1. General Description

A: SPECIFICATION

Engine	Model			2.5 L
	Cylinder arrangement			Horizontally opposed, liquid cooled, 4-cylinder, 4-stroke gasoline engine
	Valve system mechanism			Belt driven, double overhead camshaft, 4-valve/cylinder
	Bore × Stroke mm (in)			99.5 × 79.0 (3.92 × 3.11)
	Piston displacement cm^3 (cu in)			2,457 (149.94)
	Compression ratio			8.4
	Compression presure (at 200 —300rpm) kPa (kg/cm^2, psi)			981 — 1,177 (10 — 12, 142 — 171)
	Number of piston rings			Pressure ring: 2, Oil ring: 1
	Intake valve timing	Open	Max. retard	ATDC 5°
			Min. advance	BTDC 35°
		Close	Max. retard	ABDC 65°
			Min. advance	ABDC 25°
	Exhaust valve timing	Open		BBDC 55°
		Close		ATDC 5°
	Valve clearance mm (in)	Intake		0.20±0.02 (0.0079±0.0008)
		Exhaust		0.35±0.02 (0.0138±0.0008)
	Idling speed [at neutral position on MT, or “P” or “N” position on AT] rpm		No load	750±100
			A/C ON	800±100 (MT model) 825±100 (AT model)
	Ignition order			1 → 3 → 2 → 4
	Ignition timing BTDC/rpm	MT model		12°±10°/750
		AT model		17°±10°/750

