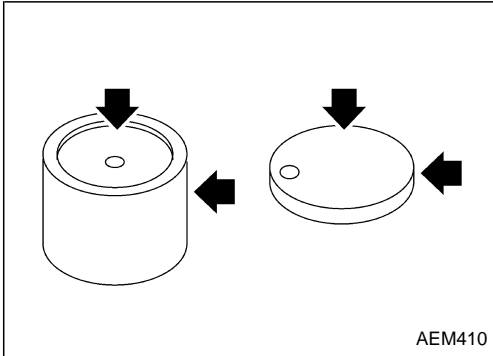
**Standard**

**418.0 (42.6, 93.9) at 29.17 (1.1484)**

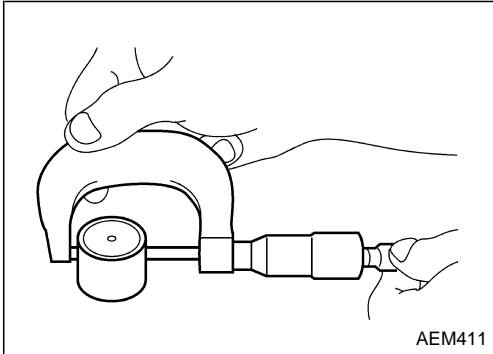
**Limit**

**393.0 (40.1, 88.4) at 29.17 (1.1484)**

If it exceeds the limit, replace spring.

**Inspection (Cont'd)****VALVE LIFTER AND VALVE SHIM**

1. Visually check contact and sliding surfaces for wear and scratches.



2. Check diameter of valve lifter and valve lifter guide bore.

**Valve lifter outer diameter:**

**33.960 - 33.975 mm (1.3370 - 1.3376 in)**

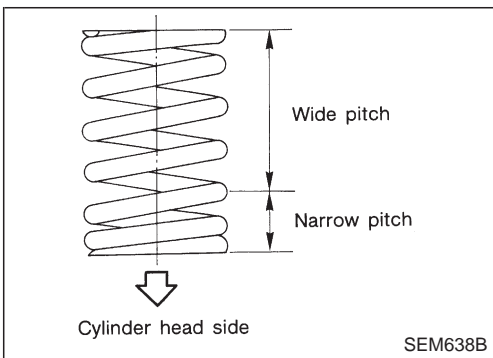
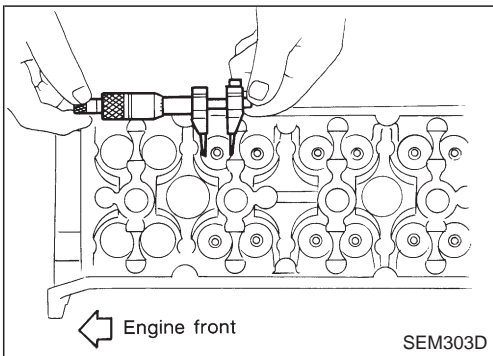
**Lifter guide bore diameter:**

**34.000 - 34.021 mm (1.3386 - 1.3394 in)**

**Valve lifter to valve lifter guide clearance:**

**0.025 - 0.061 mm (0.0010 - 0.0024 in)**

If it exceeds the standard diameter or clearance, replace valve lifter or cylinder head.

**Assembly**

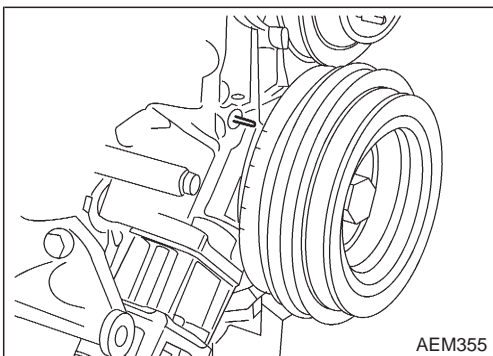
1. Install valve component parts.
  - Always use new valve oil seal. Refer to "OIL SEAL REPLACEMENT" (EM-2021).
  - Before installing valve oil seal, install valve spring seat.
  - Install outer valve spring (uneven pitch type) with its narrow pitch side toward cylinder head side.
  - After installing valve component parts, tap valve stem tip with plastic hammer to assure a proper fit.

**Valve Clearance****CHECKING**

**Check valve clearance while engine is warm but not running.**

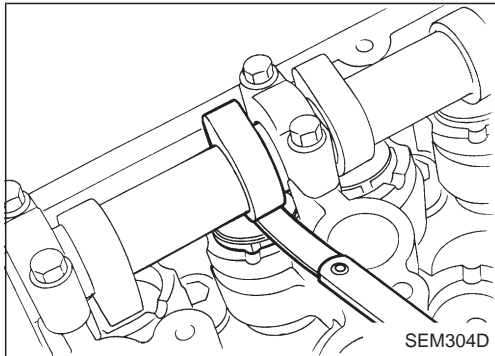
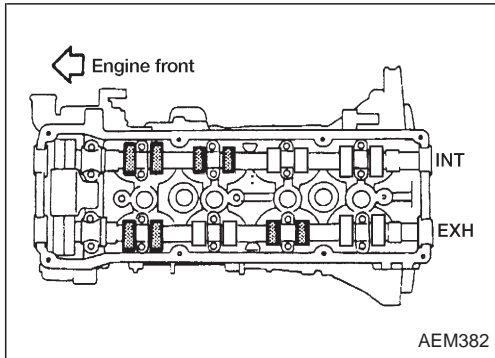
1. Remove rocker cover and all spark plugs.
2. Set No. 1 cylinder at TDC on its compression stroke.
  - Align pointer with TDC mark on crankshaft pulley.
  - Check that valve lifters on No. 1 cylinder are loose and valve lifters on No. 4 are tight.

If not, turn crankshaft one revolution (360°) and align as above.

**EM-2032**

## Valve Clearance (Cont'd)

3. Check only those valves shown in the figure.



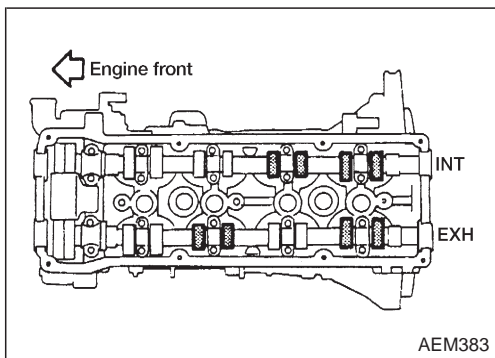
4. Using a feeler gauge, measure clearance between valve lifter and camshaft.
- Record any valve clearance measurements which are out of specification. They will be used later to determine the required replacement adjusting shim.

**Valve clearance (Hot):****Intake**

**0.31 - 0.39 mm (0.012 - 0.015 in)**

**Exhaust**

**0.33 - 0.41 mm (0.013 - 0.016 in)**



5. Turn crankshaft one revolution (360°) and align mark on crankshaft pulley with pointer.
6. Check those valves shown in the figure.
- Use the same procedure as mentioned in step 4.
7. If all valve clearances are within specification, install the following parts.
- Rocker cover
  - All spark plugs

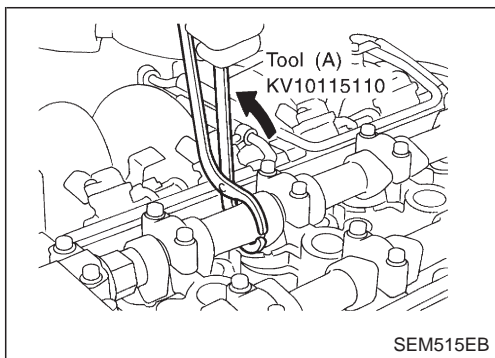
**ADJUSTING****Adjust valve clearance while engine is cold.**

1. Turn crankshaft to position cam lobe on camshaft of valve that must be adjusted upward.
2. Place Tool (A) around camshaft as shown in figure.
3. Rotate Tool (A) so that lifter is pushed down.

**Before placing Tool (A), rotate notch toward center of cylinder head (See figure.), to simplify shim removal later.**

**CAUTION:**

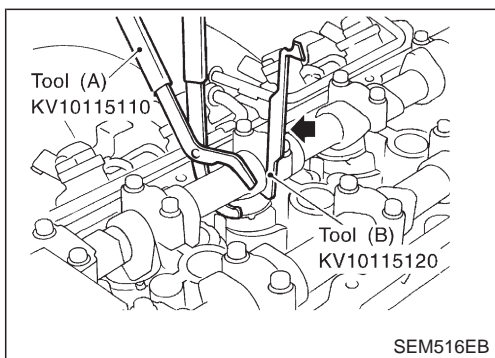
**Be careful not to damage cam surface with Tool (A).**



4. Place Tool (B) between camshaft and the edge of the valve lifter to retain valve lifter.

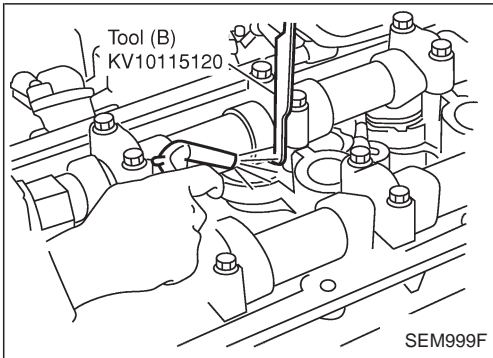
**CAUTION:**

- Tool (B) must be placed as close to camshaft bracket as possible.
  - Be careful not to damage cam surface with Tool (B).
5. Remove Tool (A).

