

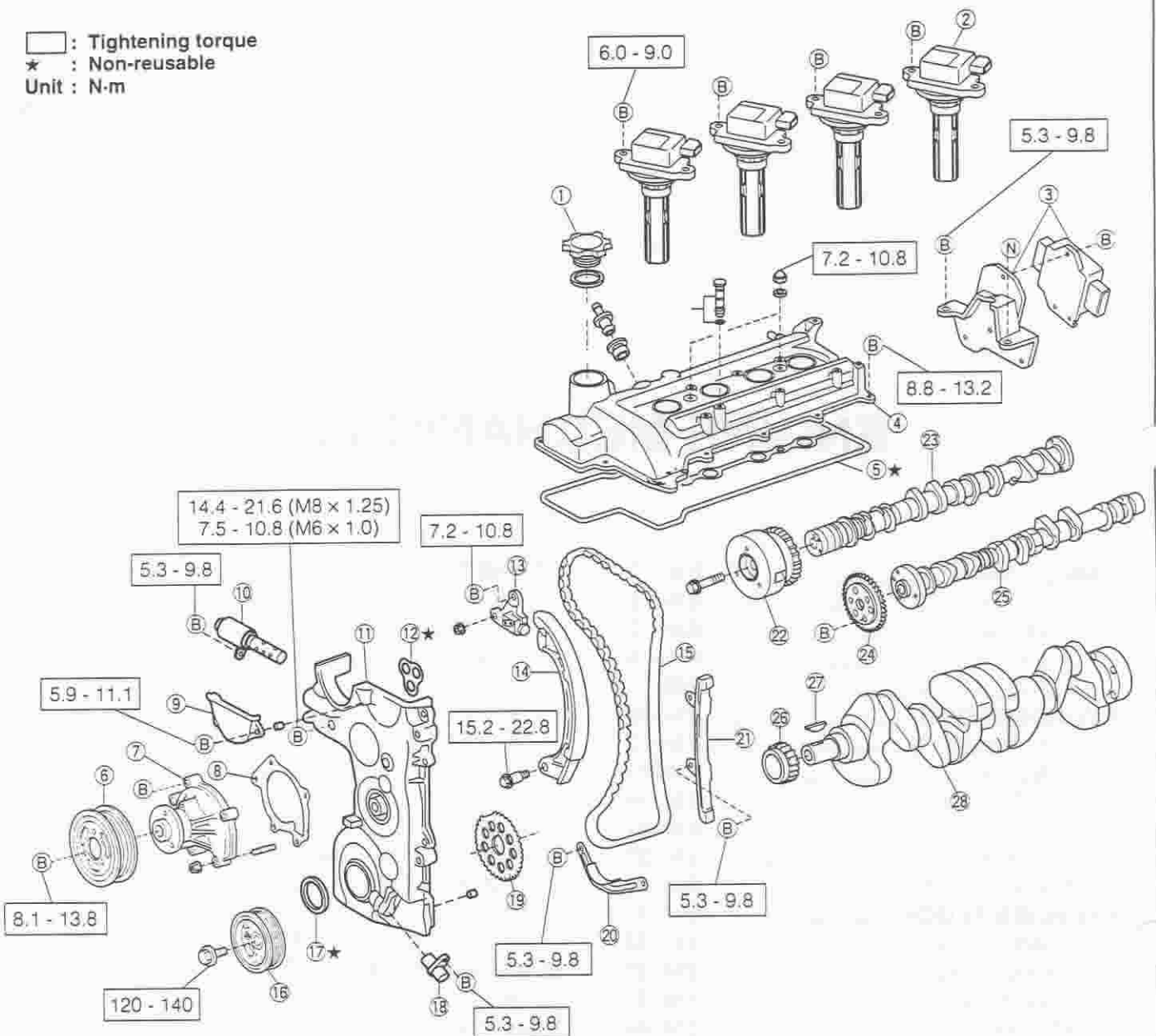
# ENGINE MECHANICAL

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JEM00001-00000

## TIMING CHAIN COMPONENTS

□ : Tightening torque  
★ : Non-reusable  
Unit : N·m

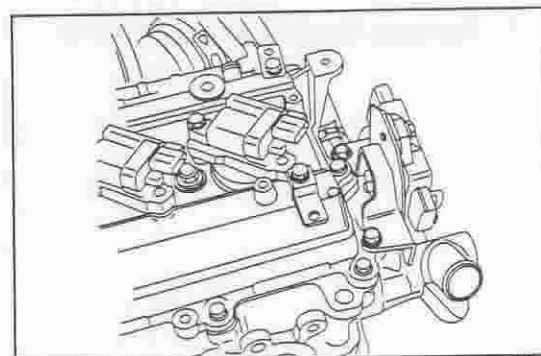


- ① Oil filler cap
- ② Ignition coil
- ③ Igniter assy
- ④ Cylinder head cover
- ⑤ Cylinder head cover gasket
- ⑥ Water pump pulley
- ⑦ Water pump
- ⑧ Water pump gasket
- ⑨ Timing chain cover No. 2
- ⑩ Oil control valve
- ⑪ Timing chain cover
- ⑫ Timing chain cover gasket
- ⑬ Timing chain tensioner
- ⑭ Tensioner arm

- ⑮ Timing chain
- ⑯ Crankshaft pulley
- ⑰ Type T oil seal
- ⑱ Crank angle sensor
- ⑲ Crank angle sensor plate
- ⑳ Timing chain guide No. 2
- ㉑ Timing chain guide
- ㉒ Valve timing controller
- ㉓ Camshaft No. 1
- ㉔ Camshaft No. 2 sprocket
- ㉕ Camshaft No. 2
- ㉖ Camshaft sprocket
- ㉗ key
- ㉘ Crankshaft

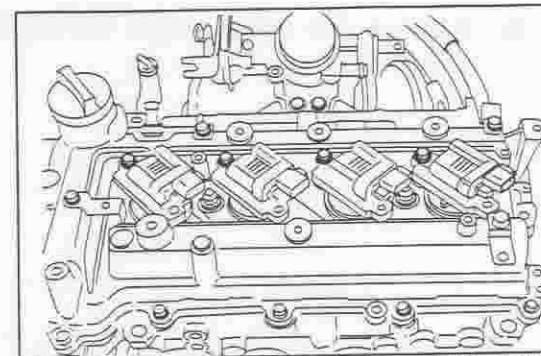
## REMOVAL

1. Remove the drive belt. (Refer to the CH section.)
2. Remove the ignitor assembly. (European specifications only)



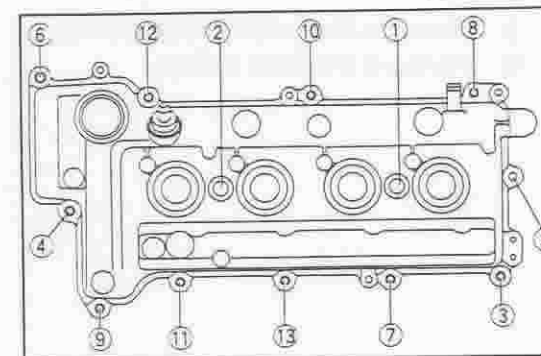
JEM00003-00002

3. Remove the ignition coil from the cylinder head cover.



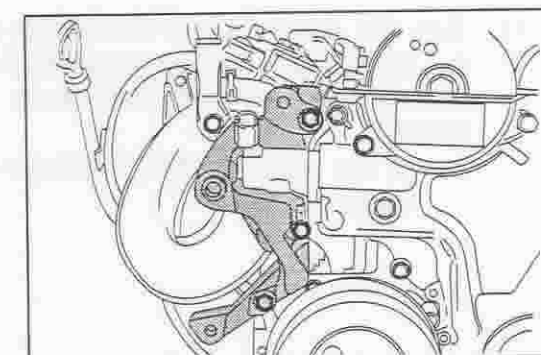
JEM00004-00003

4. Remove the cylinder head cover and gasket by removing the retaining bolts and nuts in the sequence shown in the right figure.



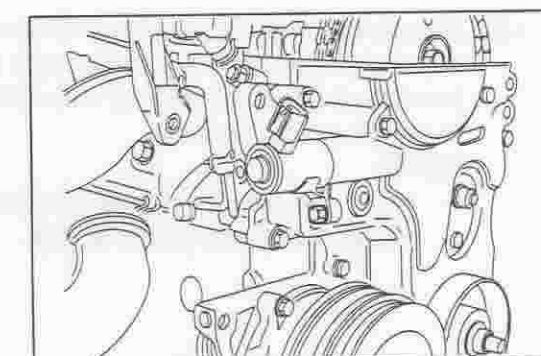
JEM00005-00004

5. Remove the alternator bracket.



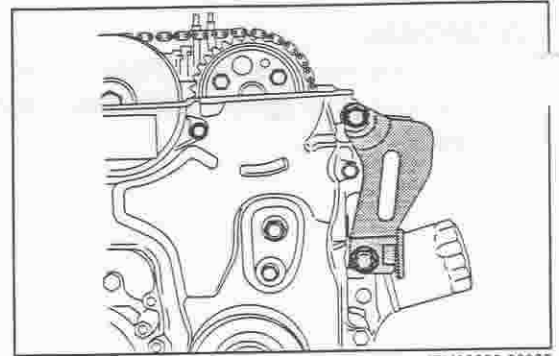
JEM00006-00005

6. Remove the oil control valve from the timing chain cover.



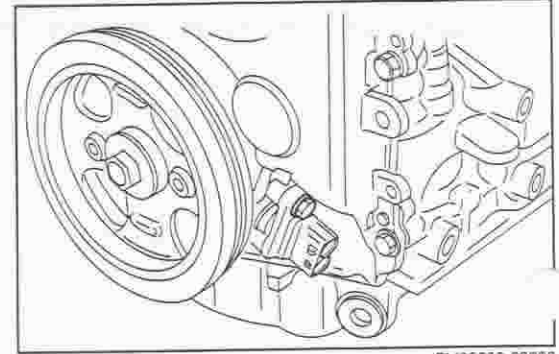
JEM00007-00006

7. Remove the idler pulley bracket.



JEM00008-00007

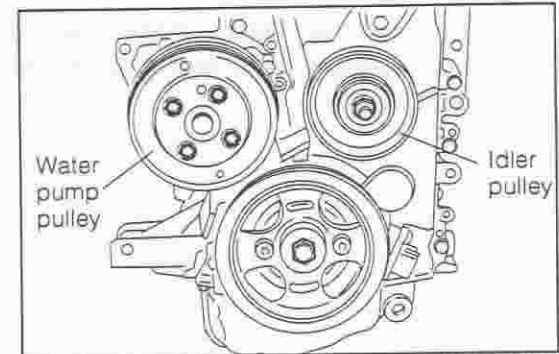
8. Remove the crank angle sensor from the timing chain cover.



JEM00009-00008

9. Remove the water pump pulley.

10. Remove the idler pulley.

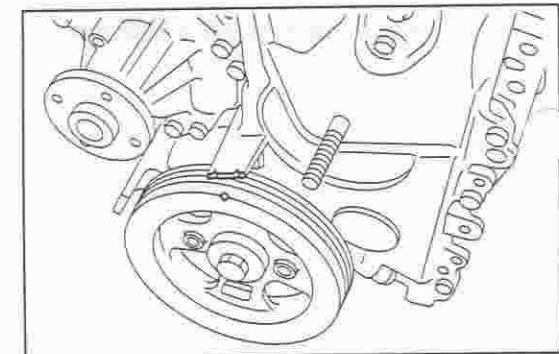


JEM00010-00009

11. Turn the crankshaft in the engine rotating direction, until the timing mark on the crankshaft pulley is aligned with the indicator on the timing chain cover.

**NOTE:**

- At this point, the No. 1 cylinder assumes the top dead center.

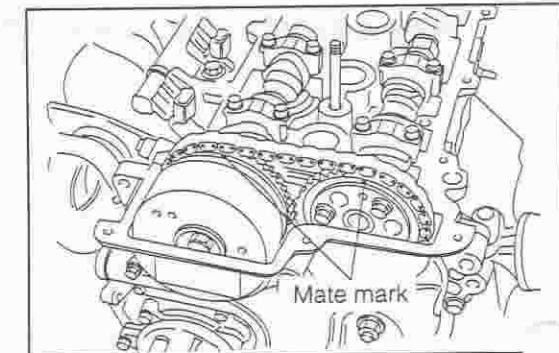


JEM00011-00010

12. Ensure that the mate mark on the camshaft timing sprocket points upward. If the mate mark does not point upward, turn the crankshaft another one turn. And ensure that now the mark points upward.

**NOTE:**

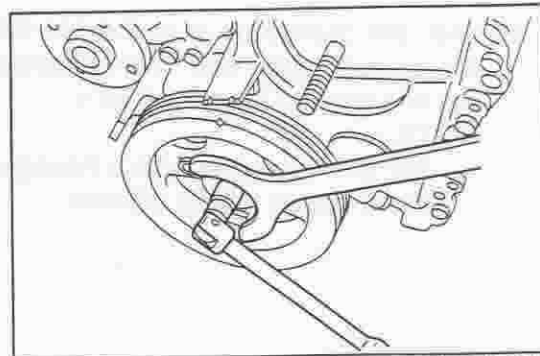
- Now, the No. 1 cylinder assumes the top dead center under the compression stroke.



JEM00012-00011

13. Remove the crankshaft pulley by removing the pulley bolt, while preventing the crankshaft pulley from being turned, using the following SST.

SST: 09278-87201-000



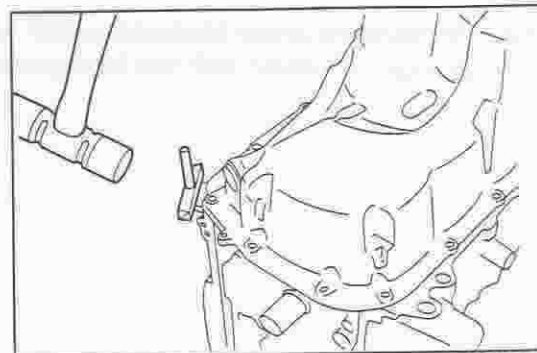
JEM00013-00012

14. Removal of oil pan.

(1) Loosen the attaching bolts and nuts of the oil pan over two or three stages. Pull out the bolts and nuts.

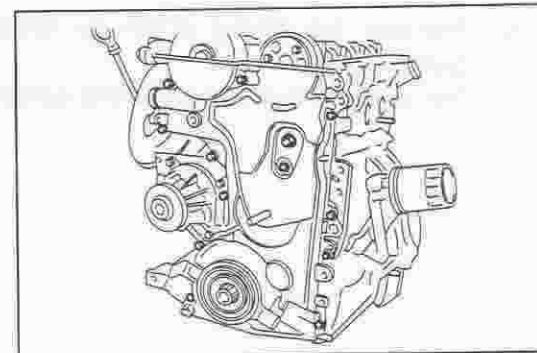
(2) Separate the oil pan from the cylinder block by driving the following SST into between the cylinder block and the oil pan.

SST: 09032-00100-000



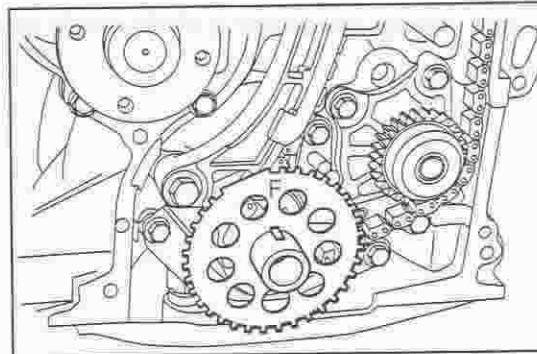
JEM00230-00215

15. Remove the timing chain cover by removing the retaining bolts and nuts.



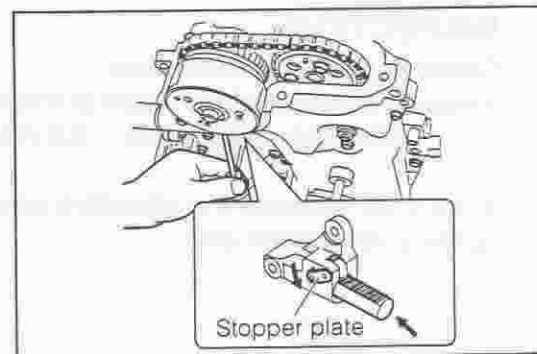
JEM00014-00013

16. Remove the crank angle sensor plate.



JEM00015-00014

17. Move the chain tensioner stopper plate downward. Under this unlocked state, push in the plunger deeply.

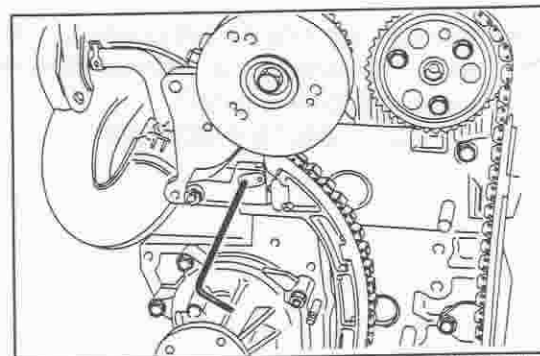


JEM00016-00015

18. With the plunger in a pushed-in state, align the holes of the stopper plate and chain tensioner. Insert a hexagonal rod wrench into place to lock it.