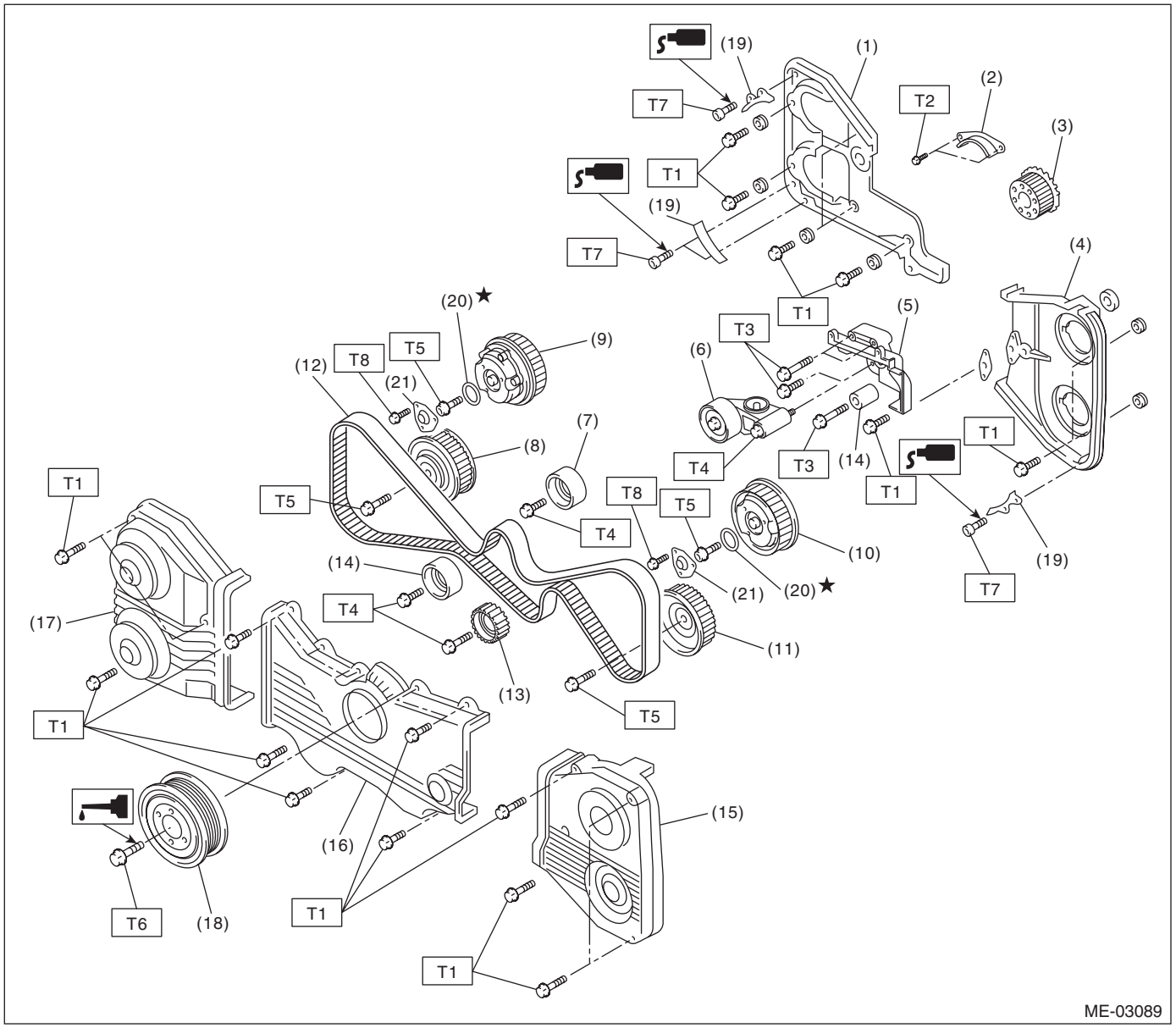
NOTE:
OS: Oversize US: Undersize

Belt tension adjuster	Protrusion of adjuster rod		mm (in)	5.2 — 6.2 (0.205 — 0.244)
Belt tensioner	Spacer O.D.		mm (in)	17.955 — 17.975 (0.7069 — 0.7077)
	Tensioner bushing I.D.		mm (in)	18.0 — 18.08 (0.7087 — 0.7118)
	Clearance between spacer and bushing	mm (in)	Standard	0.025 — 0.125 (0.0010 — 0.0049)
	Side clearance of spacer	mm (in)	Standard	0.2 — 0.55 (0.0079 — 0.0217)
Camshaft	Bending limit		mm (in)	0.020 (0.00079)
	Thrust clearance	mm (in)	Standard	0.068 — 0.116 (0.0027 — 0.0047)
	Cam lobe height mm (in)	Intake	Standard	46.55 — 46.65 (1.833 — 1.837)
		Exhaust	Standard	46.75 — 46.85 (1.841 — 1.844)
	Journal O.D. mm (in)	Standard	Front	37.946 — 37.963 (1.4939 — 1.4946)
			Center rear	29.946 — 29.963 (1.1790 — 1.1796)
	Journal clearance	mm (in)	Standard	0.037 — 0.072 (0.0015 — 0.0028)
Cylinder head	Surface warpage limit		mm (in)	0.035 (0.0014)
	Grinding limit		mm (in)	0.3 (0.012)
	Standard height		mm (in)	127.5 (5.02)
Valve seat	Seating angle			90°
	Contacting width mm (in)	Intake	Standard	0.6 — 1.4 (0.024 — 0.055)
		Exhaust	Standard	1.2 — 1.8 (0.047 — 0.071)
Valve guide	Inside diameter		mm (in)	6.000 — 6.012 (0.2362 — 0.2367)
	Protrusion above head		mm (in)	15.8 — 16.2 (0.622 — 0.638)
Valve	Head edge thickness mm (in)	Intake	Standard	1.0 — 1.4 (0.039 — 0.055)
		Exhaust	Standard	1.3 — 1.7 (0.051 — 0.067)
	Stem outer diameter mm (in)	Intake		5.955 — 5.970 (0.2344 — 0.2350)
		Exhaust		5.945 — 5.960 (0.2341 — 0.2346)
	Valve stem gap mm (in)	Standard	Intake	0.030 — 0.057 (0.0012 — 0.0022)
			Exhaust	0.040 — 0.067 (0.0016 — 0.0026)
	Overall length mm (in)	Intake		104.4 (4.110)
		Exhaust		104.65 (4.1201)
Valve spring	Free length		mm (in)	47.32 (1.863)
	Squareness			2.5°, 2.1 mm (0.083 in) or less
	Tension/spring height	N (kgf, lb)/mm (in)	Set	205 — 235 (20.9 — 24.0, 46.1 — 52.8)/36.0 (1.417)
			Lift	426 — 490 (43.4 — 50.0, 95.8 — 110)/26.50 (1.043)
Valve lifter	Outer diameter	mm (in)	Standard	34.959 — 34.975 (1.3763 — 1.3770)
	Inner diameter (cylinder head)	mm (in)	Standard	34.990 — 35.016 (1.3777 — 1.3786)
	Valve lifter clearance	mm (in)	Standard	0.019 — 0.057 (0.0007 — 0.0022)
Cylinder block	Surface warpage limit (Mating surface with cylinder head)		mm (in)	0.025 (0.0098)
	Grinding limit		mm (in)	0.1 (0.004)
	Standard height		mm (in)	201.0 (7.91)
	Cylinder inner diameter mm (in)	Standard	A	99.505 — 99.515 (3.9175 — 3.9179)
			B	99.495 — 99.505 (3.9171 — 3.9175)
	Taper	mm (in)	Standard	0.015 (0.0006)
	Out-of-roundness	mm (in)	Standard	0.010 (0.0004)
	Piston clearance	mm (in)	Standard	–0.010 — 0.010 (–0.00039 — 0.00039)
	Cylinder inner diameter boring limit (diameter)		mm (in)	To 100.005 (3.9372)

Piston	Outer diameter mm (in)		Standard	A	99.505 — 99.515 (3.9175 — 3.9179)
				B	99.495 — 99.505 (3.9171 — 3.9175)
			0.25 (0.0098) OS		99.745 — 99.765 (3.9270 — 3.9278)
			0.50 (0.0197) OS		99.995 — 100.015 (3.9368 — 3.9376)
Piston pin	Standard clearance between piston and piston pin mm (in)			Standard	0.004 — 0.008 (0.0002 — 0.0003)
	Degree of fit				Piston pin must be fitted into position with thumb at 20°C (68°F).
Piston ring	Ring closed gap mm (in)		Top ring	Standard	0.20 — 0.25 (0.0079 — 0.0098)
			Second ring	Standard	0.37 — 0.52 (0.015 — 0.0203)
			Oil ring	Standard	0.20 — 0.50 (0.0079 — 0.0197)
	Ring groove gap mm (in)		Top ring	Standard	0.040 — 0.080 (0.0016 — 0.0031)
			Second ring	Standard	0.030 — 0.070 (0.0012 — 0.0028)
Connecting rod	Bend or twist per 100 mm (3.94 in) in length mm (in)			Limit	0.10 (0.0039)
	Thrust clearance mm (in)			Standard	0.070 — 0.330 (0.0028 — 0.0130)
Bearing of large end	Oil clearance mm (in)			Standard	0.017 — 0.045 (0.0007 — 0.0018)
	Bearing size (Thickness at center) mm (in)		Standard		1.490 — 1.502 (0.0587 — 0.0591)
			0.03 (0.0012) US		1.504 — 1.512 (0.0592 — 0.0595)
			0.05 (0.0020) US		1.514 — 1.522 (0.0596 — 0.0599)
			0.25 (0.0098) US		1.614 — 1.622 (0.0635 — 0.0639)
Bushing of small end	Clearance between piston pin and bushing mm (in)			Standard	0 — 0.022 (0 — 0.0009)
Crankshaft	Bending limit mm (in)				0.035 (0.0014)
	Crank pin	Out-of-roundness mm (in)			0.003 (0.0001)
		Cylindricality mm (in)			0.004 (0.0002)
		Grinding limit (dia.) mm (in)			To 51.750 (2.0374)
	Crank journal	Out-of-roundness mm (in)			0.005 (0.0002)
		Cylindricality mm (in)			0.006 (0.0002)
		Grinding limit (dia.) mm (in)			To 59.758 (2.3527)
	Crank pin outer diameter mm (in)		Standard		51.984 — 52.000 (2.0466 — 2.0472)
			0.03 (0.0012) US		51.954 — 51.970 (2.0454 — 2.0461)
			0.05 (0.0020) US		51.934 — 51.950 (2.0447 — 2.0453)
			0.25 (0.0098) US		51.734 — 51.750 (2.0368 — 2.0374)
	Crank journal outer diameter mm (in)		Standard		59.992 — 60.008 (2.3619 — 2.3625)
			0.03 (0.0012) US		59.962 — 59.978 (2.3607 — 2.3613)
			0.05 (0.0020) US		59.942 — 59.958 (2.3599 — 2.3605)
			0.25 (0.0098) US		59.742 — 59.758 (2.3520 — 2.3527)
	Thrust clearance mm (in)			Standard	0.030 — 0.115 (0.0012 — 0.0045)
	Oil clearance mm (in)				0.010 — 0.030 (0.0004 — 0.0012)
Main bearing	Bearing size (Thickness at center) mm (in)	#1, #3	Standard		1.998 — 2.011 (0.0787 — 0.0792)
			0.03 (0.0012) US		2.017 — 2.020 (0.0794 — 0.0795)
			0.05 (0.0020) US		2.027 — 2.030 (0.0798 — 0.0799)
			0.25 (0.0098) US		2.127 — 2.130 (0.0837 — 0.0839)
		#2, #4, #5	Standard		2.000 — 2.013 (0.0787 — 0.0793)
			0.03 (0.0012) US		2.019 — 2.022 (0.0795 — 0.0796)
			0.05 (0.0020) US		2.029 — 2.032 (0.0799 — 0.0800)
			0.25 (0.0098) US		2.129 — 2.132 (0.0838 — 0.0839)