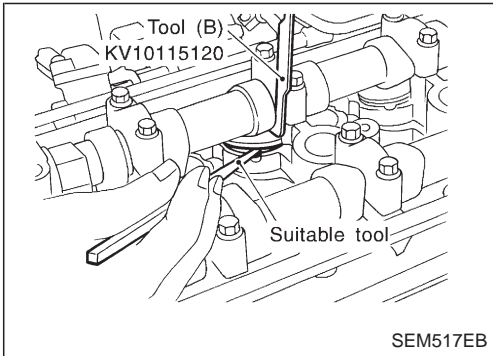




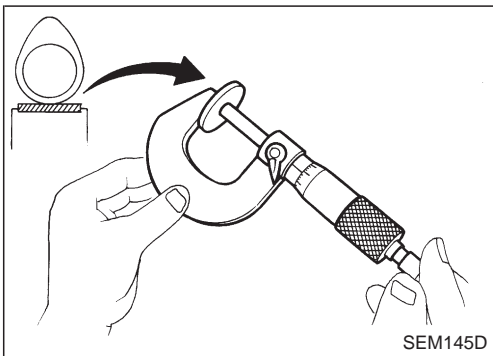
## Valve Clearance (Cont'd)



6. Rotate adjusting shim until hole is visible. Blow air into the hole to separate adjusting shim from valve lifter.



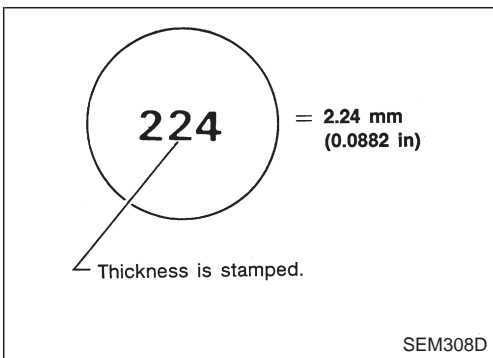
7. Remove adjusting shim using a small screwdriver and a magnetic finger.



8. Determine replacement adjusting shim size as follows.  
 a. Using a micrometer determine thickness of removed shim.  
 b. Calculate thickness of new adjusting shim so valve clearance comes within specified values.  
 $R$  = Thickness of removed shim  
 $N$  = Thickness of new shim  
 $M$  = Measured valve clearance

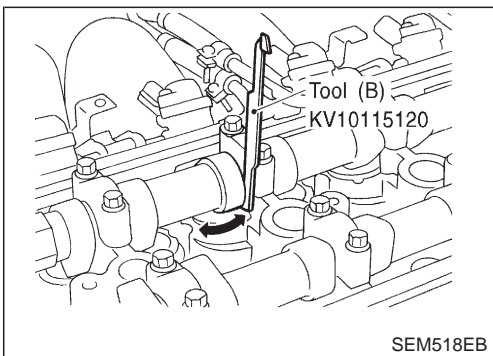
**Intake & Exhaust:**

$$N = R + [M - 0.37 \text{ mm (0.0146 in)}]$$



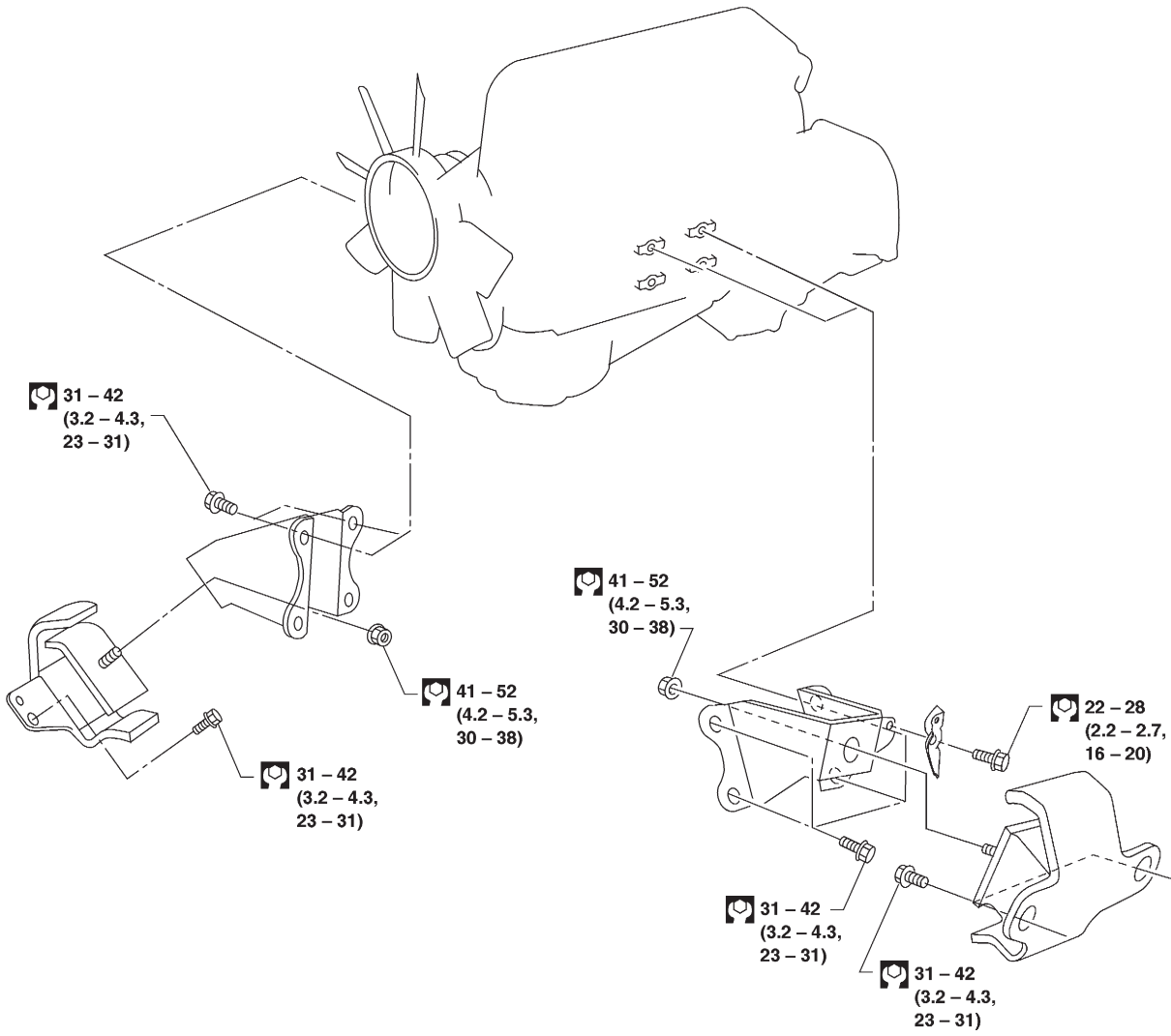
**Shims are available in thicknesses from 1.96 mm (0.0772 in) to 2.68 mm (0.1055 in), in steps of 0.02 mm (0.0008 in).**


c. Select new shim with thickness as close as possible to calculated value.  
 Refer to SDS, EM-2050.



9. Install new shim using a suitable tool.  
 ● **Install with the surface on which the thickness is stamped facing down.**  
 10. Place Tool (A) as mentioned in steps 2 and 3.  
 11. Remove Tool (B).  
 12. Remove Tool (A).  
 13. Recheck valve clearance.  
 Refer to "CHECKING" (EM-2032).

SEC. 112



 : N·m (kg·m, ft·lb)



**WARNING:**

- Position vehicle on a flat and solid surface.
- Place chocks at front and back of rear wheels.
- Do not remove engine until exhaust system has completely cooled off.  
Otherwise, you may burn yourself and/or fire may break out in fuel line.
- Before disconnecting fuel hose, release fuel pressure. Refer to EC section (“Fuel Pressure Release”, “BASIC SERVICE PROCEDURE”).
- Be sure to hoist engine and transmission in a safe manner.
- For engines not equipped with engine slingers, attach proper slingers and bolts described in PARTS CATALOG.

**CAUTION:**

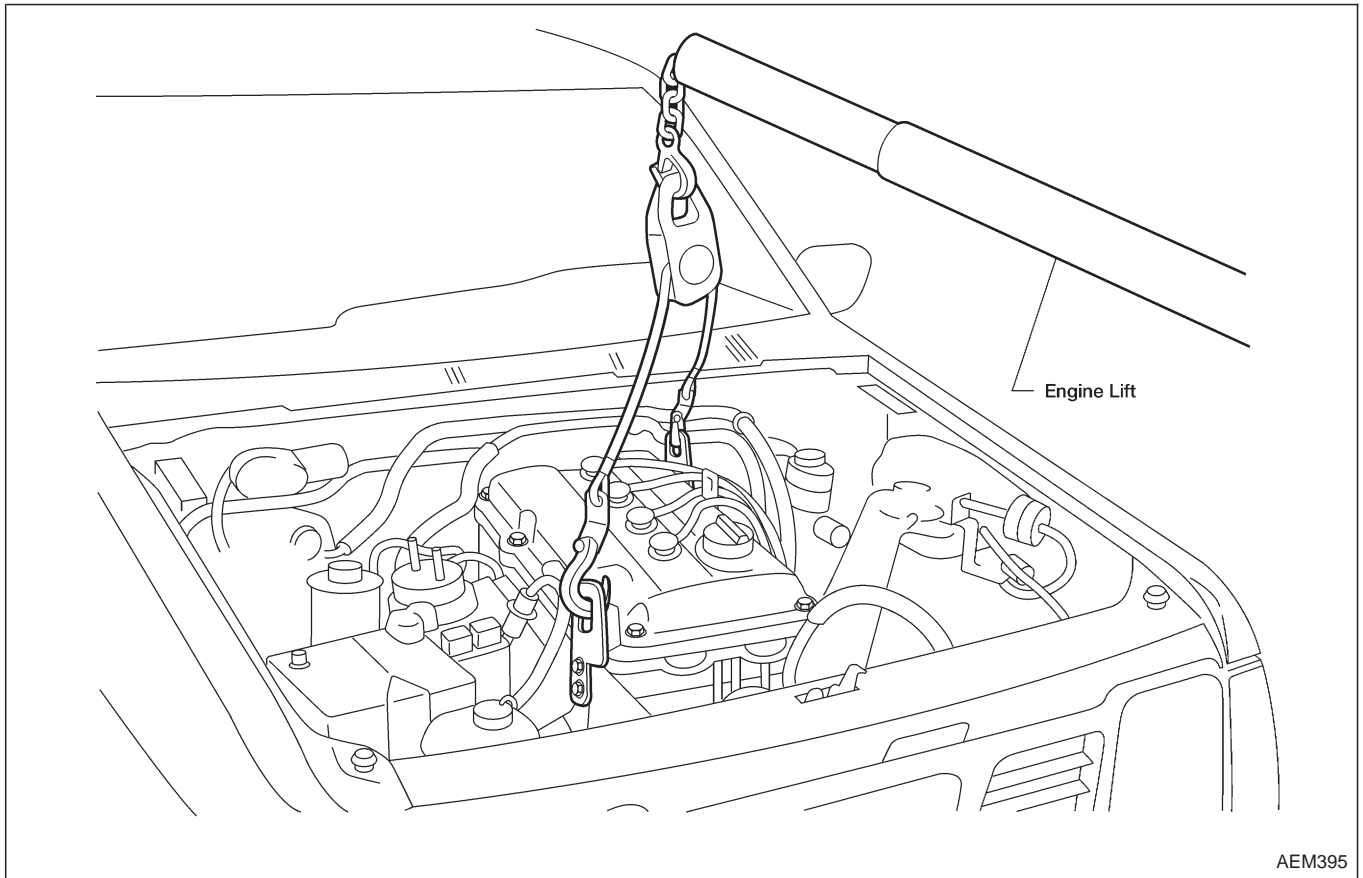
- When lifting engine, be sure to clear surrounding parts. Take special care near accelerator wire casing, brake lines and brake master cylinder.
- In hoisting the engine, always use engine slingers in a safe manner.
- For 4WD models, apply sealant between engine and transmission. Refer to MT section (“Removal and Installation”).