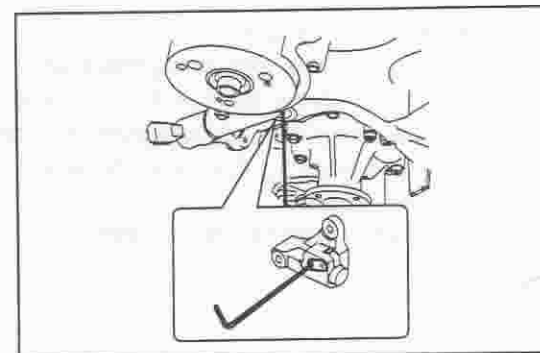
**NOTE:**

- For this operation, use a hexagonal rod wrench whose width across flats is 2.5 mm.



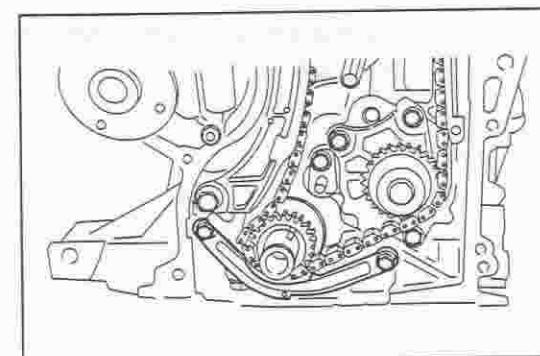
JEM00017-00016

19. Remove the chain tensioner under a condition in which the plunger is locked with the hexagonal rod wrench inserted.

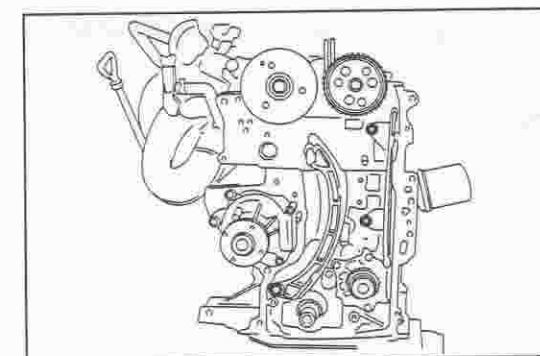


JEM00018-00017

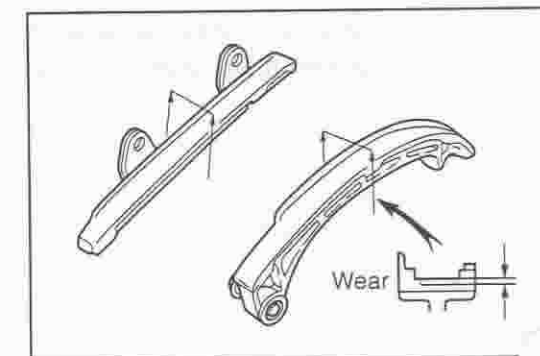
20. Remove the timing chain by removing the timing chain guide No. 2.
21. Remove the crankshaft timing sprocket.



JEM00019-00018



JEM00020-00019



JEM00021-

22. Remove the timing chain guide and timing chain arm.

## INSPECTION

### Chain Guide and Chain Arm

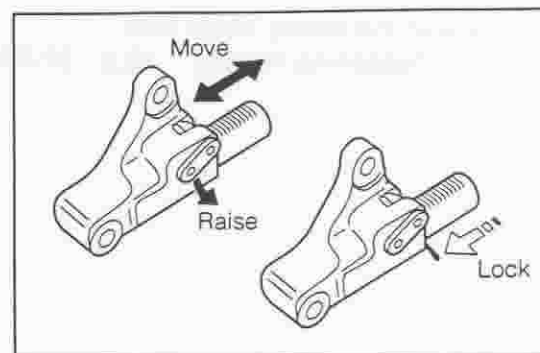
Measure the wear of the chain guide and arm.

Allowable Wear Limit: 0.5 mm

If the wear exceeds the allowable wear limit, replace the chain guide and/or chain arm.

### Chain Tensioner

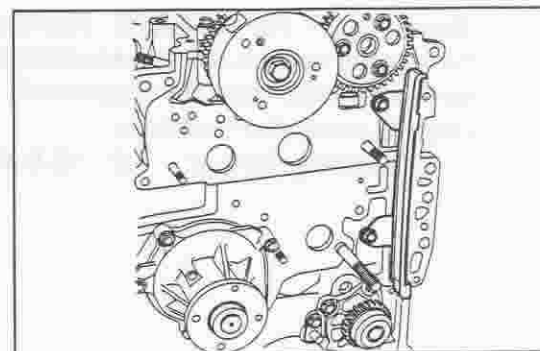
1. Depress the stopper plate with your finger. Ensure that the plunger moves smoothly.
2. When your finger is released from the stopper plate, ensure that the stopper plate is locked. Under this state, the plunger will not move, even if the plunger is moved with your finger.



JEM00022-00021

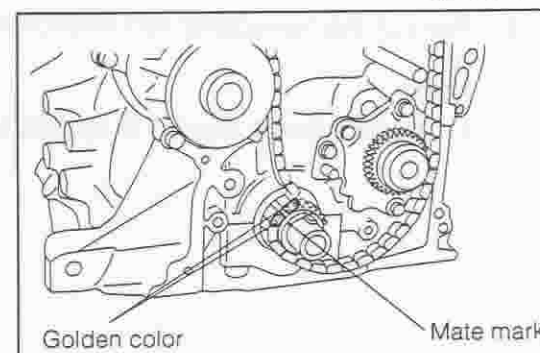
### INSTALLATION

1. Install the timing chain guide.  
Tightening Torque: 5.3 - 9.8 N·m



JEM00023-00022

2. Assemble the crankshaft timing sprocket.
3. Align the mate mark of the timing chain mark plate (golden color) with the mate mark of the crankshaft timing sprocket. Proceed to install the timing chain.

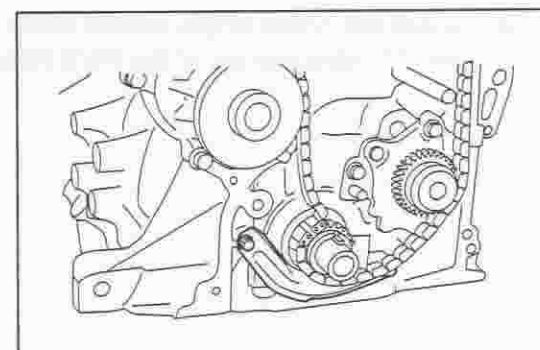


JEM00024-00023

4. Install the timing chain guide No. 2.  
Tightening Torque: 5.3 - 9.8 N·m

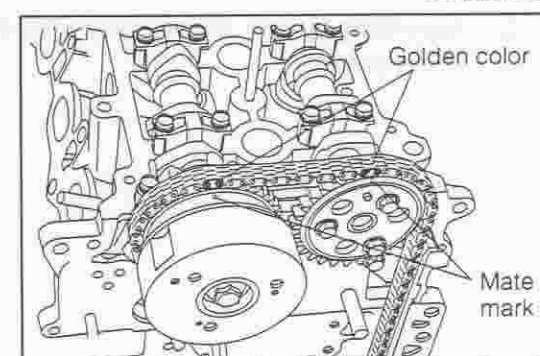
#### NOTE:

- After the timing chain guide No. 2 has been installed in place, the chain teeth of the crankshaft timing sprocket section will not jump up.



JEM00025-00024

5. Align the mate mark of the timing chain mark plate (golden color) with the mate mark of the camshaft timing sprocket. Proceed to install the timing chain.

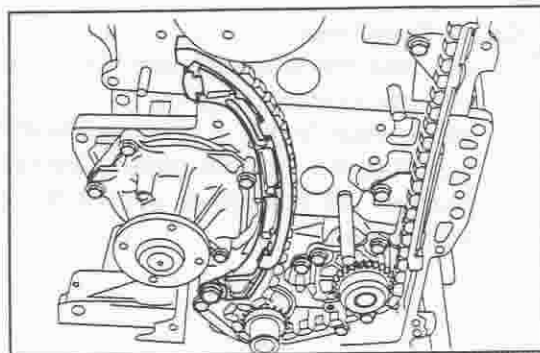


JEM00026-00025

## EM-8

6. Install the timing chain arm.

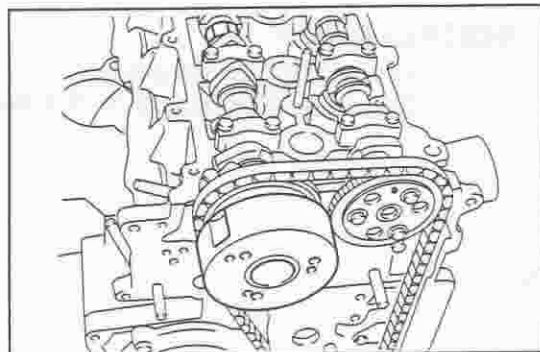
Tightening Torque: 15.2 - 22.8 N·m



JEM00027-00026

7. Slightly turn the camshaft counterclockwise, using the hexagonal section of the camshaft so that the chain at the tensioner side may be slackened. Under this state, proceed to install the tensioner.

Tightening Torque: 7.2 - 10.8 N·m

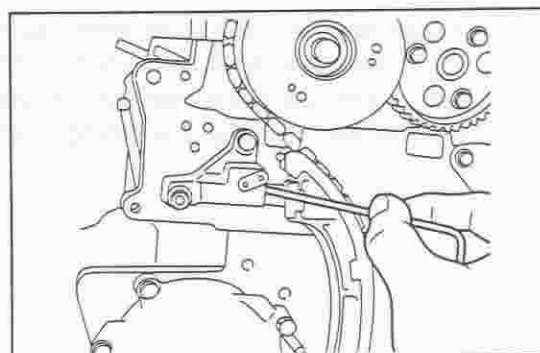


JEM00028-00027

8. Pull out the hexagonal rod wrench from the chain tensioner.

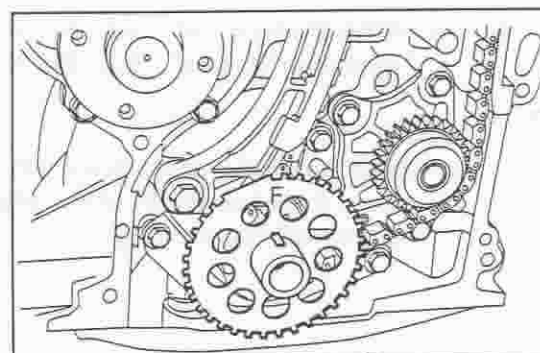
**NOTE:**

- Ensure that a tension is applied to the timing chain.



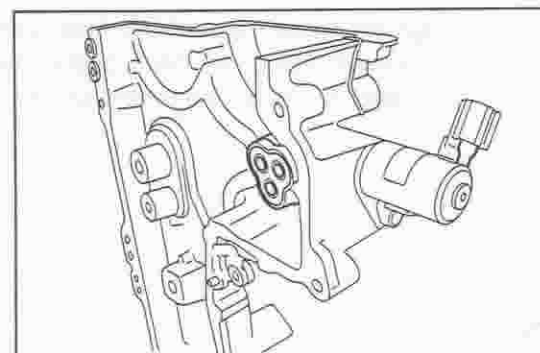
JEM00029-00028

9. Install the crank angle sensor plate in such a direction that the "F" mark comes at the front side.



JEM00030-00029

10. Assemble a new timing chain cover gasket on the timing chain cover.



JEM00031-00030



11. Apply liquid gasket at those points shown in the figure below. Install the timing chain cover.

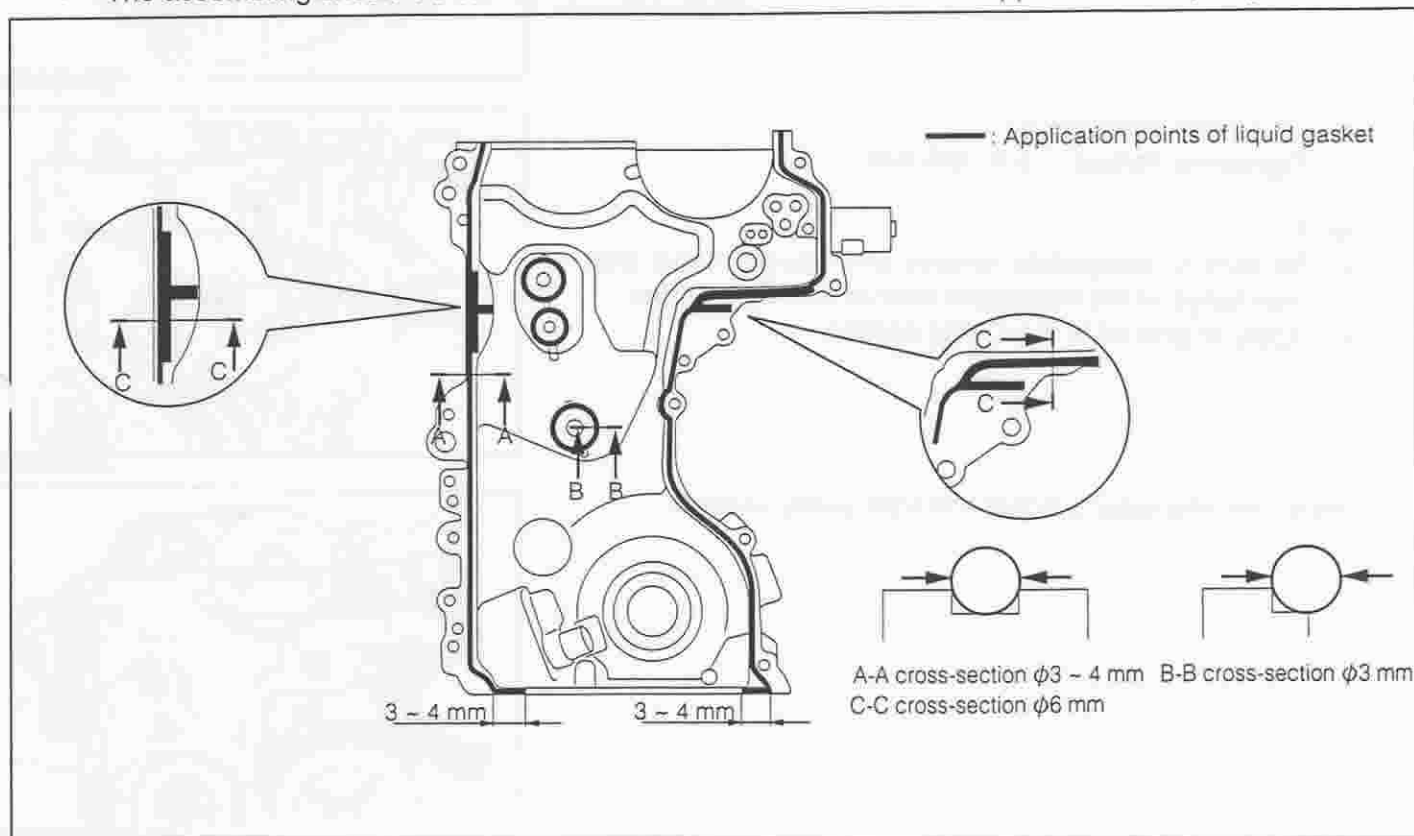
Tightening Torque: 14.4 - 21.6 N·m (M8 × 1.25)

7.2 - 10.8 N·m (M6 × 1.0)

Liquid Gasket: Three Bond TB 1280E or equivalent

**NOTE:**

- Make sure to completely remove all foreign substance and oil, etc. from the gasket surface.
- The assembling should be carried out within three minutes after the application of liquid gasket.

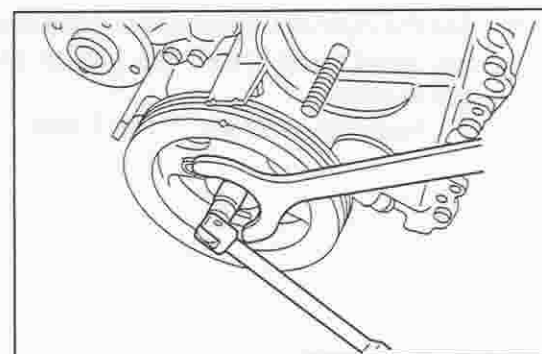


JEM00032-00031

12. Install the oil pan  
(For the installation procedure, refer to EM-53.)
13. Assemble the crankshaft pulley. Install the pulley bolt, using the following SST.