B: COMPONENT

1. TIMING BELT

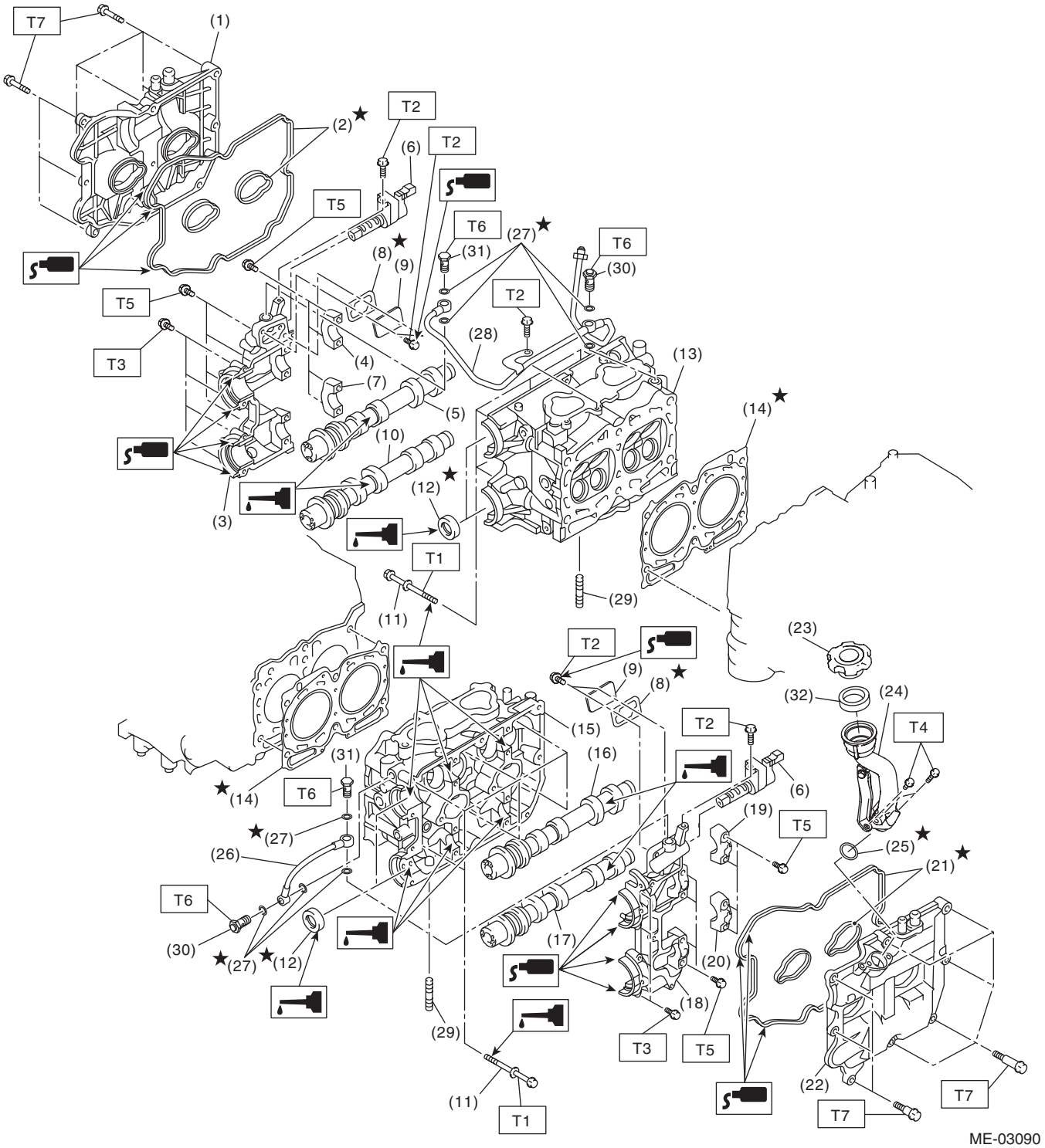


(1) Timing belt cover No. 2 (RH)
(2) Timing belt guide (MT model)
(3) Crank sprocket
(4) Timing belt cover No. 2 (LH)
(5) Tensioner bracket
(6) Automatic belt tension adjuster ASSY
(7) Belt idler
(8) Exhaust cam sprocket (RH)
(9) Intake cam sprocket (RH)
(10) Intake cam sprocket (LH)
(11) Exhaust cam sprocket (LH)
(12) Timing belt
(13) Belt idler No. 2
(14) Belt idler
(15) Timing belt cover (LH)
(16) Front belt cover
(17) Timing belt cover (RH)
(18) Crank pulley
(19) Timing belt guide (MT model)
(20) O-ring
(21) Actuator cover

Tightening torque:N·m (kgf-m, ft-lb)

T1: 5 (0.5, 3.6)
T2: 9.75 (1.0, 7.2)
T3: 24.5 (2.5, 18.1)
T4: 39 (4.0, 28.9)
T5: <Ref. to ME(H4DOTC)-51, INSTALLATION, Cam Sprocket.>
T6: <Ref. to ME(H4DOTC)-40, INSTALLATION, Crank Pulley.>
T7: 6.4 (0.65, 4.7)
T8: 3.4 (0.3, 2.5)