**Removal**

1. Drain coolant from engine block and radiator. Refer to MA section (“Changing Engine Coolant”, “ENGINE MAINTENANCE”).
2. Release fuel pressure. Refer to EC section (“Fuel Pressure Release”, “BASIC SERVICE PROCEDURE”).
3. Remove negative battery cable.
4. Remove hood. Refer to BT section.
5. Remove air cleaner and air duct.
6. Remove power steering drive belt, alternator drive belt and A/C compressor drive belt.
7. Remove radiator. Refer to LC section (“Radiator”, “ENGINE COOLING SYSTEM”).
8. Remove exhaust manifold heat shield.
9. Disconnect exhaust system from exhaust manifold.
10. Remove A/C compressor from bracket. Refer to HA section (“Compressor Mounting”, “SERVICE PROCEDURES”).
11. Disconnect accelerator wire, vacuum hoses, electrical connectors, heater hoses and vacuum booster hose.

## Removal (Cont'd)

12. Remove power steering pump from the engine.
13. Remove transmission. Refer to MT or AT section ("Removal", "REMOVAL AND INSTALLATION").
14. Remove LH and RH engine mounts.
15. Remove engine.



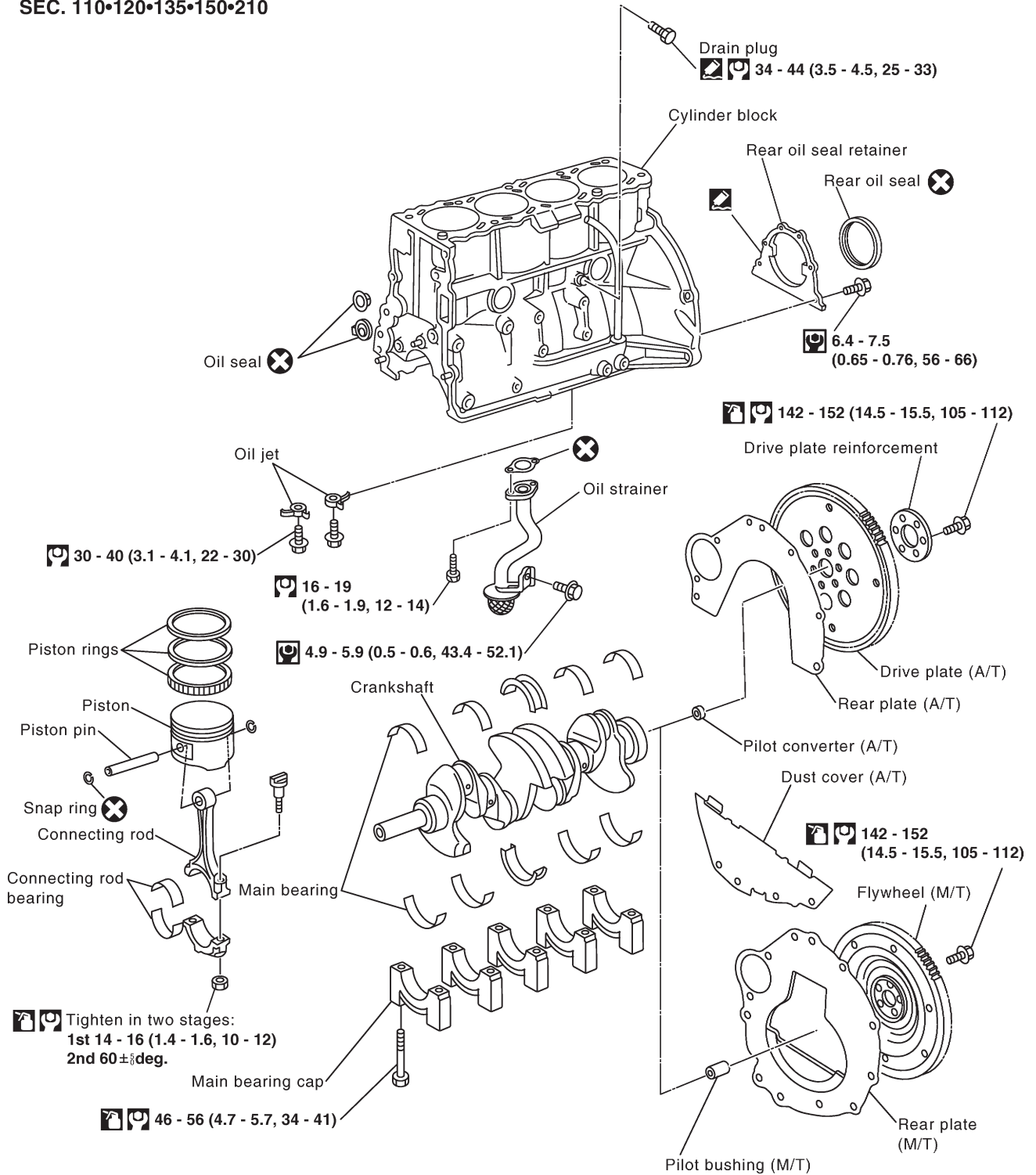
## Installation

- Install in reverse order of removal.

# CYLINDER BLOCK

KA24DE

SEC. 110•120•135•150•210



- : Lubricate with new engine oil.
- : Apply Genuine Liquid Gasket or equivalent.
- : N•m (kg-m, in-lb)
- : N•m (kg-m, ft-lb)

SEM014G

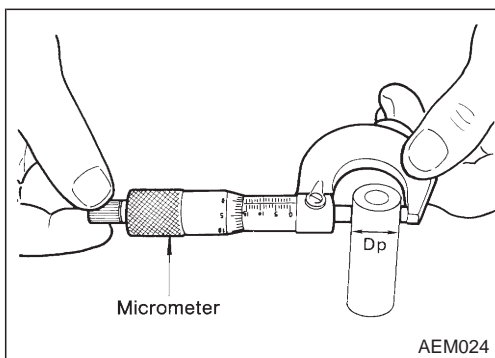
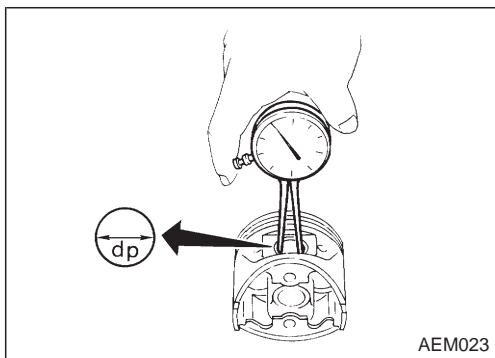
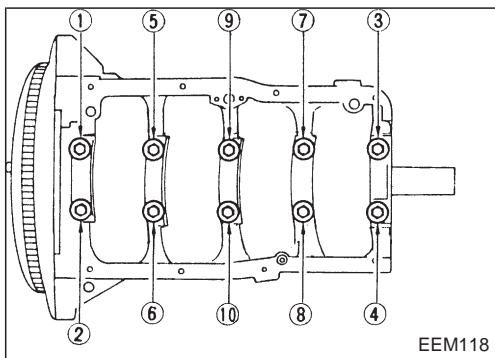
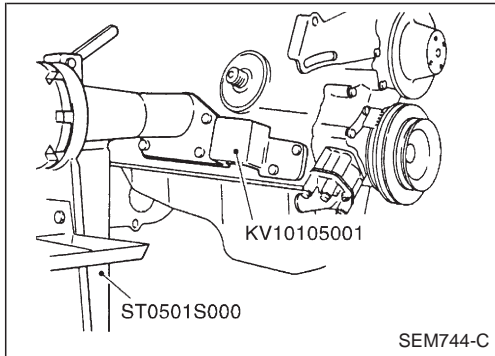
### CAUTION:

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

## Disassembly

### PISTON AND CRANKSHAFT

1. Place engine on a work stand.
  2. Drain coolant and oil.
  3. Remove oil pan.
  4. Remove timing chain. Refer to "Removal" in "TIMING CHAIN" (EM-2015).
  5. Remove water pump.
  6. Remove cylinder head.
  7. Remove pistons with connecting rods.
  8. Remove bearing caps and crankshaft.
- **Before removing bearing caps, measure crankshaft end play. Refer to EM-2047.**
  - **Bolts should be loosened in two or three steps.**



## Inspection

### PISTON AND PISTON PIN CLEARANCE

1. Measure inner diameter of piston pin hole "dp".  
**Standard diameter "dp":**  
**20.993 - 20.999 mm (0.8265 - 0.8267 in)**
2. Measure outer diameter of piston pin "Dp".  
**Standard diameter "Dp":**  
**20.989 - 21.001 mm (0.8263 - 0.8268 in)**
3. Calculate piston pin clearance.  
**dp - Dp = -0.002 to 0.01 mm (-0.0001 to 0.0004 in)**  
 If it exceeds the above value, replace piston assembly with pin.