SST: 09278-87201-000

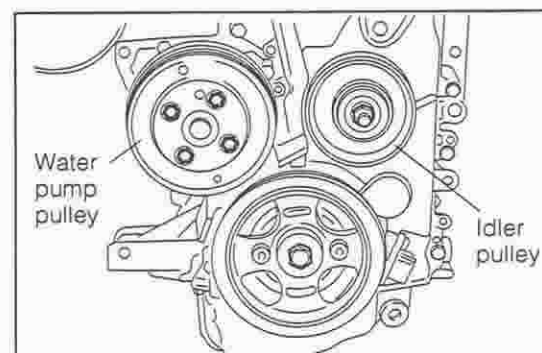
Tightening Torque: 120 - 140 N·m



JEM00033-00032

14. Install the idler pulley.  
Tightening Torque: 35.2 - 52.8 N·m

15. Install the water pump pulley.  
Tightening Torque: 8.1 - 15.0 N·m



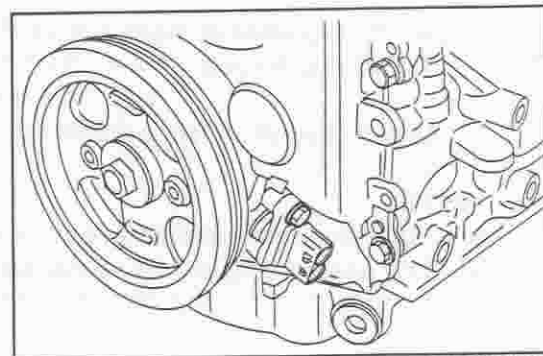
JEM00034-00033

# EM-10

16. Install the crank angle sensor.  
Tightening Torque: 5.3 - 9.8 N·m

**NOTE:**

- Prior to the installation, apply oil to the O-ring section of the sensor.

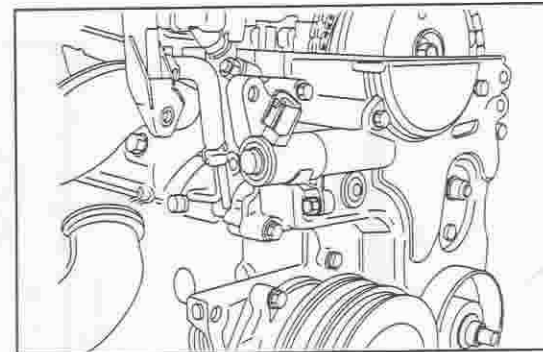


JEM00035-00034

17. Install the oil control valve.  
Tightening Torque: 5.3 - 9.8 N·m

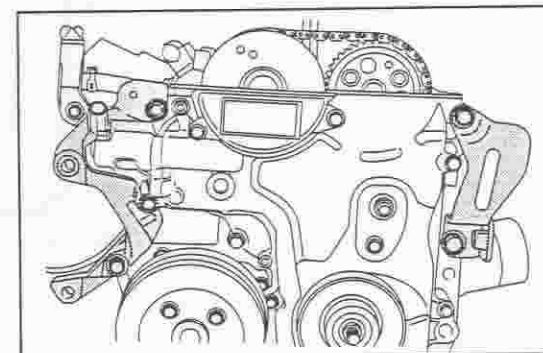
**NOTE:**

- Be sure to completely remove any foreign matter that may lodge at the installation hole or oil control valve.
- Apply engine oil to the O-ring section.



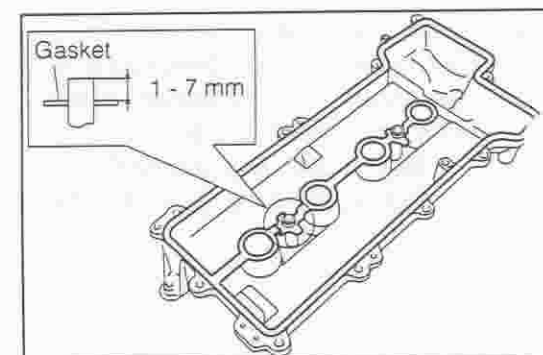
JEM00036-00035

18. Install the alternator bracket and idler pulley bracket.



JEM00037-00036

19. Set the cylinder head cover gasket to the gasket groove of the head cover. Insert the gasket into the boss at the central section.  
Insertion Amount: 1 to 7 mm



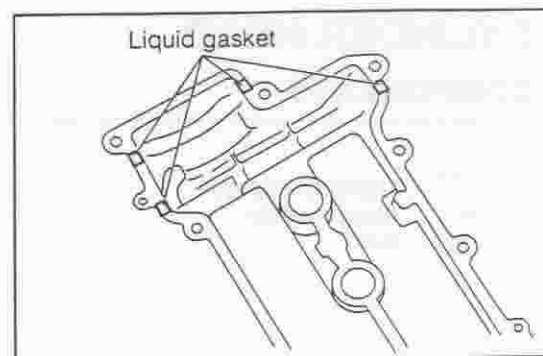
JEM00038-00037

20. Apply liquid gasket to those points indicated in the right figure.

Liquid Gasket: Three Bond TB 1280E or equivalent

**NOTE:**

- Guide to application amount: 5 mm in diameter and 2 mm in height
- The assembling should be carried out within three minutes after the application of liquid gasket.



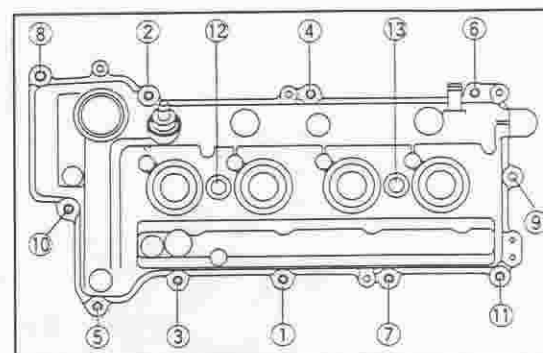
JEM00039-00038

21. Assemble the head cover retaining bolts in the sequence specified in the right figure.

Tightening Torque: 7.2 - 10.8 N·m (Cap nut)  
8.8 - 13.2 N·m (Nut)

**NOTE:**

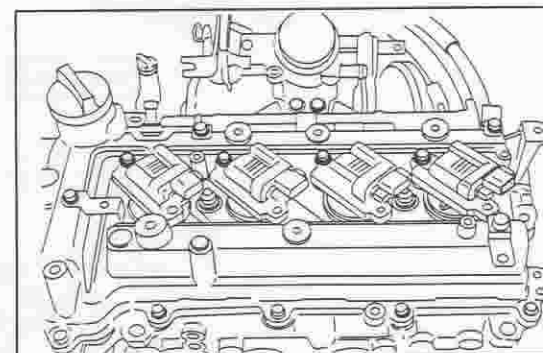
- Before the two cap nuts are installed on the central section of the cylinder head cover, install the washer seal in place.



JEM00040-00039

22. Install the ignition coil.

Tightening Torque: 6.0 - 9.0 N·m

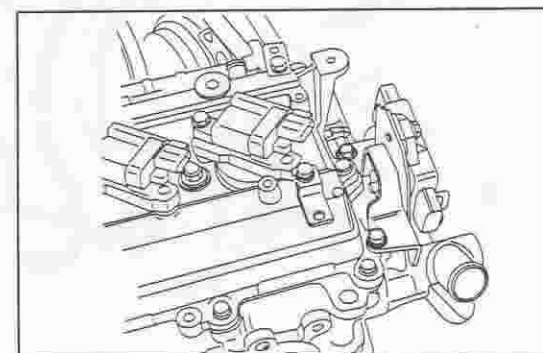


JEM00041-00040

23. Install the ignitor assembly. (European specifications only)

Tightening Torque: 5.3 - 9.8 N·m

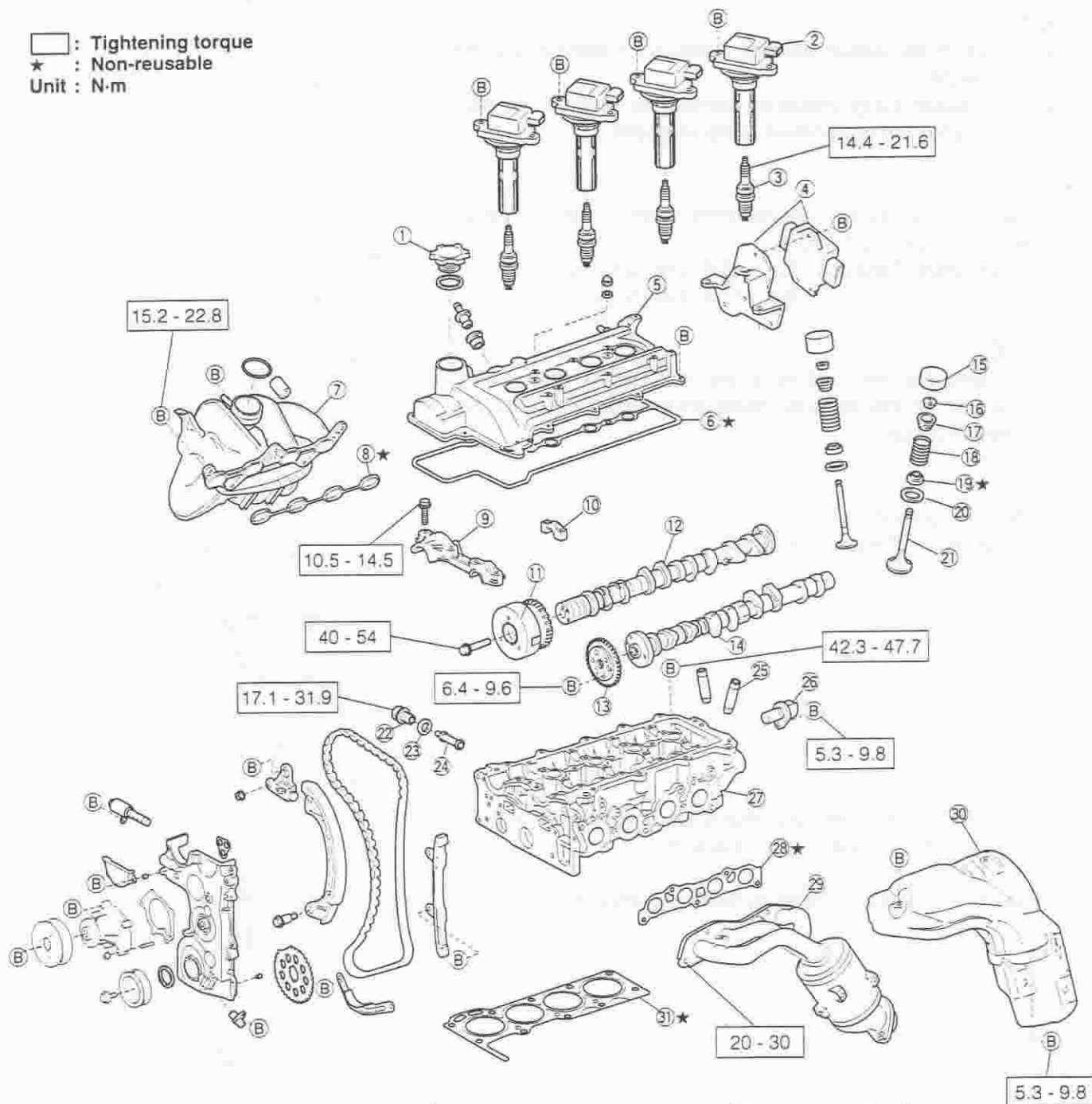
24. Install the drive belt. (Refer to the CH section.)



JEM00042-00041

## CYLINDER HEAD COMPONENTS

□ : Tightening torque  
 ★ : Non-reusable  
 Unit : N·m



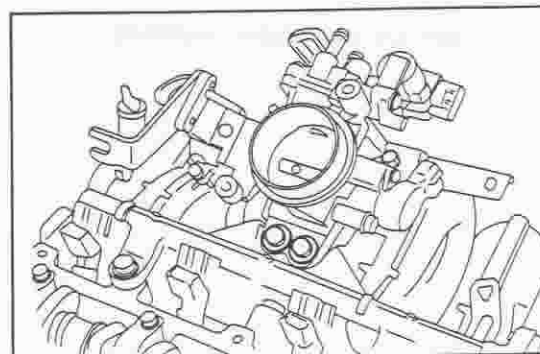
- ① Oil filler cap
- ② Ignition coil
- ③ Spark plug
- ④ Igniter assy
- ⑤ Cylinder head cover
- ⑥ Cylinder head cover gasket
- ⑦ Intake manifold
- ⑧ Intake manifold gasket
- ⑨ Camshaft bearing cap No. 1
- ⑩ Camshaft bearing cap No. 2
- ⑪ Valve timing controller

- ⑫ Camshaft No. 1
- ⑬ Camshaft No. 2 sprocket
- ⑭ Camshaft No. 2
- ⑮ Valve lifter
- ⑯ Valve spring retainer lock
- ⑰ Valve spring retainer
- ⑱ Valve spring
- ⑲ Valve stem oil seal
- ⑳ Valve seat
- ㉑ Valve
- ㉒ Straight screw plug
- ㉓ Gasket

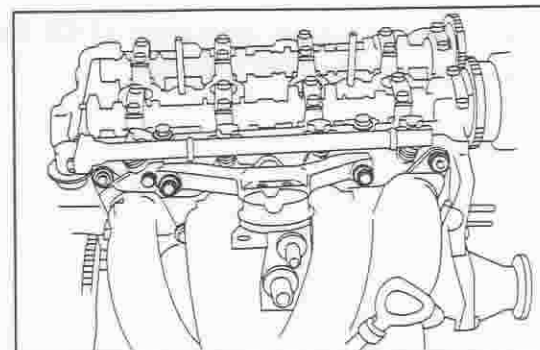
- ㉔ Oil control valve filter
- ㉕ Valve guide
- ㉖ Cam angle sensor
- ㉗ Cylinder head
- ㉘ Exhaust manifold gasket
- ㉙ Exhaust manifold
- ㉚ Exhaust manifold heat insulator
- ㉛ Cylinder head gasket

**REMOVAL**

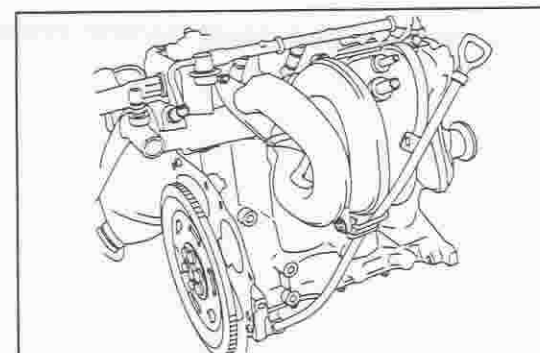
1. Remove the timing chain. (Refer to the Timing Chain section.)
2. Remove the throttle body.



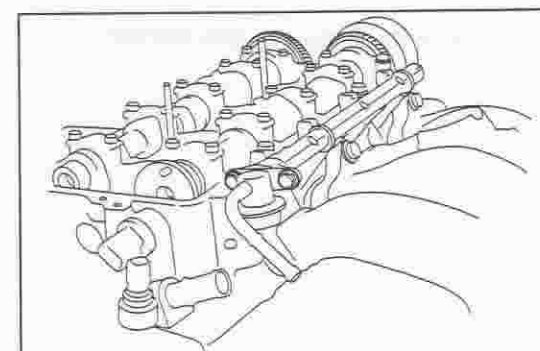
3. Remove the throttle body bracket.



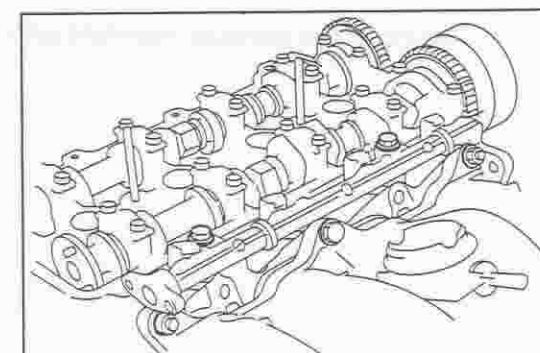
4. Remove the oil level gauge and oil level gauge bracket.  
NOTE:
  - The oil level gauge bracket has been provided only on the J102 series.