2. CYLINDER HEAD AND CAMSHAFT

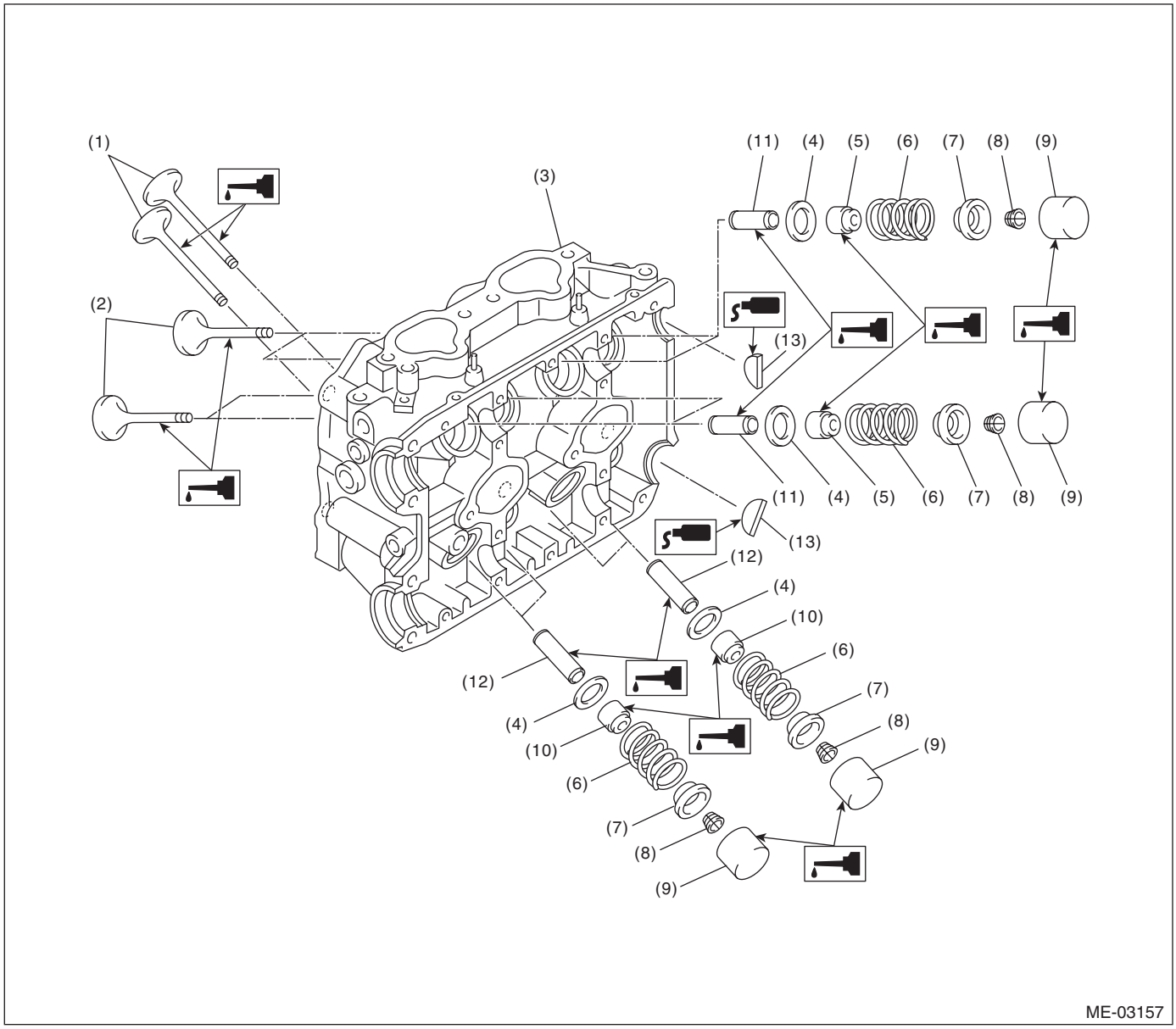


(1) Rocker cover (RH)
(2) Rocker cover gasket (RH)
(3) Camshaft cap (Front RH)
(4) Intake camshaft cap (Rear RH)
(5) Intake camshaft (RH)
(6) Oil flow control solenoid valve
(7) Exhaust camshaft cap (Rear RH)
(8) Gasket
(9) Oil return cover
(10) Exhaust camshaft (RH)
(11) Cylinder head bolt
(12) Oil seal
(13) Cylinder head (RH)
(14) Cylinder head gasket
(15) Cylinder head (LH)
(16) Intake camshaft (LH)
(17) Exhaust camshaft (LH)
(18) Camshaft cap (Front LH)
(19) Intake camshaft cap (Rear LH)
(20) Exhaust camshaft cap (Rear LH)
(21) Rocker cover gasket (LH)
(22) Rocker cover (LH)
(23) Oil filler cap
(24) Oil filler duct
(25) O-ring
(26) Oil pipe (LH)
(27) Gasket
(28) Oil pipe (RH)
(29) Stud bolt
(30) Union screw with filter (with protrusion)
(31) Union screw without filter (without protrusion)
(32) Gasket

Tightening torque:N·m (kgf-m, ft-lb)