## Inspection (Cont'd)

### PISTON RING SIDE CLEARANCE

Side clearance:

Top ring 0.04 - 0.08 mm (0.0016 - 0.0031 in)

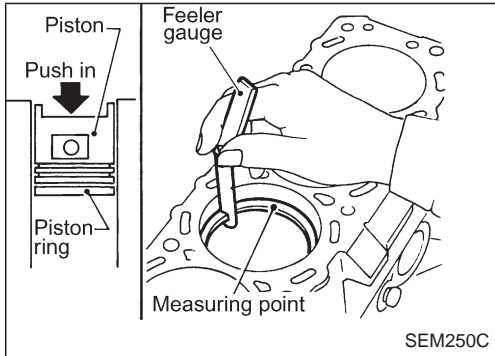
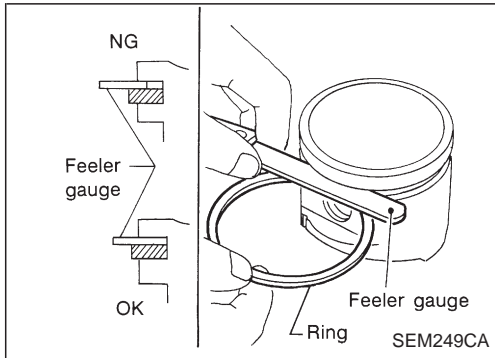
2nd ring 0.03 - 0.07 mm (0.0012 - 0.0028 in)

Max. limit of side clearance:

0.1 mm (0.004 in)

If out of specification, replace piston ring.

If clearance exceeds maximum limit with new ring, replace piston.



### PISTON RING END GAP

End gap:

Top ring

0.28 - 0.52 mm (0.0110 - 0.0205 in)

2nd ring

0.45 - 0.69 mm (0.0177 - 0.0272 in)

(R or T is punched on the ring.)

0.55 - 0.70 mm (0.0217 - 0.0276 in)

(N is punched on the ring.)

Oil ring

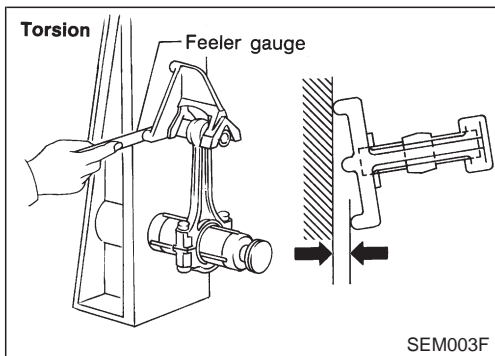
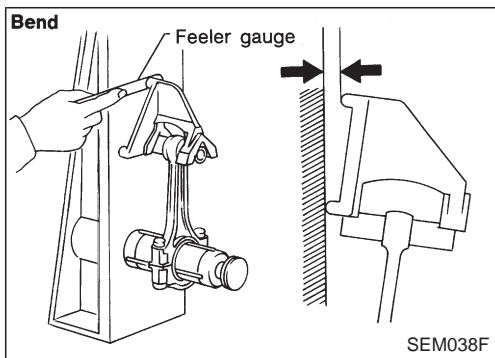
0.20 - 0.69 mm (0.0079 - 0.0272 in)

Max. limit of ring gap:

Refer to SDS, EM-2054.

If out of specification, replace piston ring. If gap exceeds maximum limit with a new ring, rebore cylinder and use oversized piston and piston rings. Refer to SDS, EM-2054.

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



### CONNECTING ROD BEND AND TORSION

Bend:

Limit 0.15 mm (0.0059 in)

per 100 mm (3.94 in) length

Torsion:

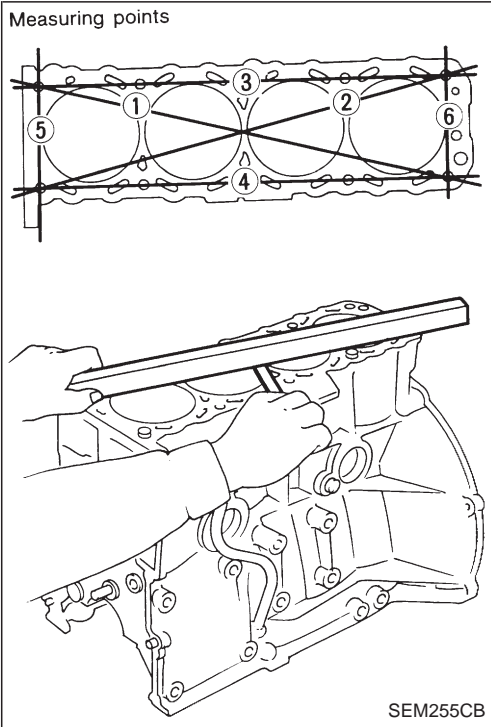
Limit 0.30 mm (0.0118 in)

per 100 mm (3.94 in) length

If it exceeds the limit, replace connecting rod assembly.

## Inspection (Cont'd)

### CYLINDER BLOCK DISTORTION AND WEAR



1. Clean upper face of cylinder block.  
Use a reliable straightedge and feeler gauge to check the flatness of cylinder block surface. Check along six positions shown in figure.

**Limit:**

**0.1 mm (0.004 in)**

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

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

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

**The maximum limit is as follows:**

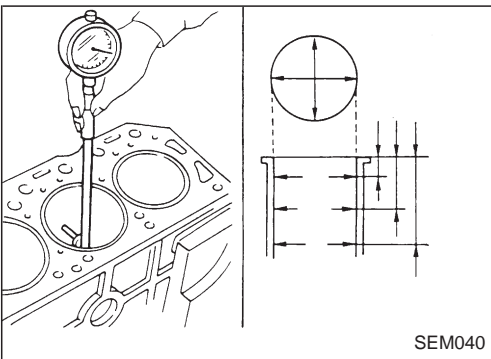
**A + B = 0.2 mm (0.008 in)**

**Nominal cylinder block height from crankshaft center:**

**246.95 - 247.05 mm (9.7224 - 9.7264 in)**

3. If necessary, replace cylinder block.

### PISTON-TO-BORE CLEARANCE



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

**Standard inner diameter:**

**Refer to SDS, EM-2052.**

**Wear limit: 0.2 mm (0.008 in)**

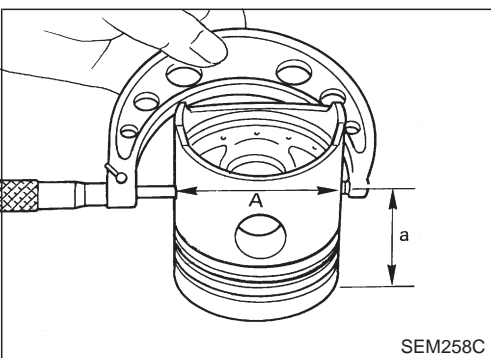
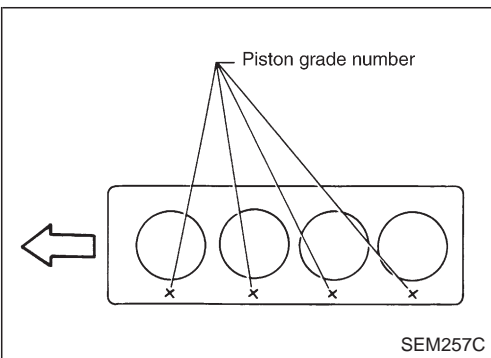
**Out-of-round (X - Y) standard: 0.015 mm (0.0006 in)**

**Taper (A - B) standard: 0.010 mm (0.0004 in)**

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

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

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



3. Measure piston skirt diameter.

**Piston diameter "A":**

**Refer to SDS, EM-2054.**

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

**Approximately 48 mm (1.89 in)**

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

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

**0.020 - 0.040 mm (0.0008 - 0.0016 in)**

5. Determine piston oversize according to amount of cylinder wear.

**Oversize pistons are available for service. Refer to SDS, EM-2054.**

**EM-2041**

**Inspection (Cont'd)**

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

**Rebored size calculation:**

$$D = A + B - C$$

where,

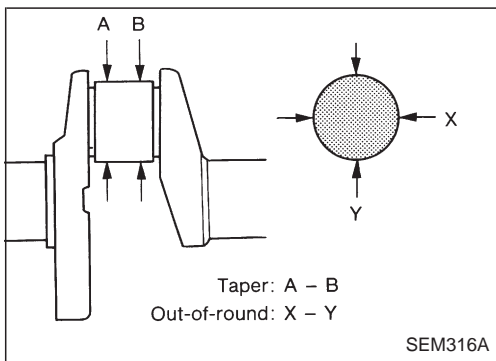
**D: Bored diameter**

**A: Piston diameter as measured**

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

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

7. Install main bearing caps and tighten bolts to the specified torque. This will prevent distortion of cylinder bores.
8. Cut cylinder bores.
  - **When any cylinder needs boring, all other cylinders must also be bored.**
  - **Do not cut too much out of cylinder bore at a time. Cut only 0.05 mm (0.0020 in) or so at a time.**
9. Hone cylinders to obtain specified piston-to-bore clearance.
10. Measure finished cylinder bore for out-of-round and taper.
  - **Measurement should be done after cylinder bore cools down.**



**CRANKSHAFT**

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

**Out-of-round (X - Y):**

**Main journal Less than 0.01 mm (0.0004 in)**

**Crank pin Less than 0.005 mm (0.0002 in)**

**Taper (A - B):**

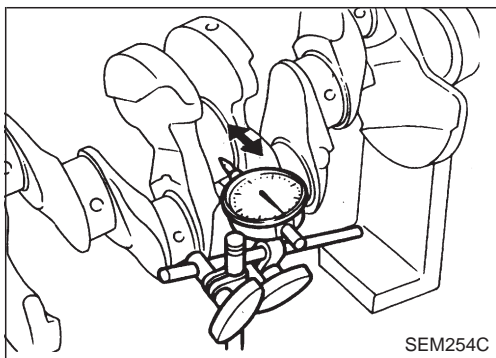
**Main journal Less than 0.01 mm (0.0004 in)**

**Crank pin Less than 0.005 mm (0.0002 in)**

3. Measure crankshaft runout.

**Runout (Total indicator reading):**

**Less than 0.10 mm (0.0039 in)**



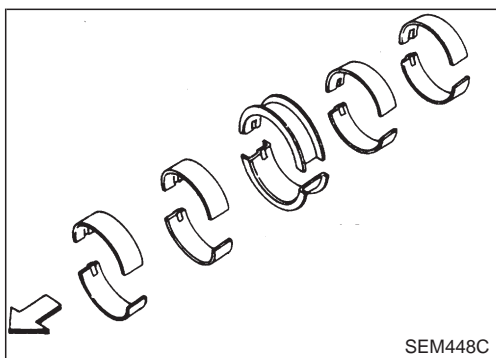
**BEARING CLEARANCE**

- Use Method A or Method B. Method A is preferred because it is more accurate.