5. Remove the pulsation damper.

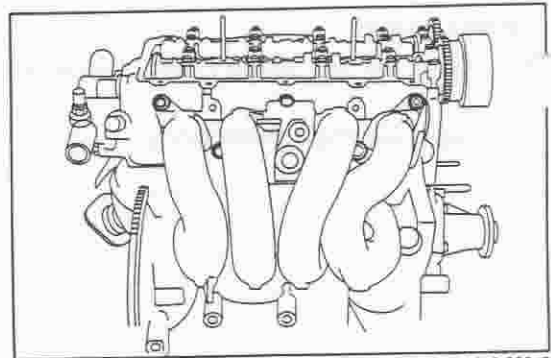


6. Remove the fuel delivery pipes and injectors.



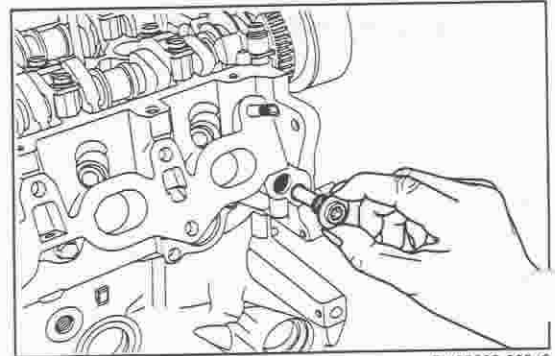
# EM-14

7. Remove the intake manifold.



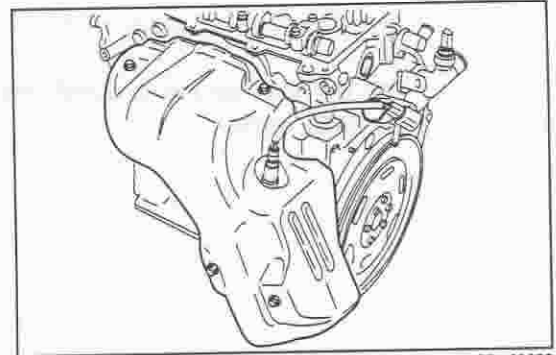
JEM00049-00048

- 8. Remove the air valve pipe. (J102 series only)
- 9. Remove the DVVT oil filter.



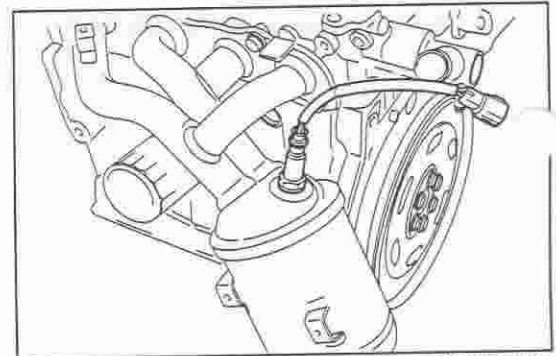
JEM00050-00049

10. Remove the exhaust manifold cover.



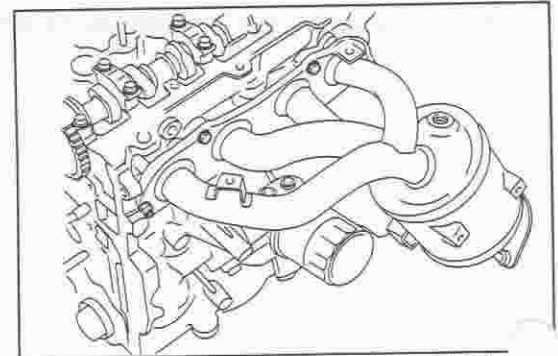
JEM00051-00050

11. Remove the oxygen sensor.



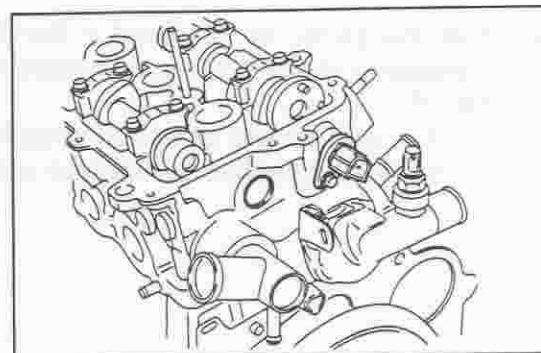
JEM00052-00051

12. Remove the exhaust manifold and gasket.



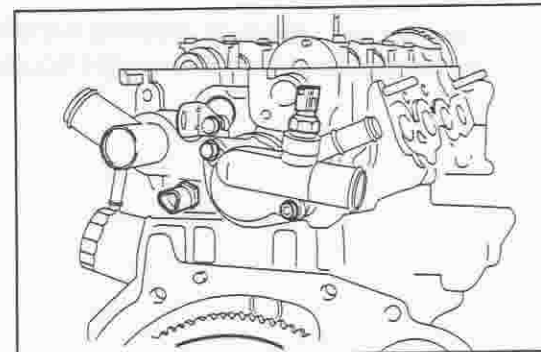
JEM00053-00052

13. Remove the cam angle sensor.



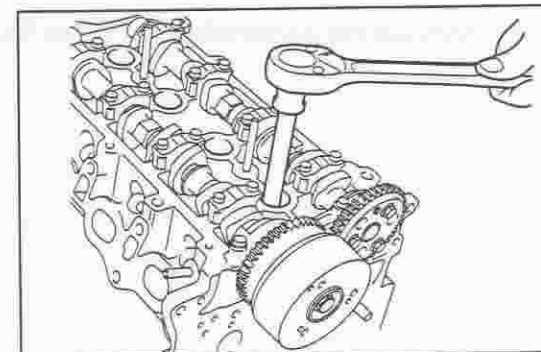
JEM00054-00053

14. Remove the radiator thermo control switch.  
 15. Remove the water inlet. Remove the thermostat.  
 16. Remove the engine coolant temperature sensor.



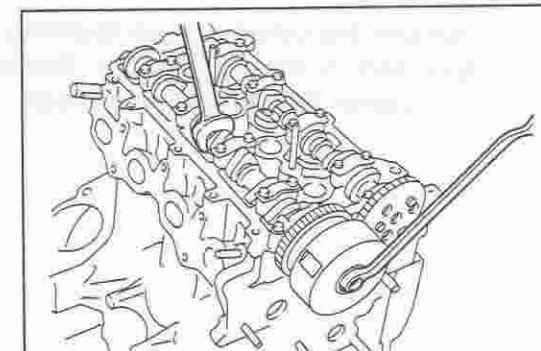
JEM00055-00054

17. Remove the spark plugs.



JEM00056-00055

18. Remove the camshaft bolt, while preventing the camshaft No. 1 from turning, using the hexagonal section of the camshaft No. 1. Remove the DVVT controller from the camshaft No. 1.

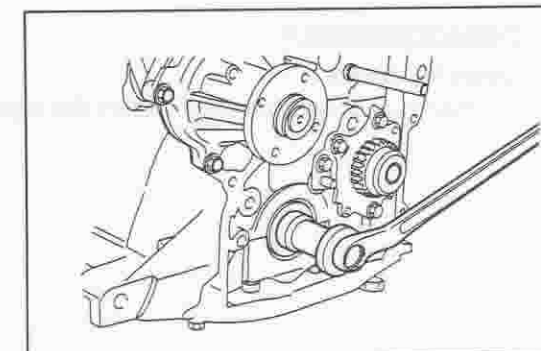


JEM00057-00056

19. Turn the crankshaft 90 degrees in the engine rotating direction.

**NOTE:**

- When the camshaft is turned in the following Step (20), care must be exercised to ensure that the valves will not interfere with the piston.



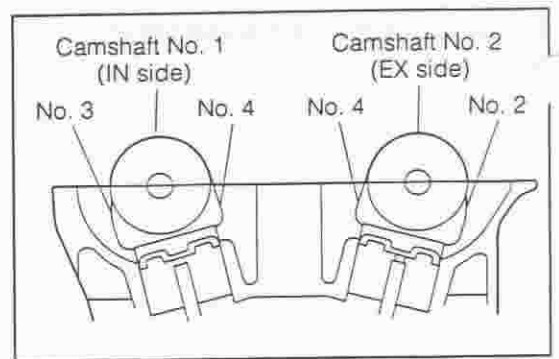
JEM00058-00057

# EM-16

20. Turn the cams, as indicated in the right figure, using the hexagonal sections of the camshafts No. 1 and No. 2.

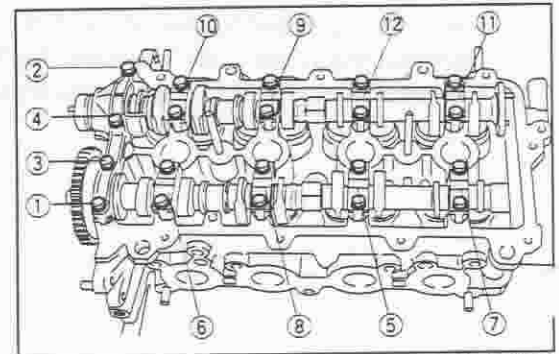
**NOTE:**

- The cam should be turned to such a position where the valve lifter pushes up least the camshaft.



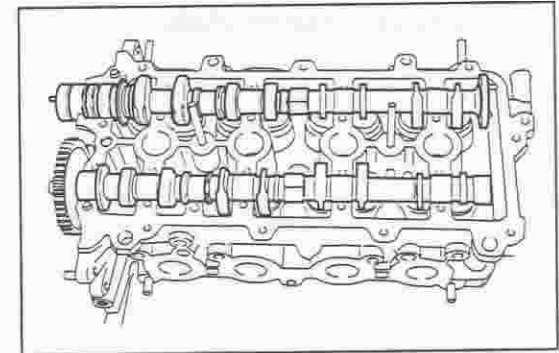
JEM00059-00059

21. Remove the camshaft bearing caps No. 1 and No. 2 in the sequence specified in the right figure.



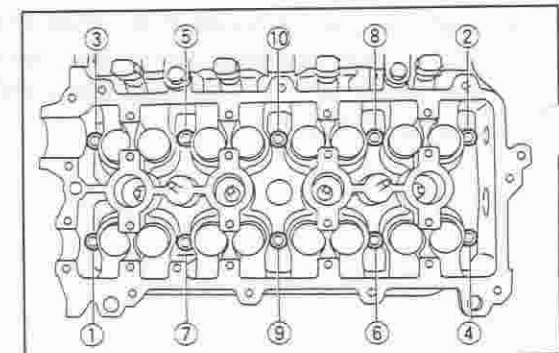
JEM00060-00059

22. Remove the camshafts No. 1 and No. 2.



JEM00061-00060

23. Remove the cylinder head retaining bolts in the sequence specified in the right figure. Remove the cylinder head and gasket from the cylinder block.

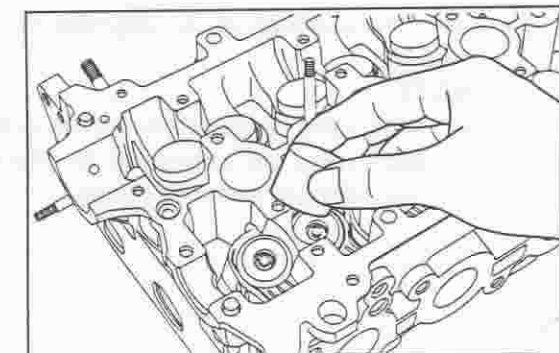


JEM00062-00061

## DISASSEMBLY

### Cylinder head

1. Remove the valve lifters from the cylinder head.

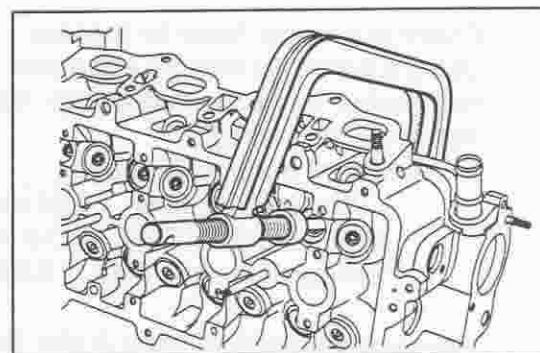


JEM00063-00062



2. Remove the valve spring retainer locks, using the following SSTs.

SST: 09202-87002-000  
09202-87002-0A0

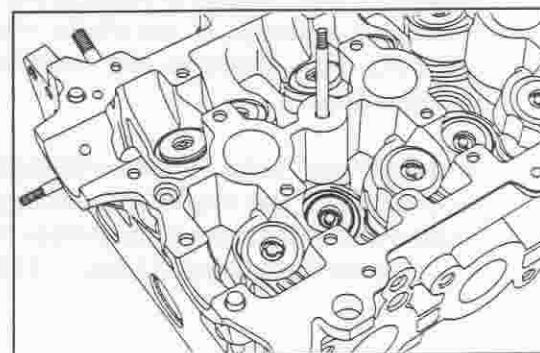


JEM00064-00063

3. Remove the valve spring retainers, and valve springs.
4. Remove the valves from the cylinder head.
5. Remove the valve stem oil seals, using pliers or the like.
6. Remove the valve spring seats from the cylinder head.

### WARNING:

- Make sure to protect your eyes with safety goggles during this operation.
- Be very careful not to allow the spring, etc. to jump out.



JEM00065-00064

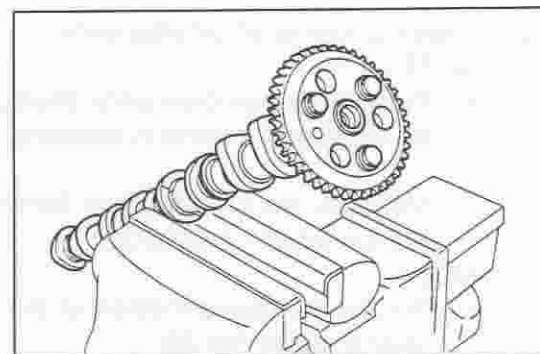
### Camshaft No. 2

1. Secure the camshaft by clamping it in a vise.

### CAUTION:

- Be very careful not to scratch the cam journal section.

2. Remove the camshaft drive gear from the camshaft.



JEM00066-00065

## INSPECTION

### Cylinder head

### NOTE:

- Clean the cylinder head by removing the remaining gasket materials, carbon deposits, and so forth.
- Check the cylinder head for cracks, using a dye penetration or like.

JEM00068-00000

# EM-18

## 1. Check of cylinder head for flatness

Using a precision straight edge and a feeler gauge, check the gasket surfaces contacting the cylinder head and manifolds for warpage.

### Maximum Surface Warpage:

Cylinder Block Side: 0.04 mm

Intake Manifold Side: 0.10 mm

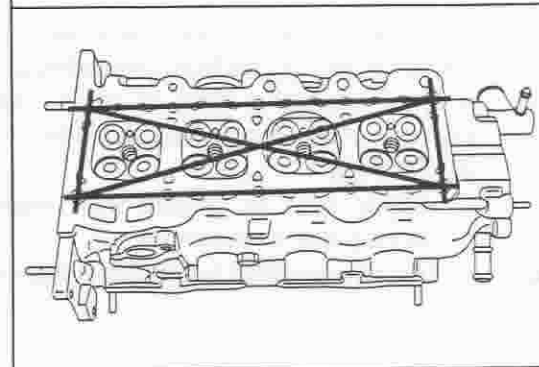
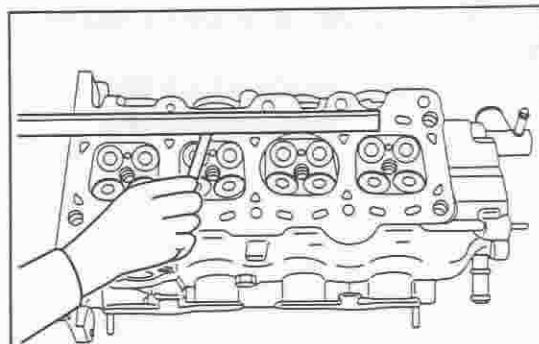
Exhaust Manifold Side: 0.05 mm

If surface warpage of the cylinder block side exceeds the maximum limit, reface or replace the cylinder head.

If surface warpage of the intake manifold and/or exhaust manifold side exceeds the maximum limit, replace the cylinder head.

If the cylinder head surface warpage at the cylinder block side exceeds the maximum warpage, reface the cylinder head within the minimum thickness limit.

Cylinder Head Height Limit: 112.7 mm



JEM00069-00067

## 2. Check of camshaft oil clearance

### NOTE:

- Prior to this oil clearance check, the camshaft should be checked for bend in advance. (See page EM-20.)

(1) Measure the oil clearance between the camshaft and the camshaft bearing cap.

### NOTE:

- For the tightening method of the camshaft bearing cap, refer to page EM-25.

### Oil Clearance:

IN: No. 1: 0.025 - 0.061

No. 2 ~ No. 5: 0.037 - 0.073

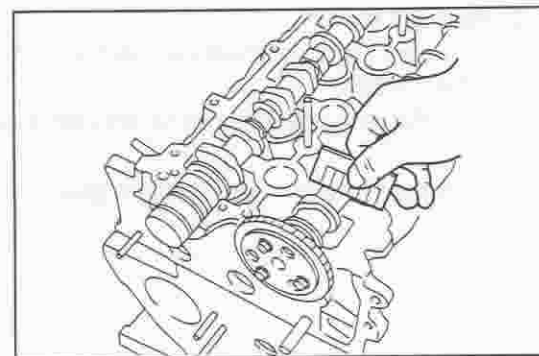
EX: No. 1 ~ No. 5: 0.037 - 0.073

If the oil clearance does not conform to the specification, measure the camshaft journals, camshaft bearing cap bore diameter.