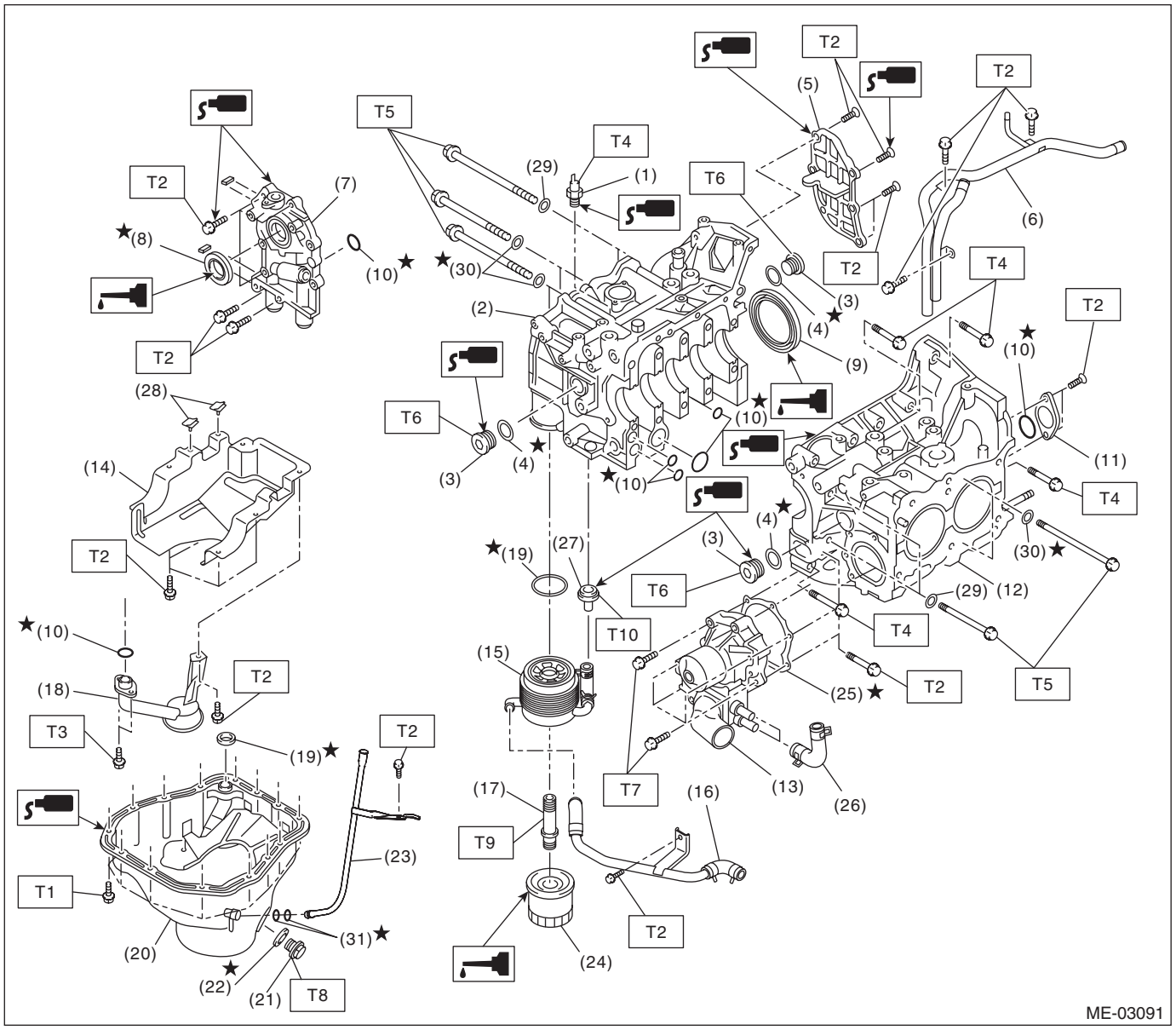
T1: ***<Ref. to ME(H4DOTC)-58, INSTALLATION, Cylinder Head.>***
T2: ***8 (0.8, 5.9)***
T3: ***<Ref. to ME(H4DOTC)-54, INSTALLATION, Camshaft.>***
T4: ***6.4 (0.65, 4.7)***
T5: ***<Ref. to ME(H4DOTC)-54, INSTALLATION, Camshaft.>***
T6: ***29 (3.0, 21.4)***
T7: ***<Ref. to ME(H4DOTC)-54, INSTALLATION, Camshaft.>***

3. CLINDER HEAD AND VALVE ASSEMBLY



(1) Exhaust valve
(2) Intake valve
(3) Cylinder head
(4) Valve spring seat
(5) Intake valve oil seal
(6) Valve spring
(7) Retainer
(8) Retainer key
(9) Valve lifter
(10) Exhaust valve oil seal
(11) Intake valve guide
(12) Exhaust valve guide
(13) Plug