**Method A (Using bore gauge and micrometer)**

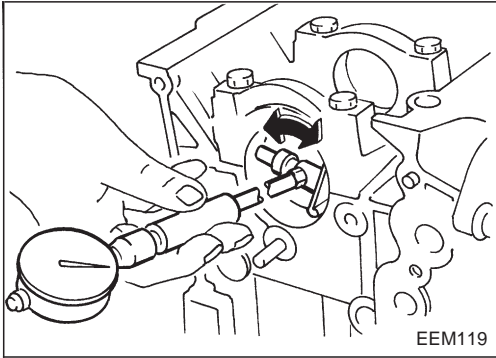
**Main bearing**

1. Set main bearings in their proper positions on cylinder block and main bearing cap.



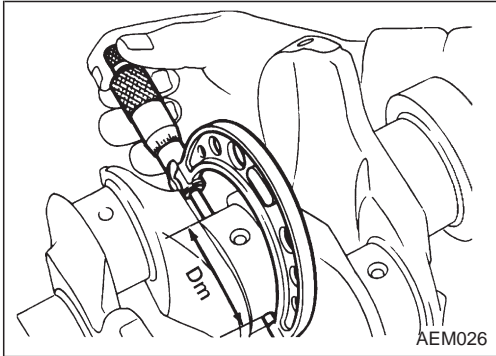


**Inspection (Cont'd)**



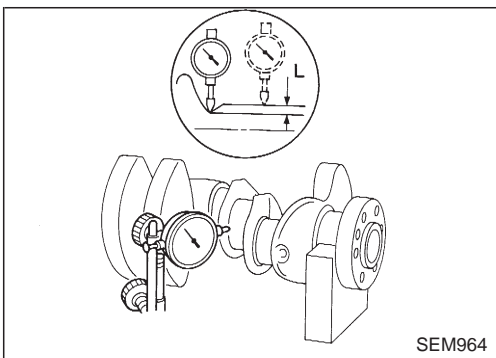
EEM119

2. Install main bearing cap to cylinder block.
  - **Tighten all bolts in correct order in two or three stages. Refer to EM-2038 and EM-2046.**
3. Measure inner diameter "A" of each main bearing.



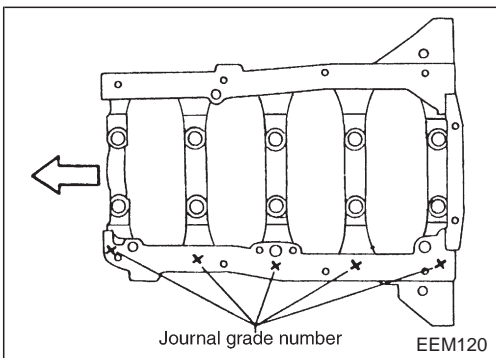
AEM026

4. Measure outer diameter "Dm" of each crankshaft main journal.
5. Calculate main bearing clearance.  
Main bearing clearance = A - Dm  
**Standard:**  
0.020 - 0.047 mm (0.0008 - 0.0019 in)  
**Limit:**  
0.1 mm (0.004 in)
6. If it exceeds the limit, replace bearing.
7. If clearance cannot be adjusted within the standard of any bearing, grind crankshaft journal and use undersized bearing.



SEM964

- a. When grinding crankshaft journal, confirm that "L" dimension in fillet roll is more than the specified limit.  
"L": 0.1 mm (0.004 in)
- b. Refer to SDS, EM-2055 & EM-2056 for grinding crankshaft and available service parts.



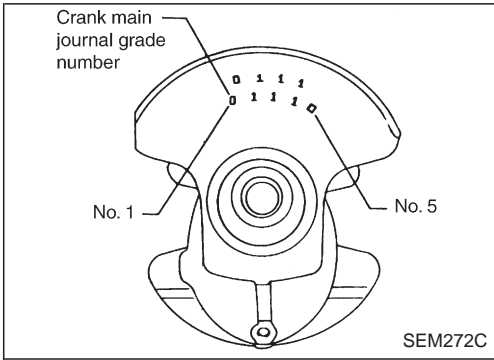
Journal grade number

EEM120

8. If crankshaft is reused, measure main bearing clearance and select thickness of main bearing.  
If crankshaft or cylinder block is replaced, select thickness of main bearings as follows:
  - a. Grade number of each cylinder block main journal is punched on the respective cylinder block. These numbers are punched in either Arabic or Roman numerals.



**Inspection (Cont'd)**



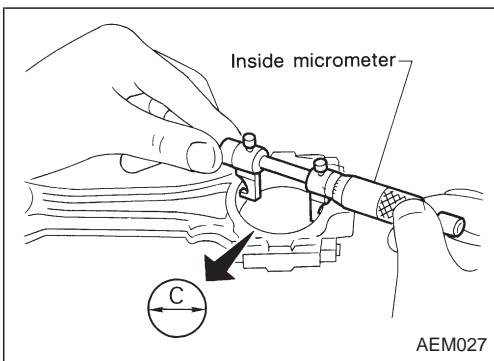
- b. Grade number of each crankshaft main journal is punched on crankshaft. These numbers are punched in either Arabic or Roman numerals.
- c. Select main bearing with suitable thickness according to the following example or table.

For example:

Main journal grade number: 1  
 Crankshaft journal grade number: 2  
 Main bearing grade number = 1 + 2  
 = 3 (Yellow)

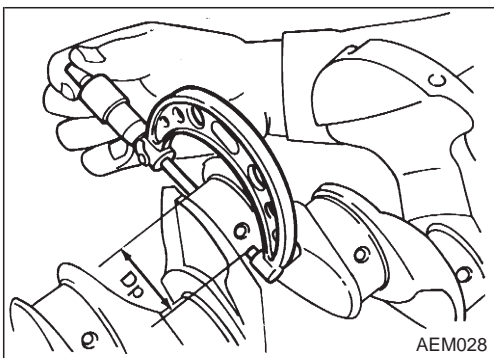
**Main bearing grade number and identification color:**

		Main journal grade number		
		0	1	2
Crankshaft journal grade number	0	0 (Black)	1 (Brown)	2 (Green)
	1 or I	1 (Brown)	2 (Green)	3 (Yellow)
	2 or II	2 (Green)	3 (Yellow)	4 (Blue)



**Connecting rod bearing (Big end)**

- 1. Install connecting rod bearing to connecting rod and cap.
- 2. Install connecting rod cap to connecting rod.
- **Tighten bolts to the specified torque.**
- 3. Measure inner diameter "C" of each bearing.



- 4. Measure outer diameter "Dp" of each crankshaft pin journal.
- 5. Calculate connecting rod bearing clearance.

**Connecting rod bearing clearance = C - Dp:**

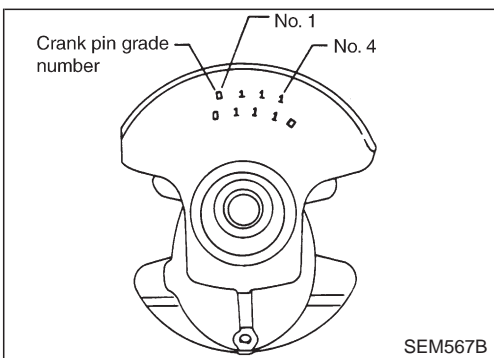
**Standard**

**0.010 - 0.035 mm (0.0004 - 0.0014 in)**

**Limit**

**0.09 mm (0.0035 in)**

- 6. If it exceeds the limit, replace bearing.
- 7. If clearance cannot be adjusted within the standard of any bearing, grind crankshaft journal and use undersized bearing. Refer to step 5 of "BEARING CLEARANCE", EM-2042.



- 8. If crankshaft is replaced, select connecting rod bearing according to the following table.

**Connecting rod bearing grade number:**

These numbers are punched in either Arabic or Roman numerals.

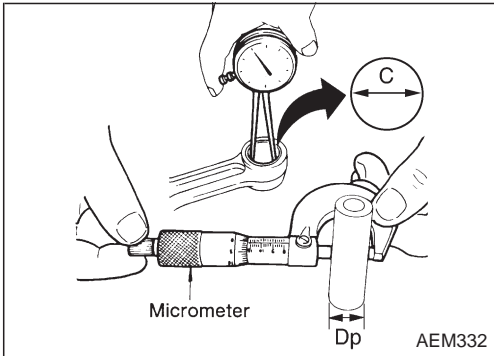
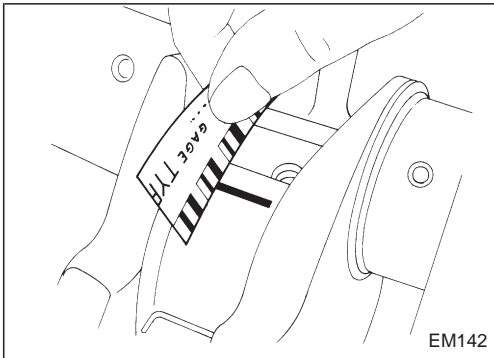
Crank pin grade number	Connecting rod bearing grade number
0	0
1 or I	1
2 or II	2

**Inspection (Cont'd)**

**Method B (Using plastigage)**

**CAUTION:**

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



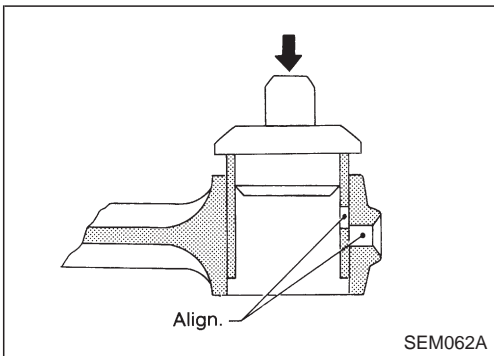
**CONNECTING ROD BUSHING CLEARANCE (Small end)**

1. Measure inner diameter "C" of bushing.
2. Measure outer diameter "Dp" of piston pin.
3. Calculate connecting rod bushing clearance.

$$C - Dp =$$

0.005 - 0.017 mm (0.0002 - 0.0007 in) (Standard)  
0.023 mm (0.0009 in) (Limit)

If out of specification, replace connecting rod assembly and/or piston set with pin.