Replace the any part which will not conform to the specifications.

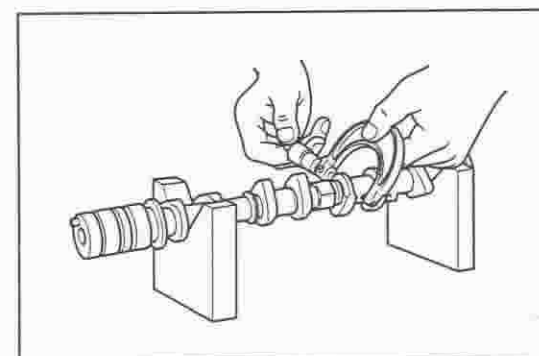
### NOTE:

- As for the replacement of the camshaft bearing cap, it should be replaced as a set with the cylinder head.



JEM00070-00068

		Camshaft journal outer diameter	Camshaft bearing cap bore diameter
Intake side	No. 1	33.984 - 34.000	34.025 - 34.045
	No. 2 - No. 5	22.979 - 22.995	23.032 - 23.052
Exhaust side	No. 1	25.979 - 25.995	26.032 - 26.052
	No. 2 - No. 5	22.979 - 22.995	23.032 - 23.052



JEM00071-00069

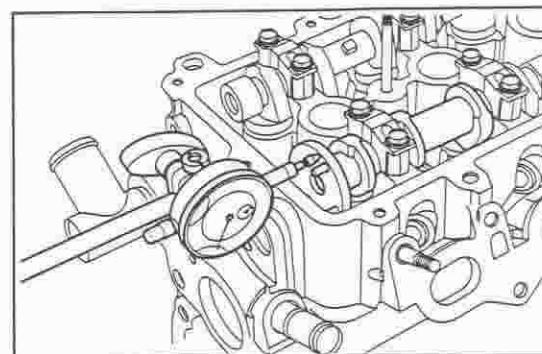
### 3. Check of camshaft thrust clearance

Assemble the camshaft, referring to the assembling procedure of the camshaft in EM-25. Measure the thrust clearance.

Specified Thrust Clearance:

Intake Side 0.10 - 0.24 mm

Exhaust Side 0.10 - 0.24 mm



JEM00072-00070

### 4. Check and grinding of valves

(1) Visually inspect the valve stem for seizure or damage.

NOTE:

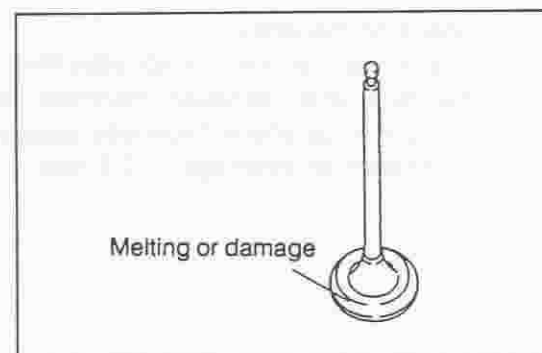
- If seizure or damage is found, replace the valve and valve guide bush as a set.
- However, this replacement should be performed only after the checks for the valve seat, valve stem and valve guide bush have been finished.
- The valve guide bush hole must be used for refacing the valve seat. Hence, if the valve guide bush hole exhibits any roughness due to seizure, etc., rectify the hole with an adjustable reamer.



JEM00073-00071

(2) Visually inspect the valve head for melting or damage. If the valve head exhibits any melting or damage, replace the valve.

If the roughness on the contact surface can be corrected, grind the valve seat contact surface with a valve refacer.



JEM00074-00072

(3) Grind the valves only enough to obtain a smooth contact surface with the valve seat.

Valve Face Angle: 45.5°

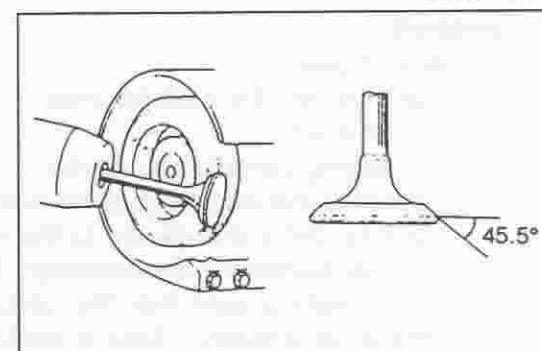
NOTE:

- Make sure the valves are ground to the correct valve face angle.
- (4) Visually inspect the valve stem end for abnormal wear. If the valve stem end exhibits abnormal wear, correct the stem end with a valve refacer. However, this correction should be made within a limit of 0.2 mm from the standard length.

[Reference]

Intake Valve: 79.4 mm

Exhaust Valve: 79.8 mm



JEM00075-00073

NOTE:

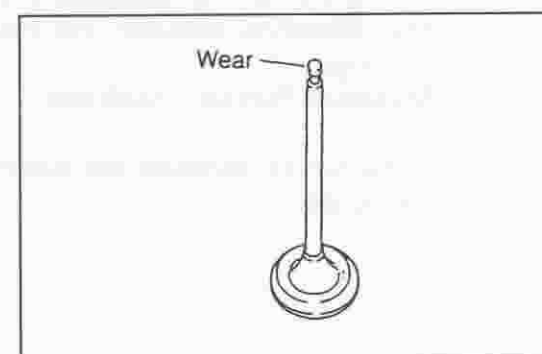
- Be very careful not to allow the valve to be overheated during grinding.

Standard Length:

Intake Valve: 88.15 mm (Unleaded)

88.35 mm (Leaded)

Exhaust Valve: 89.1 mm



JEM00076-00074

- (5) Inspect the valve head for its stock thickness.

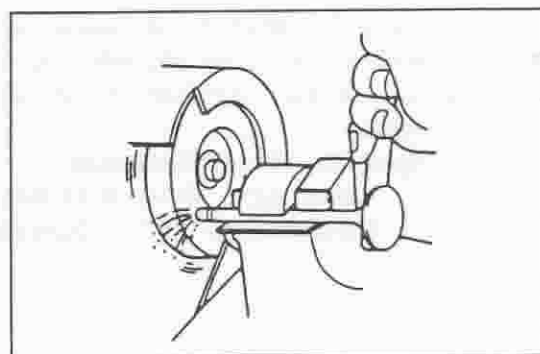
Minimum Stock Thickness:

Intake Valve:  $0.8 \pm 0.2$  mm (Unleaded)

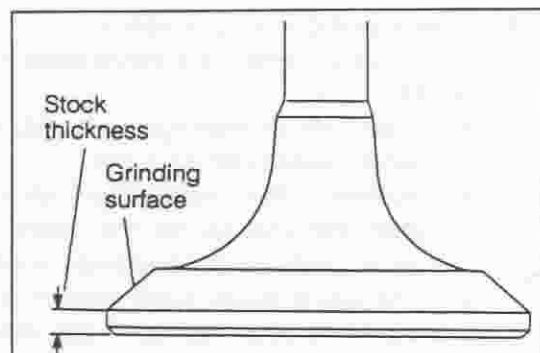
$1.0 \pm 0.2$  mm (Leaded)

Exhaust Valve:  $1.0 \pm 0.2$  mm

If the stock thickness of the valve head is less than the minimum stock thickness, replace it with a new one.



JEM00000-00075

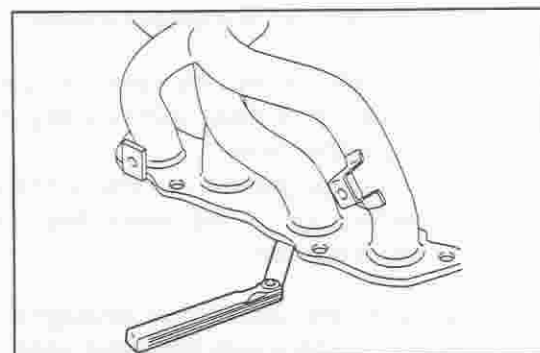


JEM00077-00076

## 13. Check of manifold

Check the cylinder head attaching surface of the intake manifold and exhaust manifold for warp, using a straight edge and a thickness gauge.

Maximum Warp: 0.1 mm



JEM00078-00077

## Camshaft

### 1. Check of gear

Visually inspect the teeth for wear.

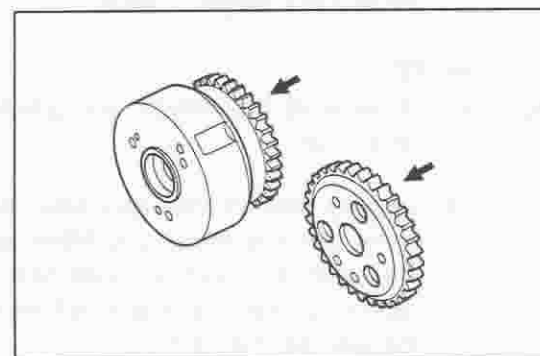
### 2. Check of shaft

#### (1) Checking camshaft for runout

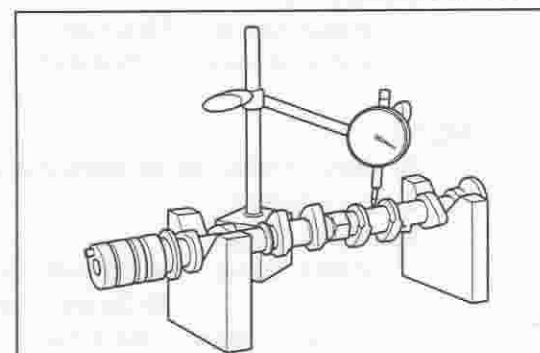
Support the camshaft at its both ends with V-shaped blocks. Set a dial gauge to the mid-point of the center journal section of the camshaft. Turn the camshaft one turn, making sure that the camshaft will not move in the axial direction. Take a reading on the dial gauge during the turning. Calculate the maximum runout, i.e. the difference between the maximum and minimum readings.

Maximum Runout: 0.03 mm

If the runout exceeds the maximum limit, replace the camshaft.



JEM00000-00078

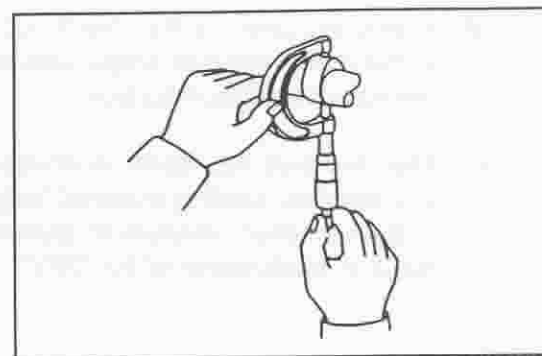


JEM00079-00079

## (2) Checking of cam lobe height

Measure the cam lobe height, using a micrometer.  
Specified Cam Lobe Height:

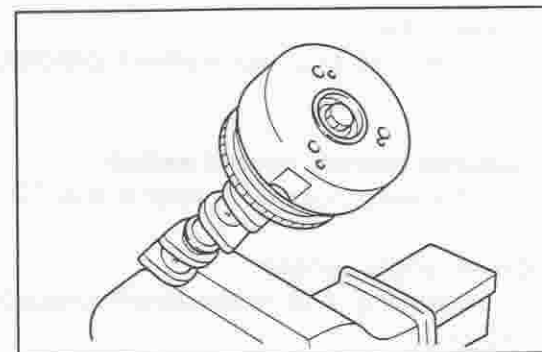
	K3-VE	K3-VE2
IN	40.45 mm	40.75 mm
EX	39.96 mm	40.69 mm



JEM00080-00080

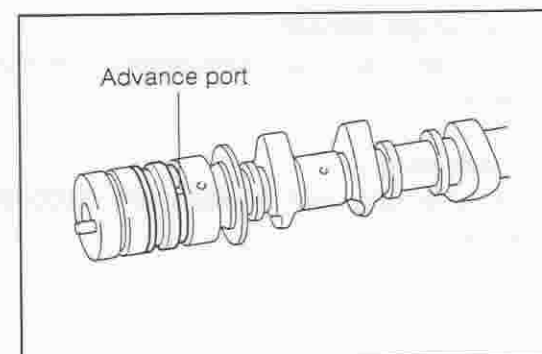
## 3. Check of DVVT controller

- (1) Clamp the hexagonal section for servicing of the camshaft assembly No. 1 in a vice, etc.
- (2) Temporarily tighten the attaching bolt at the DVVT controller attaching bolt hole so as to plug the oil passage at the timing advance side.



JEM00231-00216

- (3) Wind a vinyl tape, as indicated in the right figure. Then, make a hole at either of the two advance ports.



JEM00232-00217

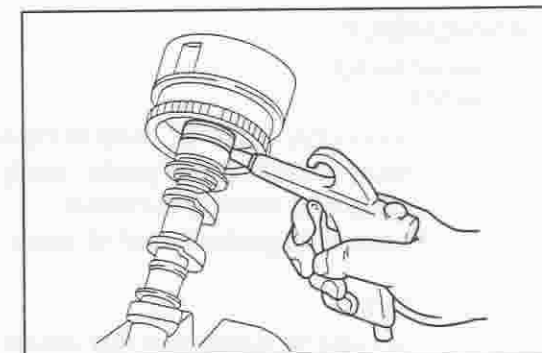
- (4) Apply compressed air to the advance port where the hole has been made, using a pneumatic tool.

**CAUTION:**

- Care must be exercised, for oil will splash.

**NOTE:**

- The most retarded angle lock will be unlocked.

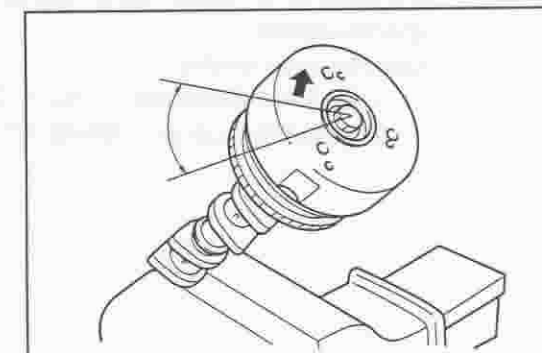


JEM00233-00218

- (5) At this time, ensure that the most retarded angle lock of the DVVT controller becomes unlocked and the DVVT controller can be moved by your hand without binding within a range of approximately 30°.

**NOTE:**

- The DVVT controller will be locked when it comes to the most retarded angle position.



JEM00234-00219

- (6) After completion of the check, lock the DVVT controller at the most retarded angle position. Then, remove the timing pulley attaching bolt.

**NOTE:**

- After the bolt has been removed, be sure to wipe off any residual sealing material lodged at the screw hole of the camshaft. (Failure to perform this operation may result in malfunction of the DVVT after assembling.)

JEM00235-00000

## Thermostat

For checking and replacement procedures, refer to the CO section.

## Radiator thermo control switch

For checking procedure, refer to the CO section.

## Crank angle sensor

For checking and replacement procedures, refer to the IG section.

## Cam angle sensor

For checking and replacement procedures, refer to the IG section.

## Spark plug

For checking and replacement procedures, refer to the IG section.

JEM00082-00000

## ASSEMBLY

### Cylinder head

**NOTE:**

- Thoroughly clean all parts to be assembled.
- Before installing the parts, apply new engine oil to all sliding and rotating surfaces.
- Replace all gaskets and oil seals with new ones.




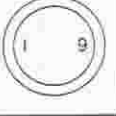
**CAUTION:**

- It should be noted that the valves for unleaded gasoline specifications differ from those for leaded gasoline specifications.

Identification marks:

Unleaded Gasoline: IN=I1, EX=E1

Leaded Gasoline: IN=I9, EX=E9

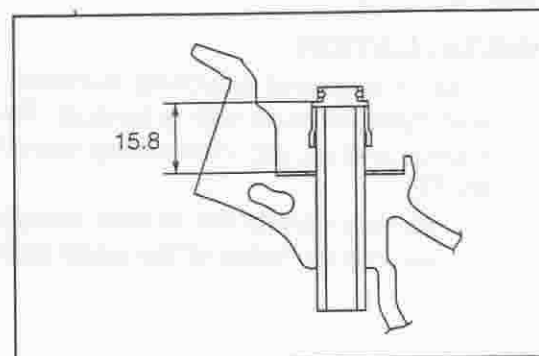
Unleaded gasoline		Leaded gasoline	
Exhaust valve	Intake valve	Exhaust valve	Intake valve
			

JEM00083-00082

1. Install the valve spring seat
2. Installation of valve stem oil seal
  - (1) Apply engine oil to the inner surface of the metal ring of the stem oil seal.
  - (2) Drive the valve stem oil seal into position.

**NOTE:**

- Make sure that the stem oil seals will not tilt against the stem.