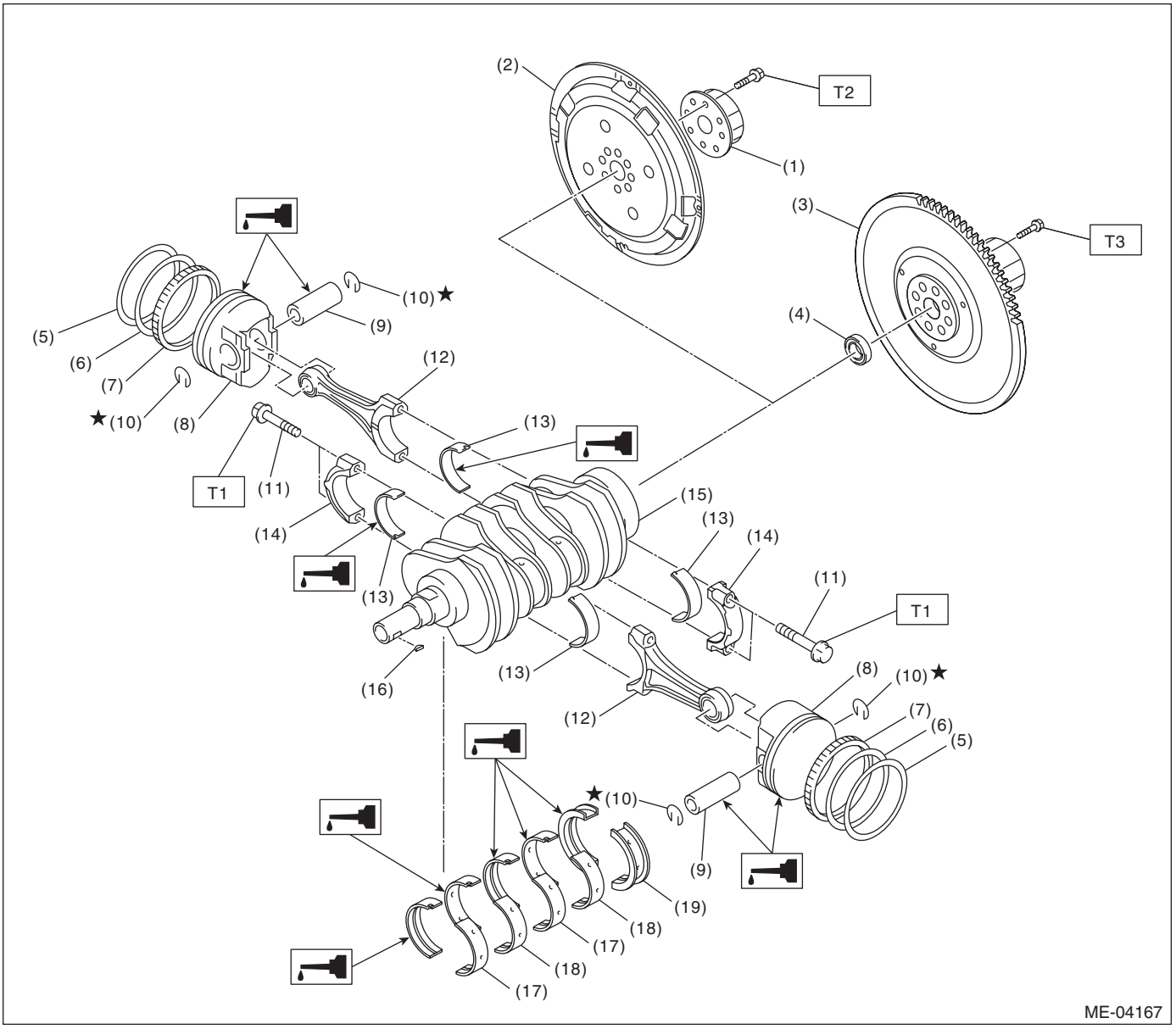
4. CYLINDER BLOCK



(1) Oil pressure switch
(2) Cylinder block (RH)
(3) Service hole plug
(4) Gasket
(5) Oil separator cover
(6) Water by-pass pipe
(7) Oil pump
(8) Front oil seal
(9) Rear oil seal
(10) O-ring
(11) Service hole cover
(12) Cylinder block (LH)
(13) Water pump
(14) Baffle plate
(15) Oil cooler
(16) Water by-pass pipe
(17) Connector
(18) Oil strainer
(19) Gasket
(20) Oil pan
(21) Drain plug
(22) Metal gasket
(23) Oil level gauge guide
(24) Oil filter
(25) Gasket
(26) Water pump hose
(27) Plug
(28) Seal
(29) Washer
(30) Seal washer
(31) O-ring

Tightening torque:N·m (kgf-m, ft-lb)	
T1:	*5 (0.5, 3.6)*
T2:	*6.4 (0.65, 4.7)*
T3:	*10 (1.0, 7.2)*
T4:	*25 (2.5, 18.1)*
T5:	*<Ref. to ME(H4DOTC)-68, INSTALLATION, Cylinder Block.>*
T6:	*70 (7.1, 51.6)*
T7:	*First 12 (1.2, 8.9) Second 12 (1.2, 8.9)*
T8:	*44 (4.5, 33)*
T9:	*54 (5.5, 40)*
T10:	*69 (7.0, 50.9)*

5. CRANKSHAFT AND PISTION



(1) Reinforcement (AT model)
(2) Drive plate (AT model)
(3) Flywheel (MT model)
(4) Ball bearing (MT model)
(5) Top ring
(6) Second ring
(7) Oil ring
(8) Piston
(9) Piston pin
(10) Snap ring
(11) Connecting rod bolt
(12) Connecting rod
(13) Connecting rod bearing
(14) Connecting rod cap
(15) Crankshaft
(16) Woodruff key
(17) Crankshaft bearing #1, #3
(18) Crankshaft bearing #2, #4
(19) Crankshaft bearing #5

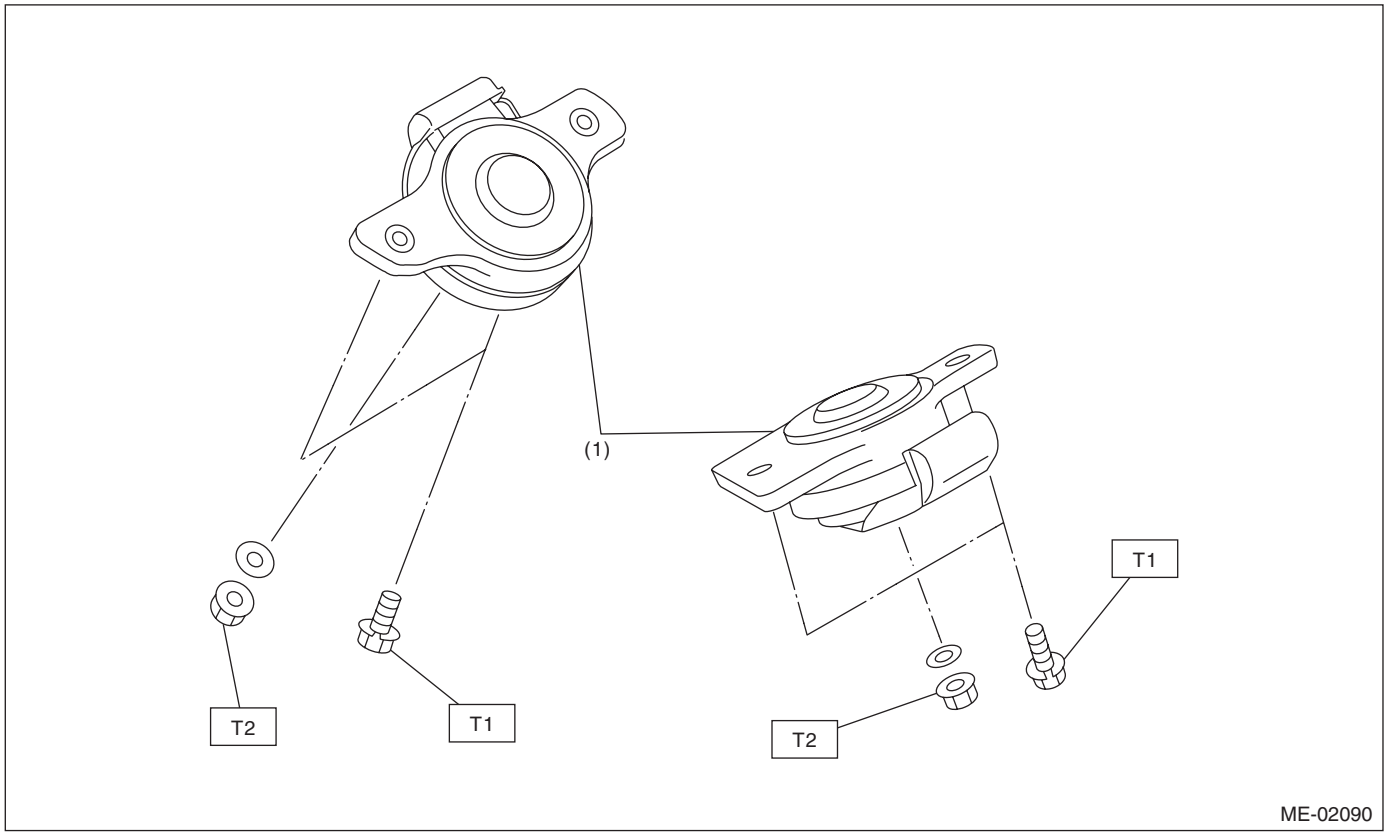
Tightening torque:N·m (kgf-m, ft-lb)