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

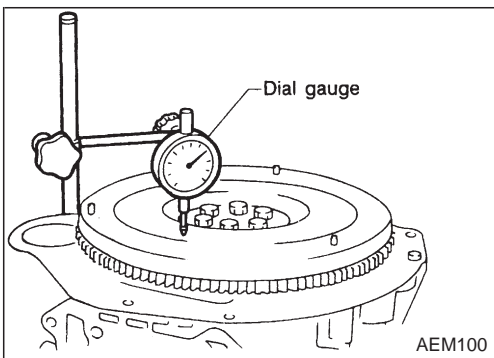
1. Drive in small end bushing until it is flush with end surface of rod.

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

2. Ream the bushing until clearance with piston pin is within specification.

**Clearance between connecting rod bushing and piston pin:**

$$0.005 - 0.017 \text{ mm (0.0002 - 0.0007 in)}$$



**FLYWHEEL/DRIVE PLATE RUNOUT**

**Runout (Total indicator reading):**

- Flywheel (M/T model)  
Less than 0.15 mm (0.006 in)
- Drive plate (A/T model)  
Less than 0.15 mm (0.006 in)

**CAUTION:**

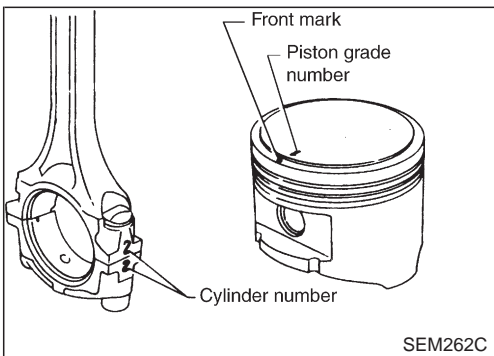
- Be careful not to damage the ring gear teeth.
- Check the drive plate for deformation and cracks.
- Do not allow any magnetic materials to contact the ring gear teeth.
- Do not resurface the flywheel. Replace as necessary.

**Assembly**

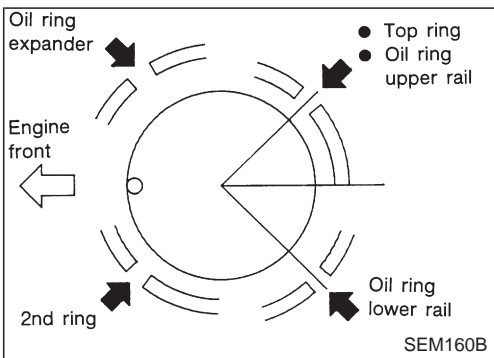
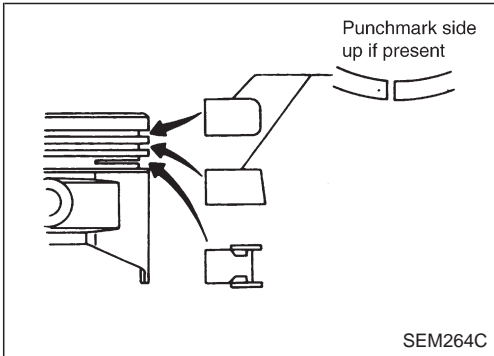
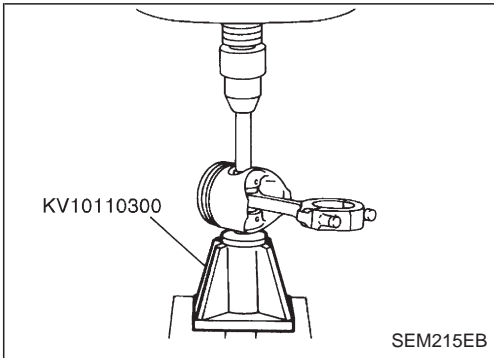
**PISTON**

1. Heat piston to 60 to 70°C (140 to 158°F) and assemble piston, piston pin and connecting rod.

- Align the direction of piston and connecting rod.
- Numbers stamped on connecting rod and cap correspond to each cylinder.
- After assembly, make sure connecting rod swings smoothly.



Assembly (Cont'd)

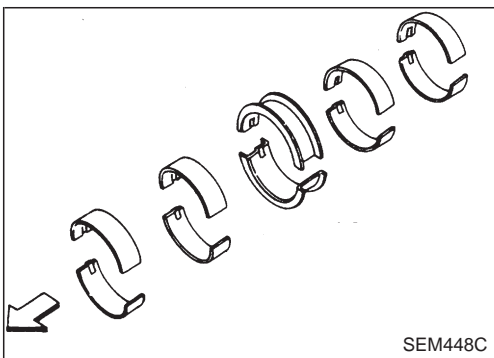


2. Set piston rings as shown.

**CAUTION:**

- When piston rings are not replaced, make sure that piston rings are mounted in their original positions.
- When piston rings are being replaced and no punchmark is present, piston rings can be mounted with either side up.

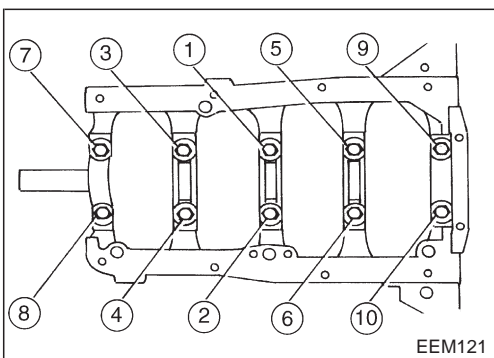
3. Align piston rings so that end gaps are positioned as shown.



**CRANKSHAFT**

1. Set main bearings in their proper positions on cylinder block and main bearing caps.

- Confirm that correct main bearings are used. Refer to EM-2042.
- Apply new engine oil to bearing surfaces.

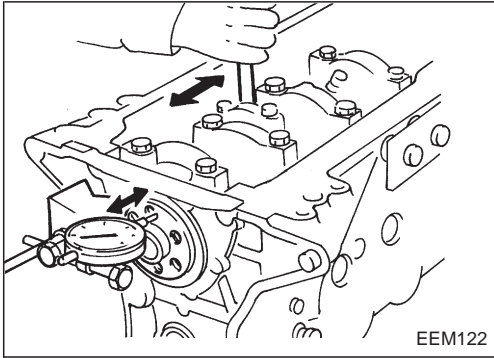


2. Install crankshaft and main bearing caps and tighten bolts to the specified torque. Refer to EM-2038.

- Apply new engine oil to the bolt threads and seat surface.
- Prior to tightening bearing cap bolts, place bearing cap in its proper position by shifting crankshaft in the axial direction.
- Tighten bearing cap bolts gradually in two or three stages. Start with center bearing and move outward as shown in figure.
- After securing bearing cap bolts, make sure crankshaft turns smoothly by hand.

**EM-2046**

## Assembly (Cont'd)



3. Measure crankshaft end play.

### Crankshaft end play:

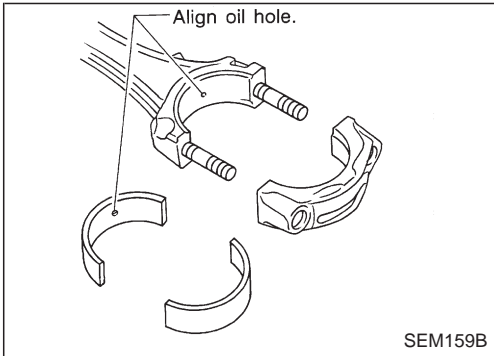
#### Standard

**0.05 - 0.18 mm (0.0020 - 0.0071 in)**

#### Limit

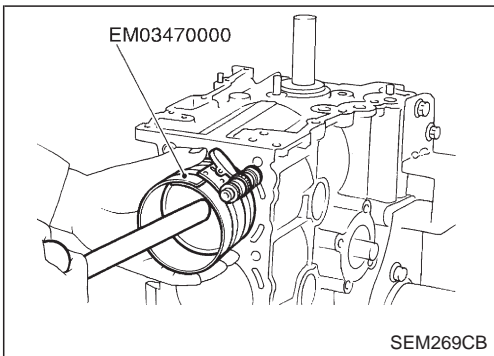
**0.3 mm (0.012 in)**

If beyond the limit, replace No. 3 bearing with a new one.



4. Install connecting rod bearings in connecting rods and connecting rod caps.

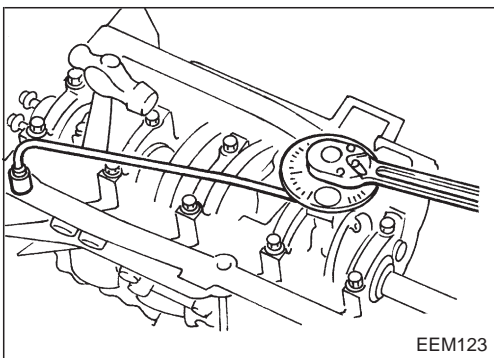
- **Confirm that correct bearings are used. Refer to EM-2044.**
- **Install bearings so that oil hole in connecting rod aligns with oil hole of bearing.**
- **Apply new engine oil to bearing surfaces, bolt threads and seating surfaces.**



5. Install pistons with connecting rods.

a. Install them into corresponding cylinders with Tool.

- **Arrange so that front mark on piston head faces toward front of engine.**
- **Make sure connecting rod does not scratch cylinder wall.**
- **Make sure connecting rod bolts do not scratch crankshaft journals.**
- **Apply new engine oil to piston rings and sliding surface of piston.**



b. Install connecting rod bearing caps.

Tighten connecting rod bearing cap nuts using the following procedure.

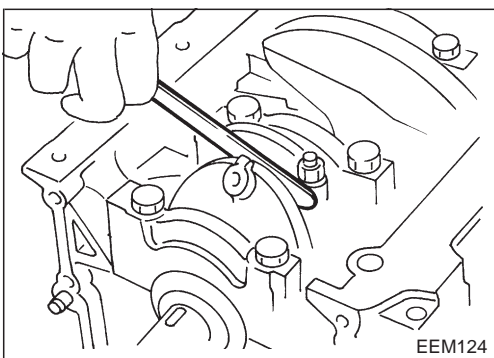
### Connecting rod bearing nut:

(1) Tighten to 14 to 16 N·m

(1.4 to 1.6 kg-m, 10 to 12 ft-lb).