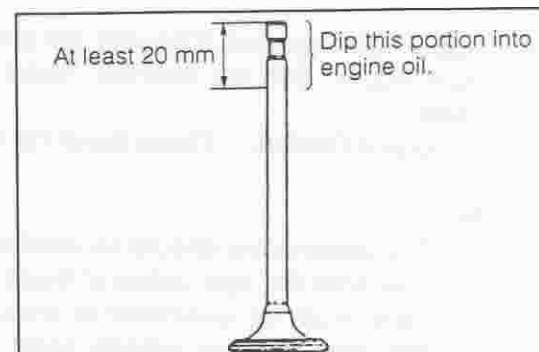


JEM00084-00083

3. Dip the long portion of the valve stem end at least 20 mm into engine oil.
4. Install the valve to the cylinder head.

**NOTE:**

- Care must be exercised as to the installing position. Do not pull out the valve once it has been inserted.
- If the inserted valve should be pulled out, replace the valve stem oil seal with a new one.

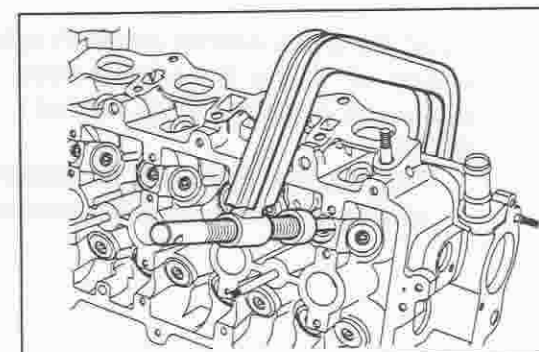


JEM00085-00084

5. Assembly of valve springs, valve spring retainers and valve spring retainer locks

- (1) Install the valve spring to the valve lifter inserting hole.
- (2) Install the valve spring retainer to the valve spring. Install the valve spring retainer locks while compressing the valve spring retainer, using the following SST.

SST: 09202-87002-000  
09202-87002-0A0

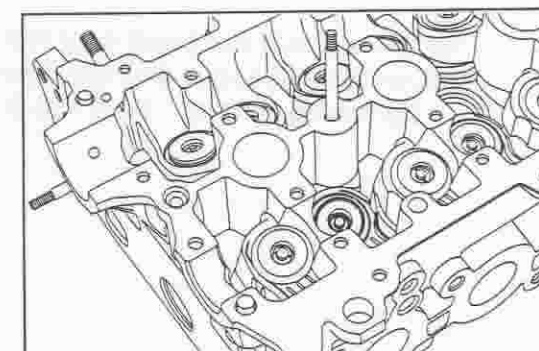


JEM00086-00085

- (3) After installing the valve spring retainer lock, lightly tap the valve spring retainer with a plastic hammer or the like so as to ensure that the valve spring retainer locks are installed securely.

**WARNING:**

- During this operation, care must be exercised to ensure that the valve spring retainer or retainer locks may not jump out.
- Protect your eyes with safety goggles during this operation.
- Never tap the hole into which the valve lifter is inserted.



JEM00087-00086

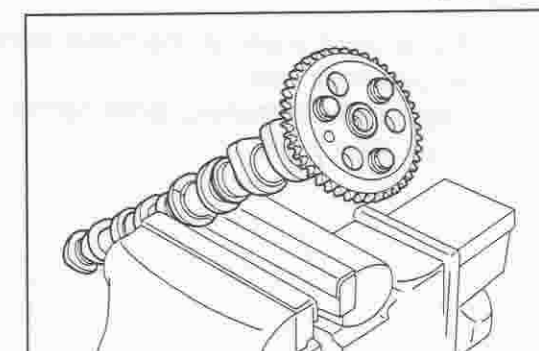
## Camshaft No. 2

1. Secure the camshaft by clamping it in a vise.

**CAUTION:**

- Be very careful not to scratch the cam journal section.

2. Install the camshaft drive gear to the camshaft.



JEM00088-00087

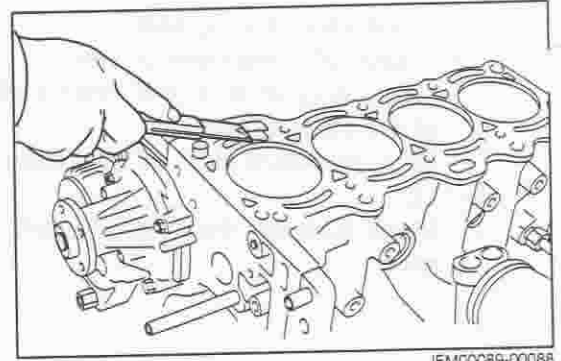


## INSTALLATION

1. Clean the gasket attaching surfaces of the cylinder block and cylinder head with a scraper. Remove all foreign substance and oil, etc. completely from the gasket surface.

### NOTE:

- Be very careful not to drop scraping debris of the gasket into the holes of the water jacket and oil holes.

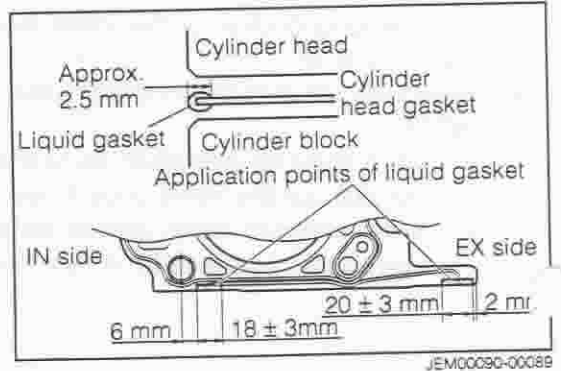


2. Apply liquid gasket, following the procedure shown in the right figure. Set the cylinder head gasket and cylinder head.

Liquid Gasket: Three Bond TB 1280E or equivalent

### NOTE:

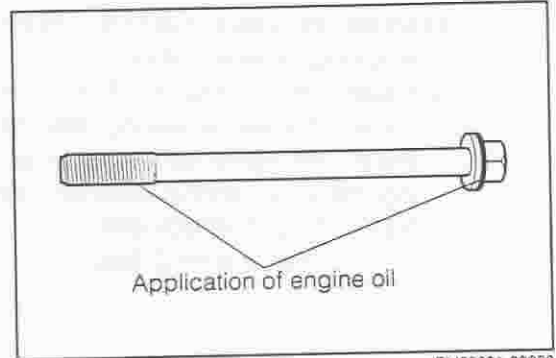
- The assembling should be carried out within three minutes after the application of liquid gasket.
- Care must be exercised to ensure that no valve lifter may drop from the cylinder head.



3. Install the plate washer on each cylinder head bolt. Apply engine oil to the threaded portion of each bolt and the seat surface of each plate washer.

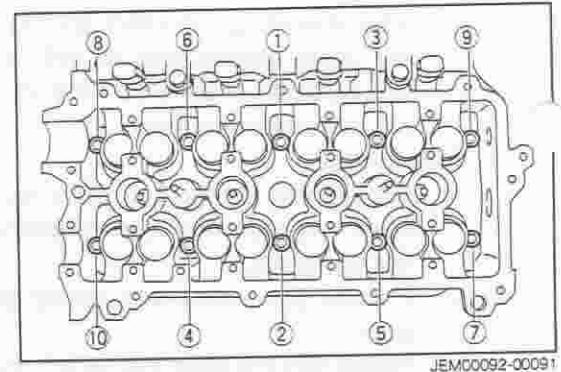
### NOTE:

The washer plate can be installed in either way. The washer does not have the front side nor the back side.

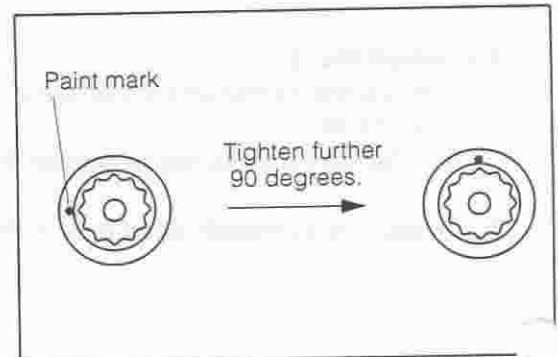


4. Tighten the cylinder head over two to three stages in the sequence specified in the right figure.

Tightening Torque: 32.0 - 34.0 N·m



5. Put a paint mark on the head section of each bolt at the engine front side.
6. Tighten the attaching bolts further 90 degrees, using the mark as a guide.





## NOTE:

- Using a micrometer, measure the diameter of the shaded, threaded ridge portion of the cylinder head bolt, as indicated in the right figure. This measurement should be conducted at several points. If the diameter has worn exceeding the allowable limit, replace the cylinder head bolt.

## Allowable Limit:

Diameter of threaded ridge diameter: 8.75 mm

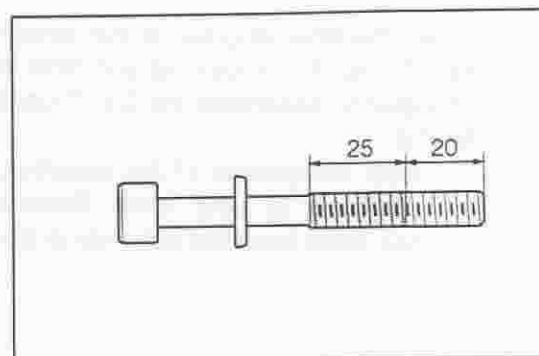
- Turn the crankshaft 90 degrees in the engine rotating direction from the top dead center of No. 1 cylinder.

## NOTE:

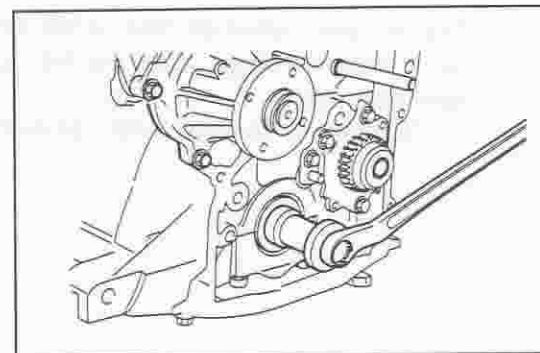
- Utmost attention must be paid so that a lifting valve will not interfere with the piston when assembling the camshaft.

- Apply engine oil to the cam lobe sections of the camshafts No. 1 and No. 2, the cylinder head journal sections and the top sections of the lifters.

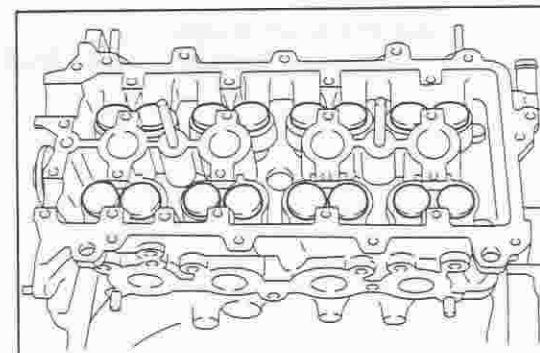
- With the cam position aligned as shown in the right figure, set the camshaft to the cylinder head.



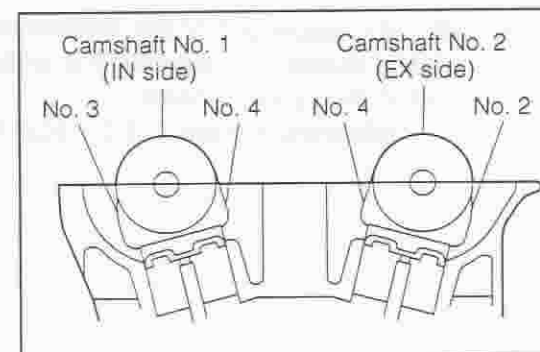
JEM00094-00093



JEM00095-00094



JEM00096-00095



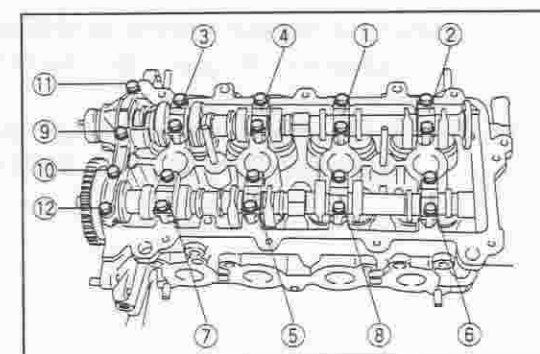
JEM00097-00096

- Install the camshaft bearing caps No. 1 and No. 2 in the sequence specified in the right figure.

Tightening Torque: 10.5 - 14.5 N·m

## NOTE:

- Make sure that the camshaft bearing cap is assembled in such a direction that the arrow-headed mark points toward the front of the engine.



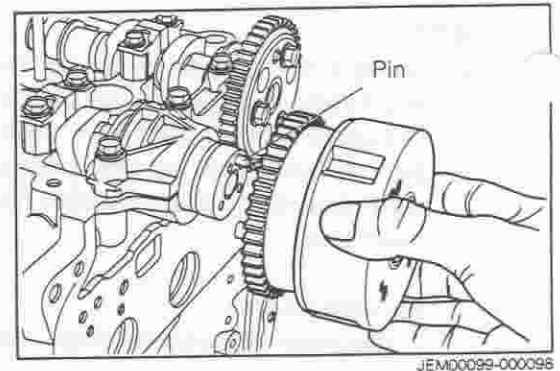
JEM00098-00097

## EM-26

11. Insert the knocking pin at the forward end of the camshaft No. 1 into the knocking pin hole of the DVVT controller. Proceed to assemble the DVVT controller.

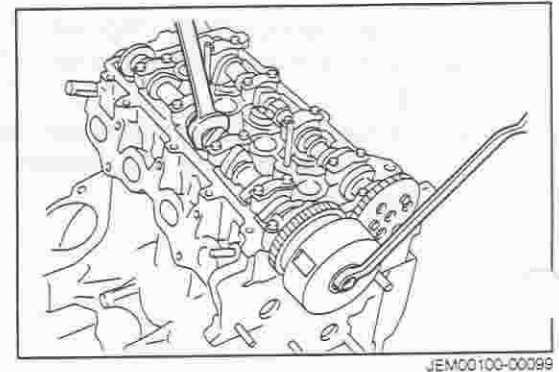
**NOTE:**

- After completion of the insertion, lightly turn the DVVT controller by your hand. Ensure that the knocking pin has been inserted securely in place.



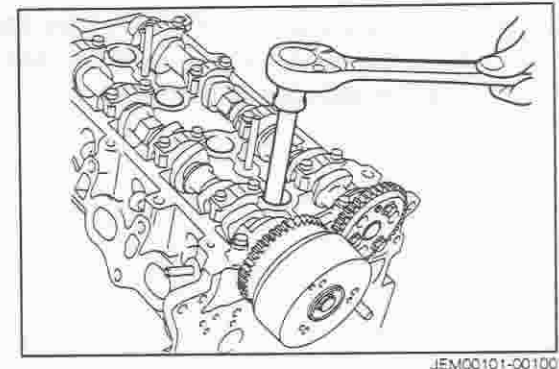
12. Tighten the camshaft bolt, while preventing the camshaft No. 1 from turning, using the hexagonal section of the intake camshaft.

Tightening Torque: 40 - 54 N·m



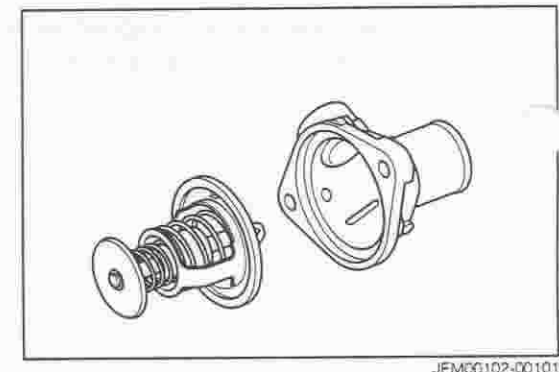
13. Install the spark plugs.

Tightening Torque: 14.4 - 21.6 N·m



14. With the jiggle pin of the thermostat aligned with the protruded section for locating the water inlet, install the water inlet in the cylinder head.