T1: 52 (5.3, 38.4)

T2: <Ref. to 5AT-65, INSTALLATION, Drive Plate.>

T3: <Ref. to CL-16, INSTALLATION, Flywheel.>

6. ENGINE MOUNTING



(1) Front cushion rubber

Tightening torque:N·m (kgf-m, ft-lb)
T1: 35 (3.6, 25.8)
T2: 85 (8.7, 62.7)

C: CAUTION

- Wear appropriate work clothing, including a cap, protective goggles and protective shoes when performing any work.
- Remove contamination including dirt and corrosion before removal, installation or disassembly.
- Keep the disassembled parts in order and protect them from dust and dirt.
- Before removal, installation or disassembly, be sure to clarify the failure. Avoid unnecessary removal, installation, disassembly and replacement.
- Vehicle components are extremely hot after driving. Be wary of receiving burns from heated parts.
- Be sure to tighten fasteners including bolts and nuts to the specified torque.
- Place shop jacks or rigid racks at the specified points.
- Before disconnecting connectors of sensors or units, be sure to disconnect the ground cable from the battery.
- All parts should be thoroughly cleaned, paying special attention to engine oil passages, pistons and bearings.
- Rotating parts and sliding parts such as piston, bearing and gear should be coated with oil prior to assembly.
- Be careful not to let oil, grease or coolant contact the timing belt, clutch disc and flywheel.
- All removed parts, if to be reused, should be reinstalled in the original positions and directions.
- Bolts, nuts and washers should be replaced with new parts as required.
- Even if necessary inspections have been made in advance, proceed with assembly work while making rechecks.
- Remove or install the engine in an area where chain hoists, lifting devices, etc. are available for ready use.
- Be sure not to damage coated surfaces of body panels with tools, or not to stain seats and windows with coolant or oil. Place a cover over fender, as required, for protection.
- Prior to starting work, prepare the following:

Service tools, clean cloth, containers to catch coolant and oil, wire ropes, chain hoist, transmission jacks, etc.

- Lift-up or lower the vehicle when necessary. Make sure to support the correct positions.

D: PREPARATION TOOL

1. SPECIAL TOOL

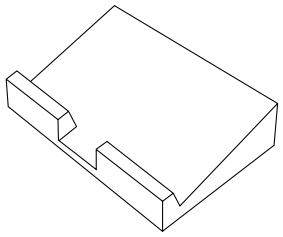
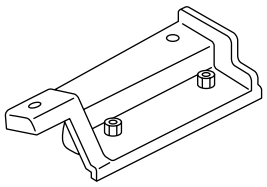
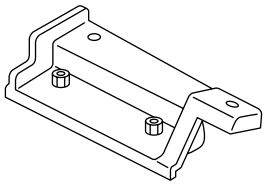
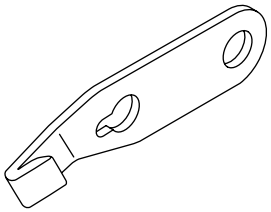
ILLUSTRATION	TOOL NUMBER	DESCRIPTION	REMARKS
 ST-498267600	498267600	CYLINDER HEAD TABLE	• Used for replacing valve guides. • Used for removing and installing valve spring.
 ST-498457000	498457000	ENGINE STAND ADAPTER RH	Used together with the ENGINE STAND (499817100).
 ST-498457100	498457100	ENGINE STAND ADAPTER LH	Used together with the ENGINE STAND (499817100).
 ST-498497100	498497100	CRANKSHAFT STOPPER	Used for removing and installing the flywheel and the drive plate.

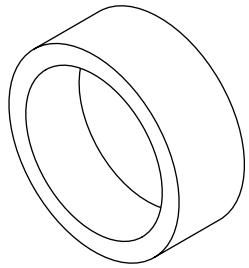
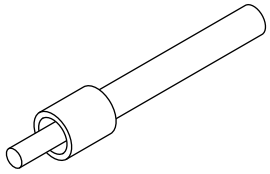
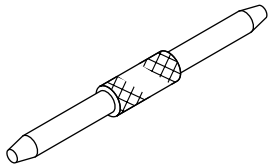
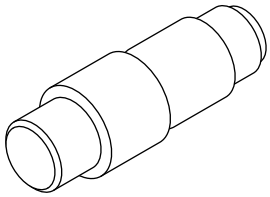
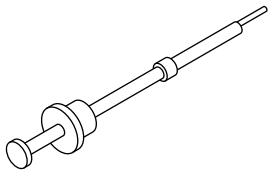
ILLUSTRATION	TOOL NUMBER	DESCRIPTION	REMARKS
 ST-498747300	498747300	PISTON GUIDE	Used for installing the cup to the wheel cylinder piston. (2.5 L model)
 ST-498857100	498857100	VALVE OIL SEAL GUIDE	Used for press-fitting of intake and exhaust valve guide oil seals.
 ST-499017100	499017100	PISTON PIN GUIDE	Used for installing piston pin, piston and connecting rod.
 ST-499037100	499037100	CONNECTING ROD BUSHING REMOVER AND INSTALLER	Used for removing and installing connecting rod bushing.
 ST-499097700	499097700	PISTON PIN REMOVER ASSY	Used for removing piston pin.

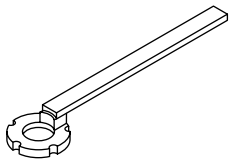
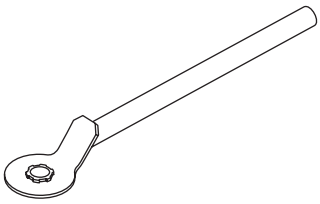
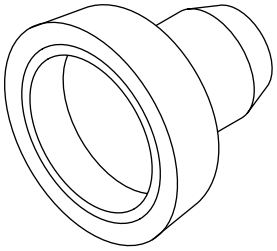
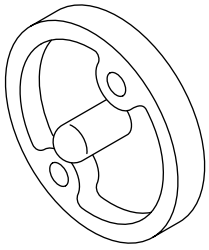
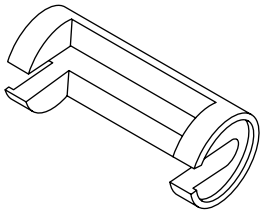
ILLUSTRATION	TOOL NUMBER	DESCRIPTION	REMARKS
 ST-499207400	499207400	CAM SPROCKET WRENCH	Used for removing and installing exhaust cam sprocket.
 ST-499977500	499977500	CAM SPROCKET WRENCH	Used for removing and installing intake cam sprocket.
 ST-499587200	499587200	CRANKSHAFT OIL SEAL INSTALLER	• Used for installing crankshaft oil seal. • Used together with the CRANKSHAFT OIL SEAL GUIDE (499597100).
 ST-499597100	499597100	CRANKSHAFT OIL SEAL GUIDE	• Used for installing crankshaft oil seal. • Used together with the CRANKSHAFT OIL SEAL INSTALLER (499587200).
 ST-499718000	499718000	VALVE SPRING REMOVER	Used for removing and installing valve spring.