(2) Tighten bolts  $60^{+5}_{-0}$  degrees clockwise with an angle wrench.

If an angle wrench is not available, tighten them to 38 to 44 N·m (3.9 to 4.5 kg-m, 28 to 33 ft-lb).



6. Measure connecting rod side clearance.

### Connecting rod side clearance:

#### Standard

**0.2 - 0.4 mm (0.008 - 0.016 in)**

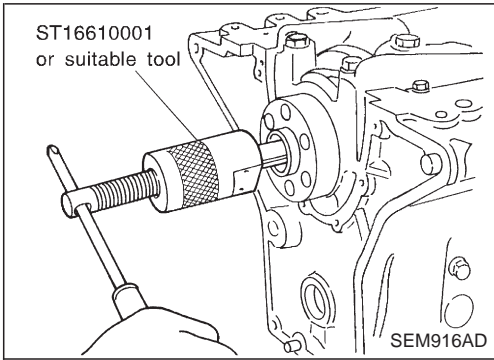
#### Limit

**0.6 mm (0.024 in)**

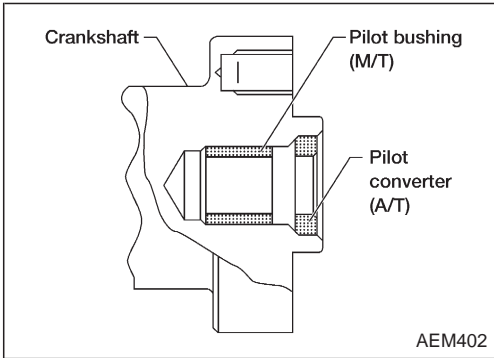
If beyond the limit, replace connecting rod and/or crankshaft.

## Assembly (Cont'd) REPLACING PILOT BUSHING

1. Remove pilot bushing.



2. Install pilot bushing.



General Specifications

Cylinder arrangement	In-line 4	
Displacement	cm <sup>3</sup> (cu in)	2,389 (145.78)
Bore and stroke	mm (in)	89 x 96 (3.50 x 3.78)
Valve arrangement	DOHC	
Firing order	1-3-4-2	
Number of piston rings		
Compression	2	
Oil	1	
Number of main bearings	5	
Compression ratio	9.2	

COMPRESSION PRESSURE

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

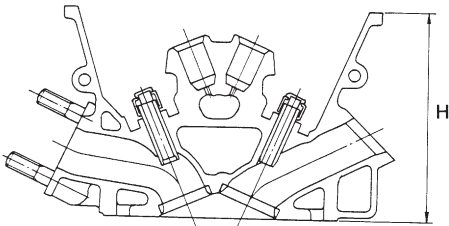
Compression pressure	
Standard	1,226 (12.26, 12.5, 178)
Minimum	1,030 (10.30, 10.5, 149)
Differential limit between cylinders	98 (0.98, 1.0, 14)

Inspection and Adjustment

CYLINDER HEAD

Unit: mm (in)

	Standard	Limit
Head surface distortion	Less than 0.03 (0.0012)	0.1 (0.004)

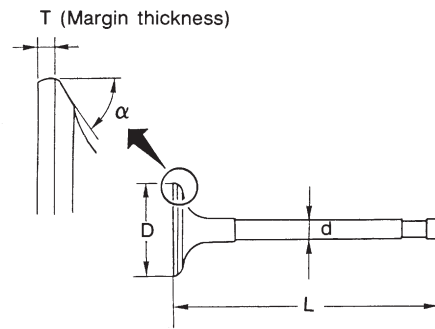


Nominal cylinder head height:  
H = 126.3 - 126.5 (4.972 - 4.980)

SEM519E

VALVE

Unit: mm (in)



SEM188

Valve head diameter "D"	
Intake	36.5 - 36.7 (1.437 - 1.445)
Exhaust	31.2 - 31.4 (1.228 - 1.236)
Valve length "L"	
Intake	101.02 - 102.65 (3.9772 - 4.0413)
Exhaust	98.52 - 99.12 (3.8787 - 3.9024)
Valve stem diameter "d"	
Intake	6.965 - 6.980 (0.2742 - 0.2748)
Exhaust	6.945 - 6.960 (0.2734 - 0.2740)
Valve seat angle "alpha"	
Intake & Exhaust	45°15' - 45°45'
Valve margin "T"	
Intake	1.15 - 1.45 (0.0453 - 0.0571)
Exhaust	1.44 - 1.75 (0.0567 - 0.0689)
Valve margin "T" limit	More than 0.5 (0.020)
Valve stem end surface grinding limit	Less than 0.2 (0.008)

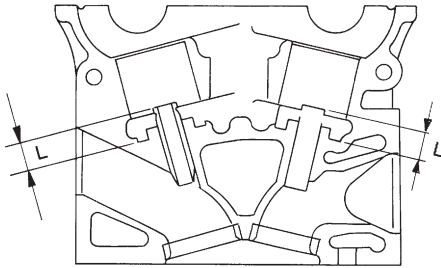
**Inspection and Adjustment (Cont'd)**

**Valve spring**

Free height	mm (in)	50.37 (1.9831)	
Pressure N (kg, lb) at height mm (in)		418.0 (42.6, 93.9) at 29.17 (1.1484)	
			Standard
			Limit
Out-of-square	mm (in)	Less than 2.2 (0.087)	

**Valve guide**

Unit: mm (in)



SEM301D

		Standard	Service
Valve guide	Outer diameter	Intake	11.023 - 11.034 (0.4340 - 0.4344)
		Exhaust	11.023 - 11.034 (0.4340 - 0.4344)
Valve guide	Inner diameter (Finished size)	Intake	7.000 - 7.018 (0.2756 - 0.2763)
		Exhaust	7.000 - 7.018 (0.2756 - 0.2763)
Cylinder head valve guide hole diameter	Intake	10.975 - 10.996 (0.4321 - 0.4329)	11.175 - 11.196 (0.4400 - 0.4408)
	Exhaust	10.975 - 10.996 (0.4321 - 0.4329)	11.175 - 11.196 (0.4400 - 0.4408)
Interference fit of valve guide	0.027 - 0.059 (0.0011 - 0.0023)		
		Standard	Limit
Stem to guide clearance	Intake	0.020 - 0.053 (0.0008 - 0.0021)	0.08 (0.0031)
	Exhaust	0.040 - 0.073 (0.0016 - 0.0029)	0.1 (0.004)
Valve deflection limit	0.2 (0.008)		
Projection length "L"	13.3 - 13.9 (0.524 - 0.547)		

**Valve lifter**

Unit: mm (in)

Valve lifter outer diameter	33.960 - 33.975 (1.3370 - 1.3376)
Lifter guide inner diameter	34.000 - 34.021 (1.3386 - 1.3394)
Clearance between lifter and filter guide	0.025 - 0.061 (0.0010 - 0.0024)

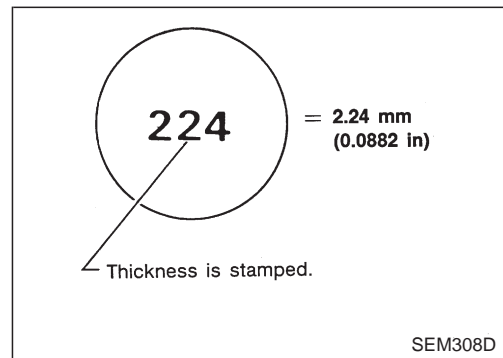
**Valve clearance adjustment**

Unit: mm (in)

Valve clearance (Hot)	
Intake	0.31 - 0.39 (0.012 - 0.015)
Exhaust	0.33 - 0.41 (0.013 - 0.016)

**Available shims**

Thickness mm (in)	Identification mark
1.96 (0.0772)	196
1.98 (0.0780)	198
2.00 (0.0787)	200
2.02 (0.0795)	202
2.04 (0.0803)	204
2.06 (0.0811)	206
2.08 (0.0819)	208
2.10 (0.0827)	210
2.12 (0.0835)	212
2.14 (0.0843)	214
2.16 (0.0850)	216
2.18 (0.0858)	218
2.20 (0.0866)	220
2.22 (0.0874)	222
2.24 (0.0882)	224
2.26 (0.0890)	226
2.28 (0.0898)	228
2.30 (0.0906)	230
2.32 (0.0913)	232
2.34 (0.0921)	234
2.36 (0.0929)	236
2.38 (0.0937)	238
2.40 (0.0945)	240
2.42 (0.0953)	242
2.44 (0.0961)	244
2.46 (0.0969)	246
2.48 (0.0976)	248
2.50 (0.0984)	250
2.52 (0.0992)	252
2.54 (0.1000)	254
2.56 (0.1008)	256
2.58 (0.1016)	258
2.60 (0.1024)	260
2.62 (0.1031)	262
2.64 (0.1039)	264
2.66 (0.1047)	266
2.68 (0.1055)	268



SEM308D

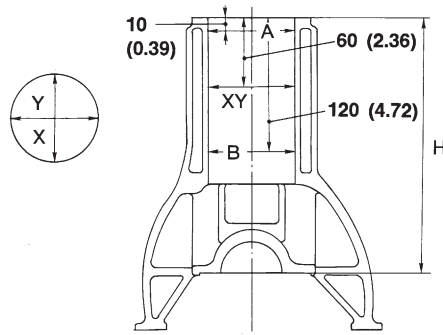






Inspection and Adjustment (Cont'd)

CYLINDER BLOCK



SEM400E

Unit: mm (in)