Tightening Torque: 7.2 - 10.8 N·m

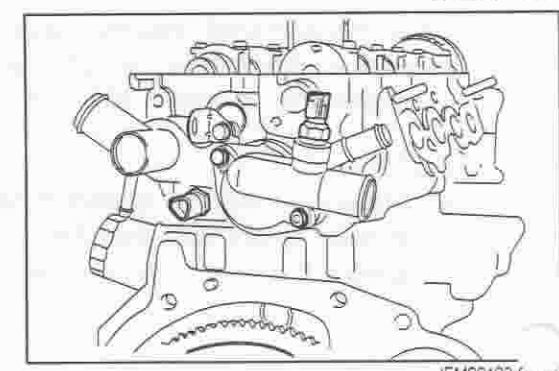


15. Install the radiator thermo control switch to the water inlet.

Tightening Torque: 30 - 40 N·m

16. Install the engine coolant temperature sensor.

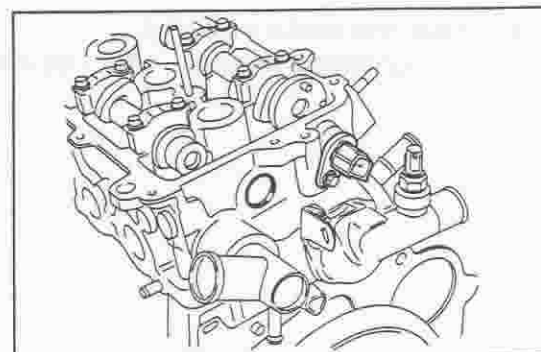
Tightening Torque: 16 - 24 N·m



17. Install the cam angle sensor to the cylinder head.  
Tightening Torque: 5.3 - 9.8 N·m

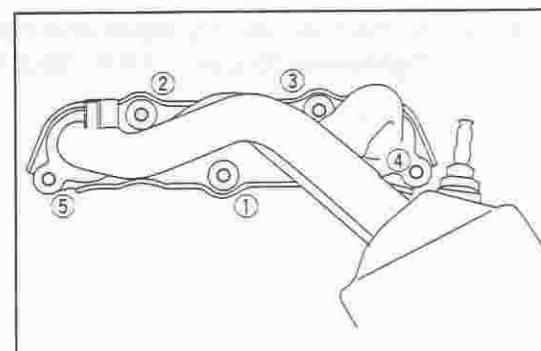
**NOTE:**

- Prior to the installation of the sensor, be sure to apply oil to the O-ring of the sensor.



JEM00105-00104

18. Install the exhaust manifold and gasket in the sequence specified in the right figure.  
Tightening Torque: 21 - 29 N·m

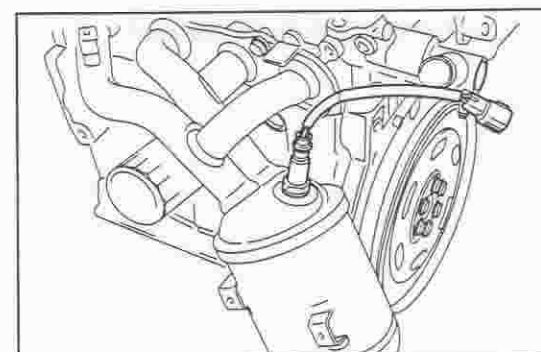


JEM00106-00105

19. Install the oxygen sensor to the exhaust manifold.  
Tightening Torque: 29.0 - 39.0 N·m

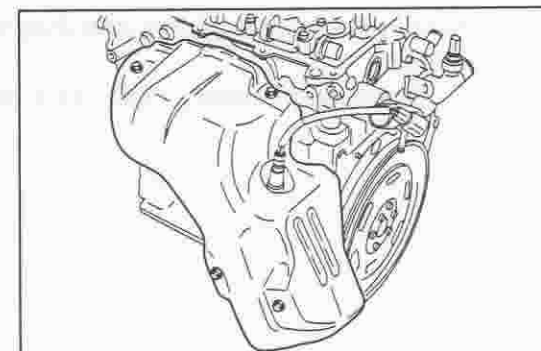
**NOTE:**

- Never use an impact wrench when assembling the oxygen sensor.
- Care must be exercised not to give damage to the harness during the assembling operation.



JEM00107-00106

20. Install the exhaust manifold cover.  
Tightening Torque: 5.3 - 9.8 N·m



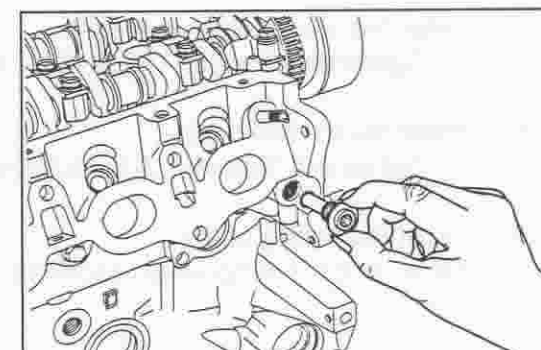
JEM00108-00107

21. Install the DVVT oil filter, using a new gasket.  
Tightening Torque: 17.1 - 31.9 N·m

**NOTE:**

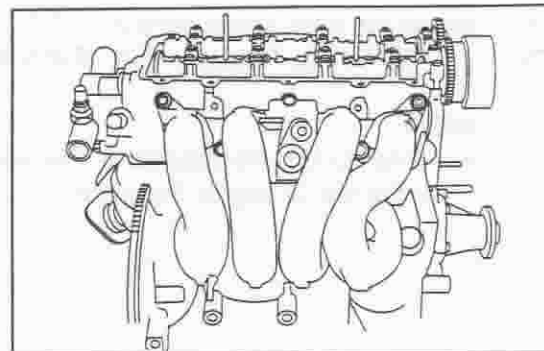
- Make sure that no foreign substance gets to the filter hole and filter plug of the cylinder head.
- The gasket is a non-resuable part.

22. Install the air valve pipe. (J102 series only)



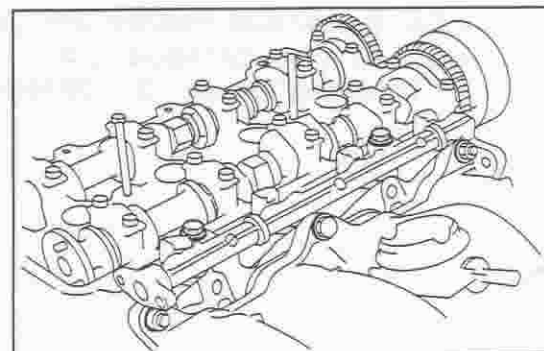
JEM00109-00108

23. Install the intake manifold.  
Tightening Torque: 15.2 - 22.8 N·m



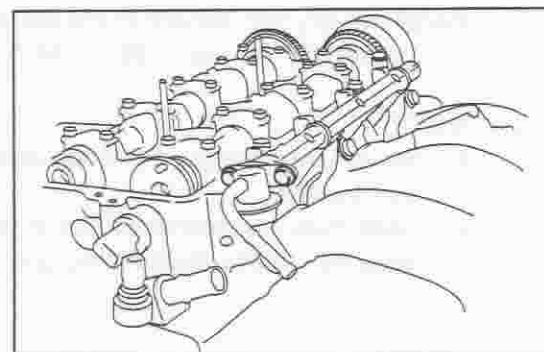
JEM00110-00109

24. Install the fuel delivery pipes and injectors.  
Tightening Torque: 16.8 - 25.2 N·m



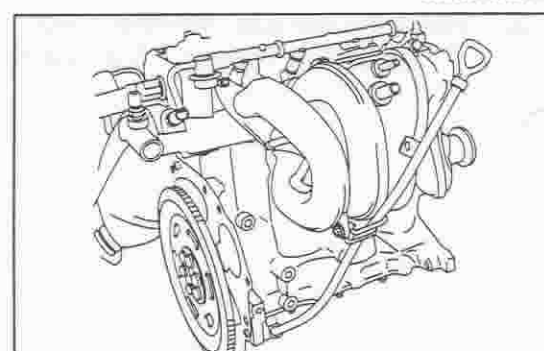
JEM00111-00110

25. Install the pulsation damper.



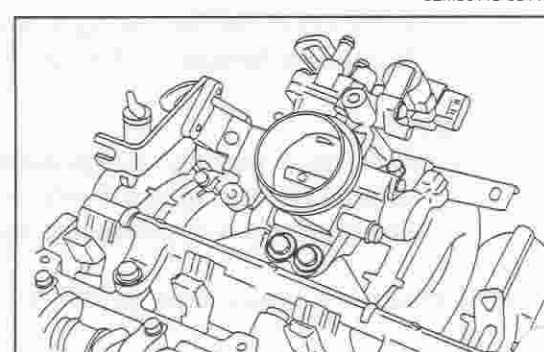
JEM00112-00111

26. Install the oil level gauge and insert the oil level gauge in place.  
Tightening Torque: 6.0 - 11.1 N·m



JEM00113-00112

27. Install the throttle body bracket.  
Tightening Torque: 16.8 - 25.2 N·m



JEM00114-00113

28. Install the throttle body.  
Tightening Torque: 5.3 - 9.8 N·m

29. Install the timing chain.  
(Refer to the Timing Chain section.)

## 30. Adjustment of valve clearance

- (1) Turn the crankshaft in the engine rotating direction so that the crankshaft key groove may point upward.

### NOTE:

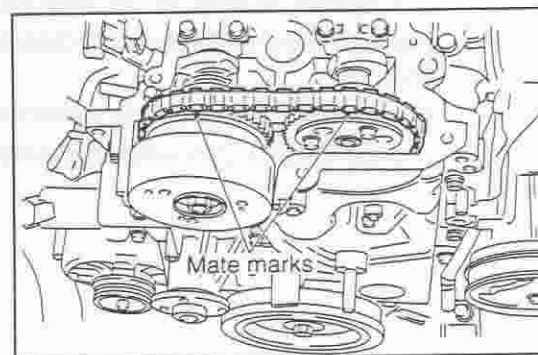
- Set the No. 1 cylinder to the top dead center.

JEM00115-00000

- (2) Ensure that the mate mark on the camshaft timing sprocket points upward. If the mate mark does not point upward, turn the crankshaft another one turn. And ensure that now the mark points upward.

### NOTE:

- Now, the No. 1 cylinder assumes the top dead center under the compression stroke.

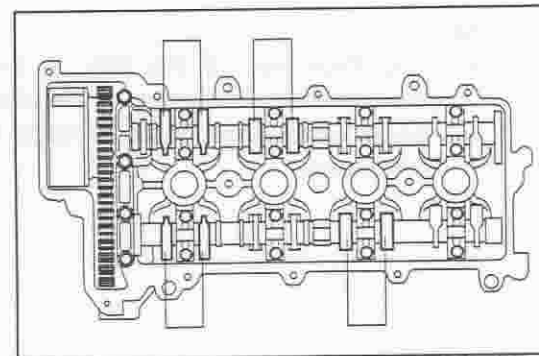


JEM00116-00115

- (3) Check the valve clearances at those points specified in the right figure, using a thickness gauge.

Valves to be checked at top dead center of No. 1 cylinder under compression stroke

No. 1 cylinder		No. 2 cylinder		No. 3 cylinder		No. 4 cylinder	
IN	EX	IN	EX	IN	EX	IN	EX
○	○	○	—	—	○	—	—

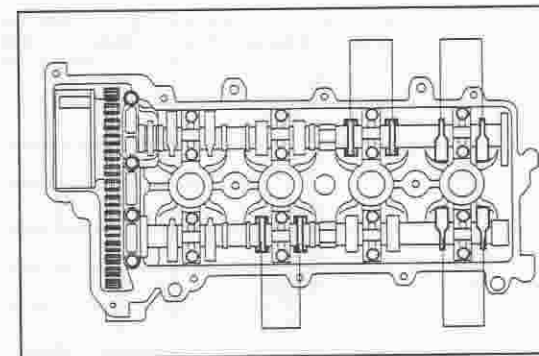


JEM00117-00116

- (4) Turn the crankshaft another one turn so that the No. 1 cylinder assumes the top dead center under the exhaust stroke. Check the valve clearances at those points specified in the right figure.

Valves to be checked at top dead center of No. 1 cylinder under exhaust stroke

No. 1 cylinder		No. 2 cylinder		No. 3 cylinder		No. 4 cylinder	
IN	EX	IN	EX	IN	EX	IN	EX
—	—	—	○	○	—	○	○



JEM00118-00117

- (5) If the valve clearances will not come within the specified values, remove the timing chain and camshaft.

**Specified Valve Clearances:**

Intake (cold): 0.145 - 0.235

Exhaust (cold): 0.275 - 0.365

- (6) Select proper valve lifters, using the formula given below, so that the valve clearances may fall within the specified values.

**Intake**

(Thickness of lifter to be selected) = (Thickness of removed lifter) + [(Measured clearance) - 0.18 mm]

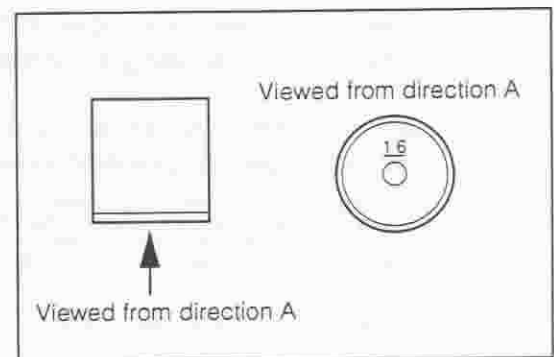
**Exhaust**

(Thickness of lifter to be selected) = (Thickness of removed lifter) + [(Measured clearance) - 0.31 mm]

JEM00119-00000

**NOTE:**

- The thickness of the lifter to be assembled must be measured at the center of the lifter.
- Each valve lifter bears a mark that identifies its lifter thickness.



JEM00120-00119

Code	Lifter thickness (mm)	Code	Lifter thickness (mm)	Code	Lifter thickness (mm)	Code	Lifter thickness (mm)
12	5.120	28	5.280	42	5.420	56	5.560
14	5.140	30	5.300	44	5.440	58	5.580
16	5.160	32	5.320	46	5.460	60	5.600
18	5.180	34	5.340	48	5.480	62	5.620
20	5.200	36	5.360	50	5.500	64	5.640
22	5.220	38	5.380	52	5.520	66	5.660
24	5.240	40	5.400	54	5.540	68	5.680
26	5.260						

JEM00121-00000

- (7) Apply engine oil to the outer periphery of each selected valve lifter. Proceed to insert the valve lifters into the lifter holes.

Assemble the camshafts No. 1 and No. 2. (Refer to EM-25.)

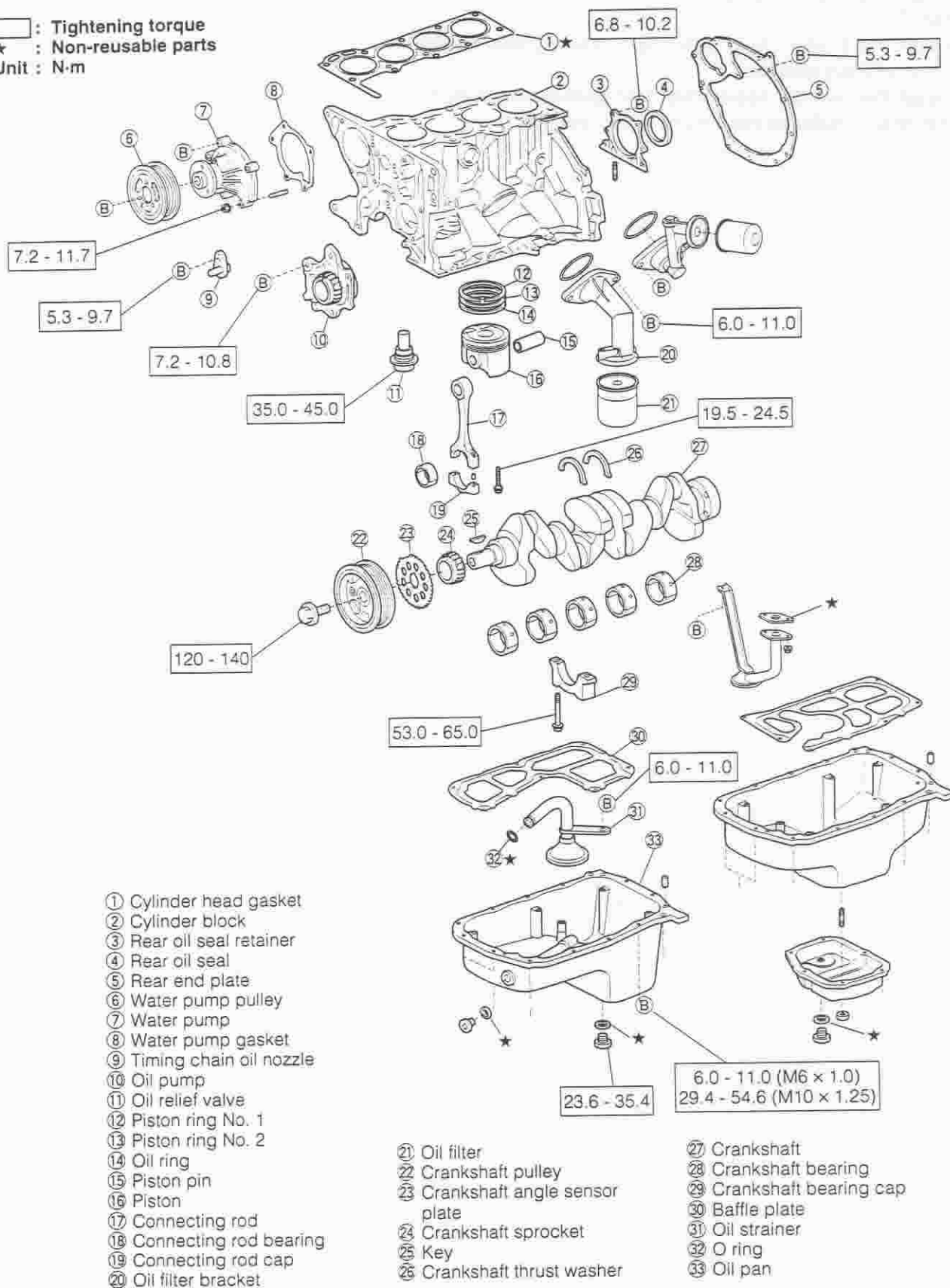
- (8) Install the timing chain and chain cover. (Refer to the Timing Chain section.)