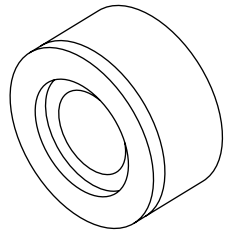
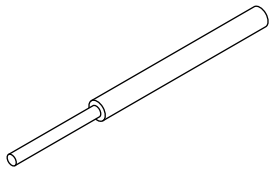
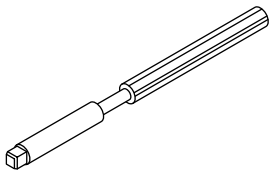
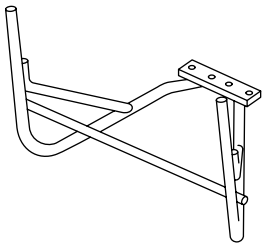
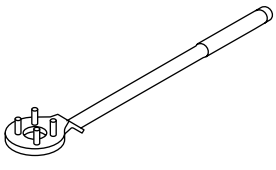
ILLUSTRATION	TOOL NUMBER	DESCRIPTION	REMARKS
 ST18251AA020	18251AA020	VALVE GUIDE ADJUSTER	Used for installing intake and exhaust valve guides.
 ST-499767200	499767200	VALVE GUIDE REMOVER	Used for removing valve guides.
 ST-499767400	499767400	VALVE GUIDE REAMER	Used for reaming valve guides.
 ST-499817100	499817100	ENGINE STAND	• Stand used for engine disassembly and assembly. • Used together with the ENGINE STAND ADAPTER RH (498457000) & LH (498457100).
 ST-499977100	499977100	CRANK PULLEY WRENCH	Used for stopping rotation of crank pulley when loosening/tightening crank pulley bolt.

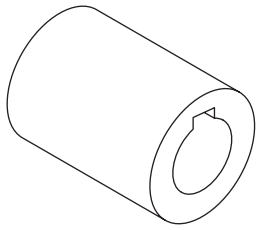
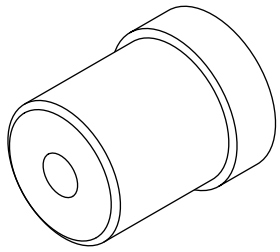
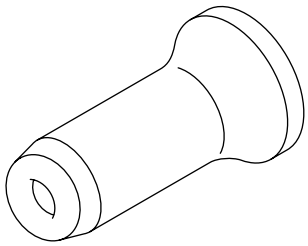
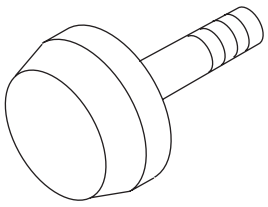
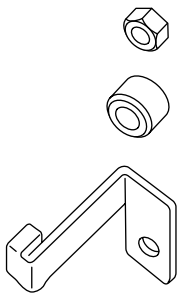
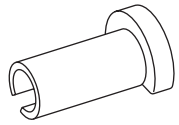
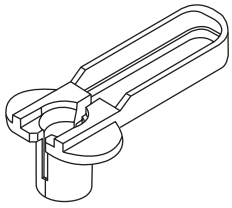
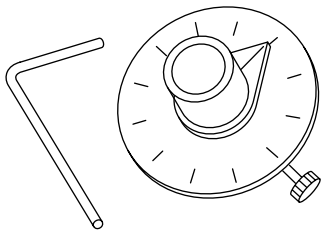
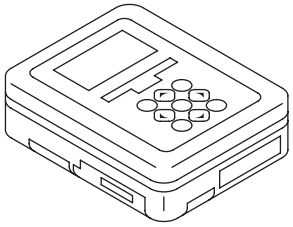
ILLUSTRATION	TOOL NUMBER	DESCRIPTION	REMARKS
 ST-499987500	499987500	CRANKSHAFT SOCKET	Used for rotating crankshaft.
 ST-499587100	499587100	OIL SEAL INSTALLER	Used for installing oil pump oil seal.
 ST-499587600	499587600	OIL SEAL INSTALLER	Used for installing camshaft oil seal for DOHC engine.
 ST-499597200	499597200	OIL SEAL GUIDE	• Used for installing camshaft oil seal for DOHC engine. • Used together with the OIL SEAL INSTALLER (499587600).
 ST-498277200	498277200	STOPPER SET	Used for installing automatic transmission assembly to engine.

ILLUSTRATION	TOOL NUMBER	DESCRIPTION	REMARKS
 ST42099AE000	42099AE000	CONNECTOR REMOVER	Used for disconnecting quick connector of the engine compartment.
 ST18371AA000	18371AA000 (Newly adopted tool)	CONNECTOR REMOVER	Used for disconnecting the quick connector on the fuel return hose of the engine compartment.
 ST18854AA000	18854AA000	ANGLE GAUGE	Used for installing the crank pulley.
 ST1B020XU0	1B020XU0	SUBARU SELECT MONITOR KIT	Used for troubleshooting the electrical system.

2. GENERAL TOOL

TOOL NAME	REMARKS
Compression gauge	Used for measuring compression.
Timing light	Used for measuring ignition timing.
Vacuum gauge	Used for measuring intake manifold vacuum.
Oil pressure gauge	Used for measuring engine oil pressure.
Fuel pressure gauge	Used for measuring fuel pressure.

E: PROCEDURE

It is possible to conduct the following service procedures with engine on vehicle, however, the procedures described in this section are based on the condition that the engine is removed from vehicle.

- V-belt
- Timing belt
- Camshaft
- Cylinder head