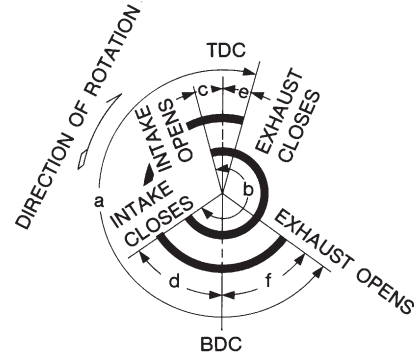
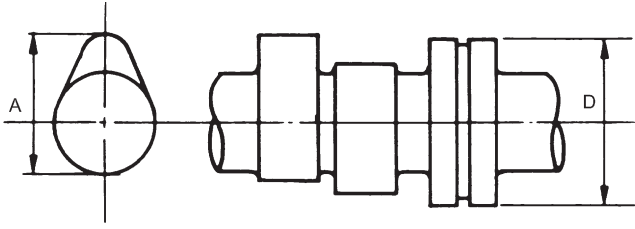
			Standard	Limit
Distortion			—	0.1 (0.004)
Cylinder bore	Inner diameter	Grade 1	89.000 - 89.010 (3.5039 - 3.5043)	0.2 (0.008)*
		Grade 2	89.010 - 89.020 (3.5043 - 3.5047)	
		Grade 3	89.020 - 89.030 (3.5047 - 3.5051)	
	Out-of-round (X - Y)		Less than 0.015 (0.0006)	—
Taper (A - B)		Less than 0.010 (0.0004)	—	
Difference in inner diameter between cylinders			Less than 0.03 (0.0012)	0.2 (0.008)
Piston-to-cylinder clearance			0.020 - 0.040 (0.0008 - 0.0016)	—
Cylinder block height (From crankshaft center)			246.95 - 247.05 (9.7224 - 9.7264)	0.2 (0.008)**

\* Wear limit

\*\* Total amount of cylinder head resurfacing and cylinder block resurfacing

Inspection and Adjustment (Cont'd)

CAMSHAFT AND CAMSHAFT BEARING



SEM568A

EM120

Unit: mm (in)

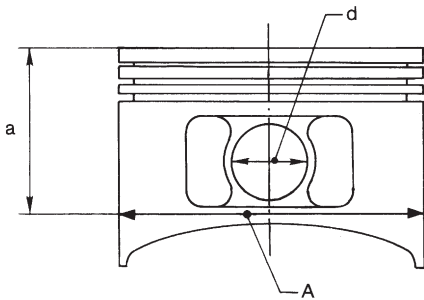
		Standard	Limit
Cam height (A)	Intake	42.505 - 42.695 (1.673 - 1.681)	—
	Exhaust	40.905 - 41.095 (1.610 - 1.618)	—
Wear limit of cam height		—	0.2 (0.008)
Camshaft journal to bearing clearance		0.045 - 0.090 (0.0018 - 0.0035)	0.12 (0.0047)
Inner diameter of camshaft bearing	#1 to #5 journals	28.000 - 28.025 (1.1024 - 1.1033)	—
Outer diameter of camshaft journal (D)	#1 to #5 journals	27.935 - 27.955 (1.0998 - 1.1006)	—
Camshaft runout*		Less than 0.02 (0.0008)	0.04 (0.0016)
Camshaft end play		0.070 - 0.148 (0.0028 - 0.0058)	0.2 (0.008)
Valve timing (Degree on crankshaft)	a	216	—
	b	232	—
	c	-1	—
	d	53	—
	e	4	—
	f	32	—

\* Total indicator reading

Inspection and Adjustment (Cont'd)

PISTON, PISTON RING AND PISTON PIN

Piston



SEM804E

Unit: mm (in)

Piston skirt diameter (A)	Standard	Grade No. 1	88.970 - 88.980 (3.5027 - 3.5031)
		Grade No. 2	88.980 - 88.990 (3.5031 - 3.5035)
		Grade No. 3	88.990 - 89.000 (3.5035 - 3.5039)
	Service (Oversize)	0.5 (0.020)	89.470 - 89.500 (3.5224 - 3.5236)
		1.0 (0.039)	89.970 - 90.000 (3.5421 - 3.5433)
Dimension (a)	Approximately 48 (1.89)		
Piston pin hole diameter (d)	20.993 - 20.999 (0.8265 - 0.8267)		
Piston-to-cylinder bore clearance	0.020 - 0.040 (0.0008 - 0.0016)		

Piston pin

Unit: mm (in)

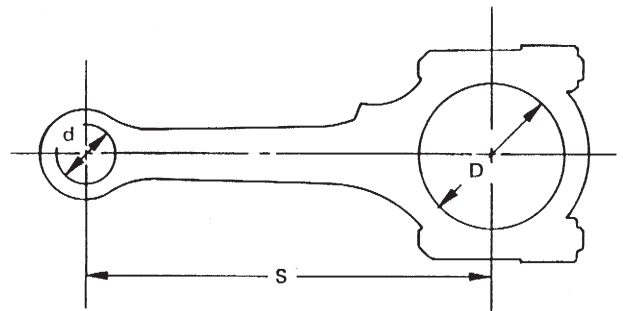
	Standard	Limit
Piston pin outer diameter	20.989 - 21.001 (0.8263 - 0.8268)	—
Interference fit of piston pin to piston pin hole	-0.002 to 0.01 (-0.0001 to 0.0004)	—
Piston pin to connecting rod bearing clearance	0.005 - 0.017 (0.0002 - 0.0007)	0.023 (0.0009)

Piston ring

Unit: mm (in)

		Standard	Limit
Side clearance	Top	0.040 - 0.080 (0.0016 - 0.0031)	0.1 (0.004)
	2nd	0.030 - 0.070 (0.0012 - 0.0028)	0.1 (0.004)
Ring gap	Top	0.28 - 0.52 (0.0110 - 0.0205)	1.0 (0.039)
	2nd	0.45 - 0.69 (0.0177 - 0.0272)	1.0 (0.039)
	Oil (rail ring)	0.20 - 0.69 (0.0079 - 0.0272)	1.0 (0.039)

CONNECTING ROD



SEM570A

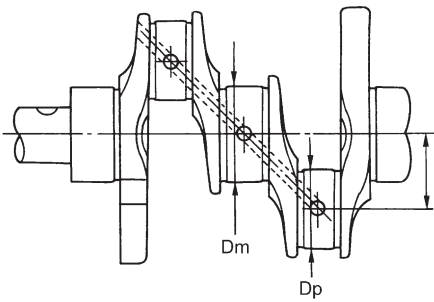
Unit: mm (in)

	Standard	Limit
Center distance (S)	164.95 - 165.05 (6.4941 - 6.4980)	—
Bend [per 100 mm (3.94 in)]	—	0.15 (0.0059)
Torsion [per 100 mm (3.94 in)]	—	0.30 (0.0118)
Connecting rod small end inner diameter (d)*	23.987 - 24.000 (0.9444 - 0.9449)	—
Piston pin bushing inner diameter	21.000 - 21.012 (0.8268 - 0.8272)	—
Connecting rod big end inner diameter (D)*	53.000 - 53.013 (2.0866 - 2.0871)	—
Side clearance	0.2 - 0.4 (0.008 - 0.016)	0.6 (0.024)

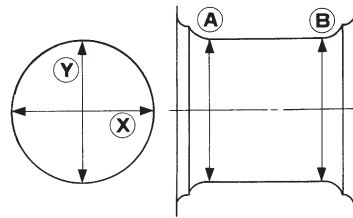
\* Without bearing

Inspection and Adjustment (Cont'd)

CRANKSHAFT



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



SEM394

EM715

Unit: mm (in)

Main journal diameter (Dm)	Grade	No. 0	59.967 - 59.975 (2.3609 - 2.3612)		
		No. 1	59.959 - 59.967 (2.3606 - 2.3609)		
		No. 2	59.951 - 59.959 (2.3603 - 2.3606)		
Pin journal diameter (Dp)	Grade	No. 0	49.968 - 49.974 (1.9672 - 1.9675)		
		No. 1	49.962 - 49.968 (1.9670 - 1.9672)		
		No. 2	49.956 - 49.962 (1.9668 - 1.9670)		
Center distance (r)		47.95 - 48.05 (1.8878 - 1.8917)			
Taper of journal and pin [(A) - (B)]	Journal	Standard	—	Limit	0.01 (0.0004)
	Pin	Standard	—	Limit	0.005 (0.0002)
Out-of-round of journal and pin [(X) - (Y)]	Journal	Standard	—	Limit	0.01 (0.0004)
	Pin	Standard	—	Limit	0.005 (0.0002)
Runout [TIR]*		Standard	—	Limit	0.10 (0.0039)
Free end play		0.05 - 0.18 (0.0020 - 0.0071)		Limit	0.3 (0.012)
Fillet roil		More than 0.1 (0.004)			

\* Total indicator reading

BEARING CLEARANCE

Unit: mm (in)

	Standard	Limit
Main bearing clearance	0.020 - 0.047 (0.0008 - 0.0019)	0.1 (0.004)
Connecting rod bearing clearance	0.010 - 0.035 (0.0004 - 0.0014)	0.09 (0.0035)

# SERVICE DATA AND SPECIFICATIONS (SDS)

KA24DE

## Inspection and Adjustment (Cont'd)

### AVAILABLE MAIN BEARING

#### Standard

Grade number	Thickness mm (in)	Identification color
0	1.821 - 1.825 (0.0717 - 0.0719)	Black
1	1.825 - 1.829 (0.0719 - 0.0720)	Brown
2	1.829 - 1.833 (0.0720 - 0.0722)	Green
3	1.833 - 1.837 (0.0722 - 0.0723)	Yellow
4	1.837 - 1.841 (0.0723 - 0.0725)	Blue

#### Undersize (service)

Unit: mm (in)

	Thickness	Main journal diameter "Dm"
0.25 (0.0098)	1.952 - 1.960 (0.0769 - 0.0772)	Grind so that bearing clearance is the specified value.

### AVAILABLE CONNECTING ROD BEARING

#### Standard

Grade number	Thickness mm (in)	Identification color
0	1.505 - 1.508 (0.0593 - 0.0594)	—
1	1.508 - 1.511 (0.0594 - 0.0595)	Brown
2	1.511 - 1.514 (0.0595 - 0.0596)	Green

#### Undersize (service)

Unit: mm (in)

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

### MISCELLANEOUS COMPONENTS

Unit: mm (in)

Camshaft sprocket runout	[TIR]*	Less than 0.15 (0.0059)
Flywheel runout	[TIR]*	Less than 0.15 (0.006)
Drive plate runout	[TIR]*	Less than 0.15 (0.006)

\* Total indicator reading