- (9) Install the cylinder head cover and gasket on the cylinder head. (Refer to the Timing Chain section.)

JEM00122-00000

## CYLINDER BLOCK COMPONENTS

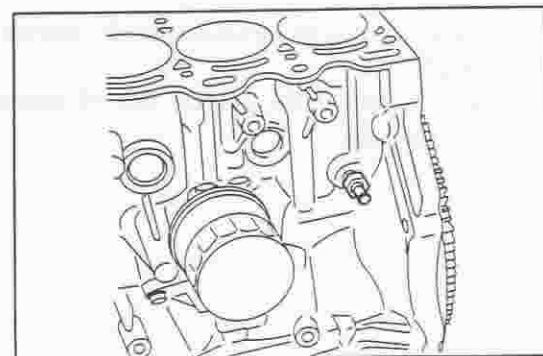
□ : Tightening torque  
 ★ : Non-reusable parts  
 Unit : N·m





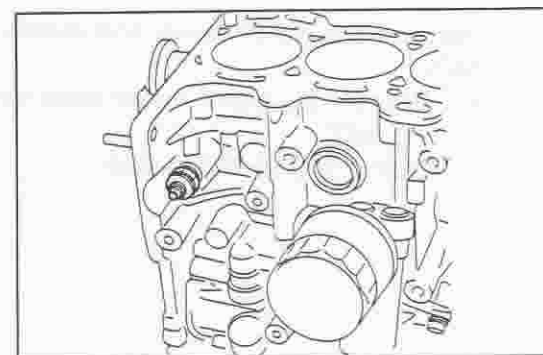
## DISASSEMBLY

1. Remove the timing chain. (For the removal procedure, refer to the Timing Chain section.)
2. Remove the cylinder head. (For removal procedure, refer to the Cylinder Head section.)
3. Drain the engine oil by removing the drain plug of the oil pan.
4. Drain the engine coolant by slackening the water drain cock. Remove the water drain cock.



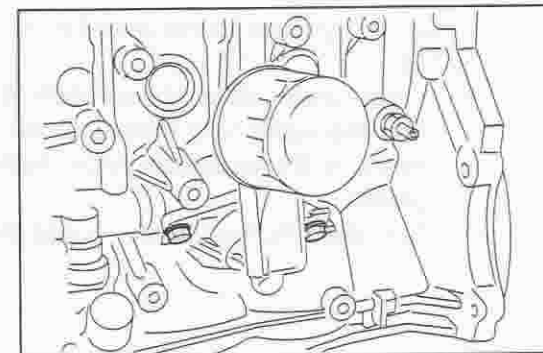
JEM00125-C0123

5. Remove the oil pressure switch.
6. Remove the knock sensor. (Except European specifications)



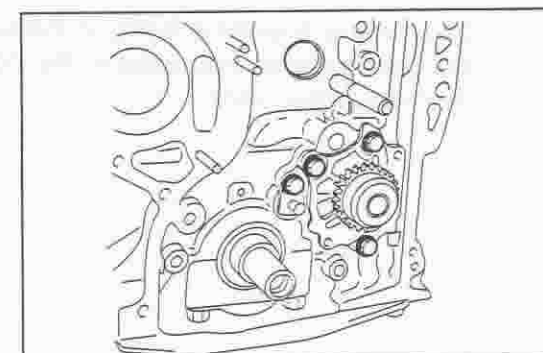
JEM00126-C0124

7. Remove the oil filter bracket.



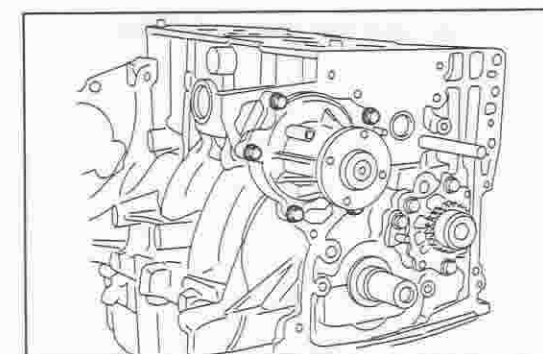
JEM00127-C0125

8. Remove the oil pump and chain oil nozzle.



JEM00128-C0126

9. Remove the water pump and gasket.



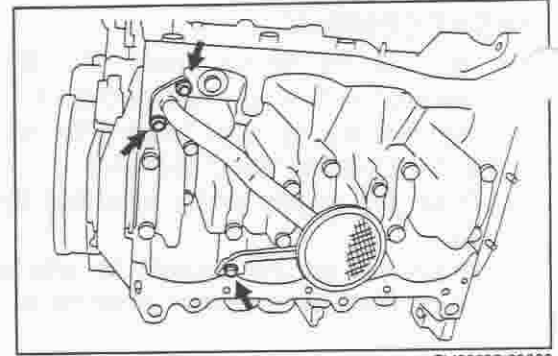
JEM00129-C0127

## EM-34

10. Remove the oil strainer. (M101 series only)

**NOTE:**

- On the J102 series, the oil strainer is provided on the oil pan.

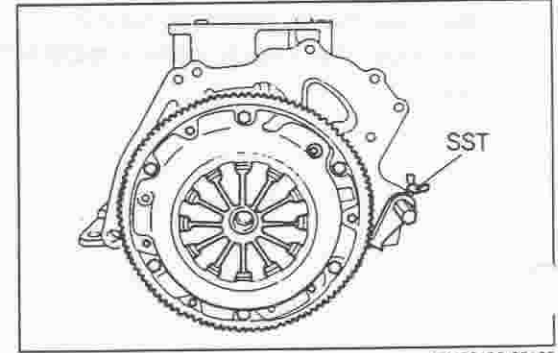


11. Remove the clutch cover and clutch disc.

**NOTE:**

- Prevent the clutch cover from turning, using the following SST.

SST: 09210-87701-000

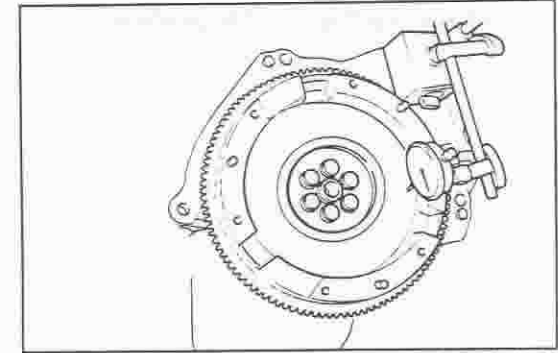


12. Check of flywheel (drive plate) runout.

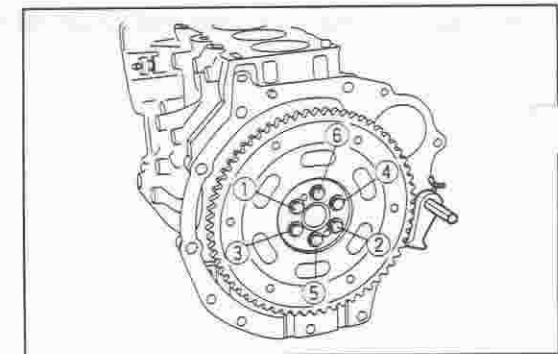
**NOTE:**

- If the runout does not conform to the specification, confirm the tightening torque of the tightening torque conforms to the specified value, replace the flywheel (drive plate).

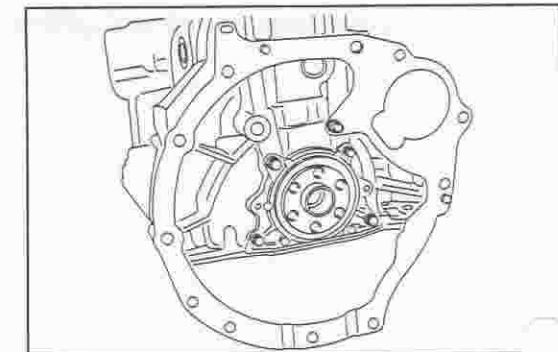
Specified Runout Limit: Less than 0.2 mm



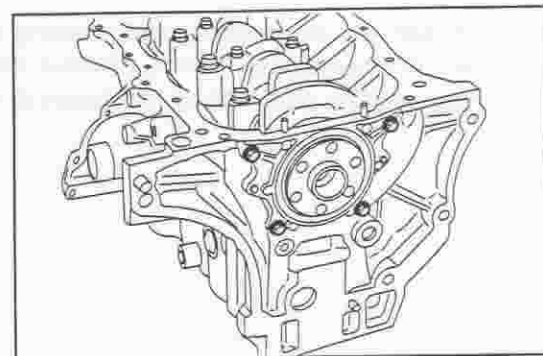
13. Loosen the attaching bolts of the flywheel (drive plate) in the sequence as indicated in the right figure. Remove the flywheel (drive plate).



14. Remove the rear end plate.



15. Remove the rear oil seal retainer from the cylinder block.



JEM00137-00135

16. Measurement of connecting rod thrust clearance.  
Measure the thrust clearance between the connecting rod and the crankshaft, using a thickness gauge.

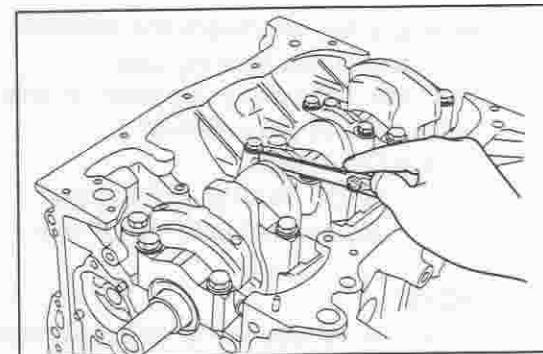
Thrust Clearance:

Specified Value: 0.10 - 0.30 mm

Maximum Limit: 0.35 mm

**NOTE:**

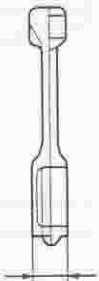
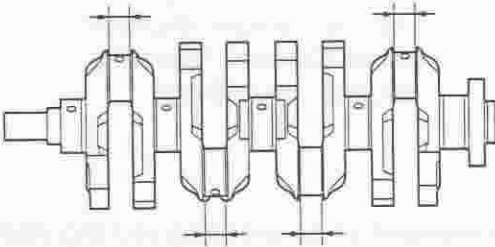
- The thrust clearance should be measured while the connecting rod is being pushed against either side of the crankshaft in the axial direction. Measure the thrust clearance at the opposite side.



JEM00138-00136

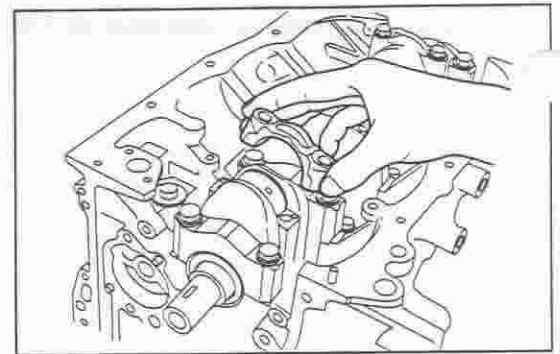
If the clearance exceeds the specified value, replace the connecting rod or the crankshaft, or both of them, referring to the width of the big end of the connecting rod in the thrust direction and the side width of the crankpin.

**[Reference]**

Width of big end of connecting rod in thrust direction	Side width of crankpin
17.79 - 17.84 mm	17.94 - 18.09 mm
Connecting rod 	Crankshaft 

JEM00139-00137

17. Loosen the connecting rod bearing cap bolts evenly over two or three stages. Then, remove the bolt.
18. Remove the connecting rod bearing cap.



19. Measure the oil clearance between the crankpin and the connecting rod bearing cap.  
(For the tightening method of the connecting rod cap bolts, refer to page EM-51.)

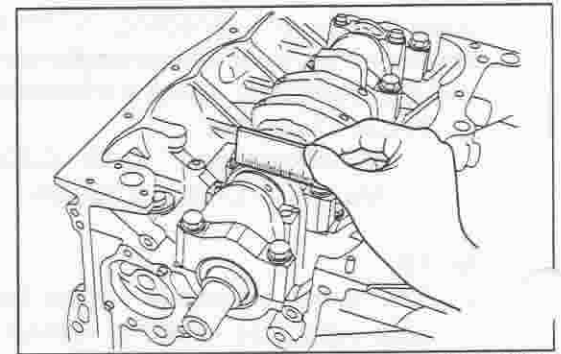
Oil Clearance:

STD: 0.016 - 0.040 mm

Maximum Limit: 0.07 mm

## NOTE:

- If the oil clearance does not conform to the specification, measure the crankpin diameter, connecting rod big end bore diameter and connecting rod bearing center thickness, following the procedure given below. Replace any part which will not conform to the specifications.

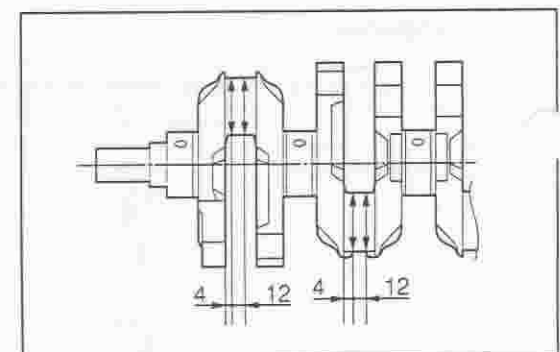


## Measurement of crankpin diameter

- ① Measure the crankpin diameter of the crankshaft in four directions for each crankshaft pin, 90 degrees spaced, at those points indicated in the right figure.
- ② The greatest value among the measured diameters is regarded as the crankpin diameter.

Specified Crankpin Diameter:

39.992 - 40.000 mm

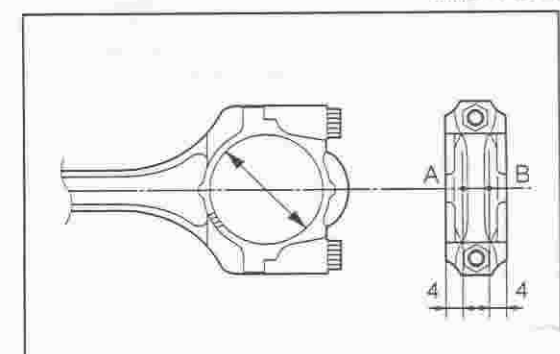


## Measurement of connecting rod big end bore diameter

- ① Perform measurement at the two points indicated in the figure.
- ② The smaller value among the measured diameters is regarded as the connecting rod big end bore diameter.

Specified Connecting Rod Big End Bore:

43.000 - 43.008 mm



### Measurement of connecting rod bearing center thickness

- ① Measure the connecting rod bearing center thickness.

Connecting Rod Bearing Center Thickness:

1.488 - 1.492 mm

JEM00144-00000

#### CAUTION:

- Since undersized bearings are available, the crank journals of a crankshaft which will not meet the specification can be machined according to the undersized bearing. In this case, perform machining of the crank pin, referring to the table below.

Kind of bearing	Crankpin diameter (mm)
U/S 0.25	39.726 - 39.766

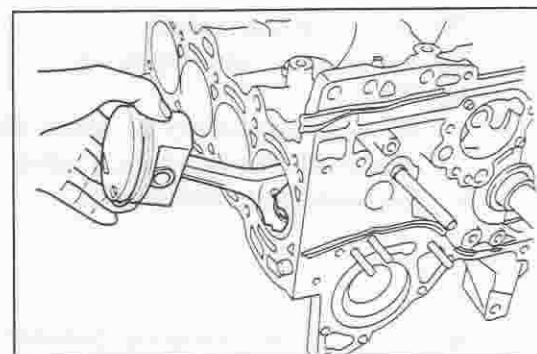
JEM00145-00000

### 20. Removal of piston

- (1) Push out the piston and connecting rod assembly and the upper bearing through the top of the cylinder block.

#### NOTE:

- Arrange the removed pistons and connecting rods so that their installation positions may be identified readily.
- Care should be exercised so as not to damage the bearings.



JEM00146-00142

### 21. Checking procedure of crankshaft thrust clearance

#### NOTE:

- Measure the thrust clearance, using a dial gauge.

Thrust Clearance:

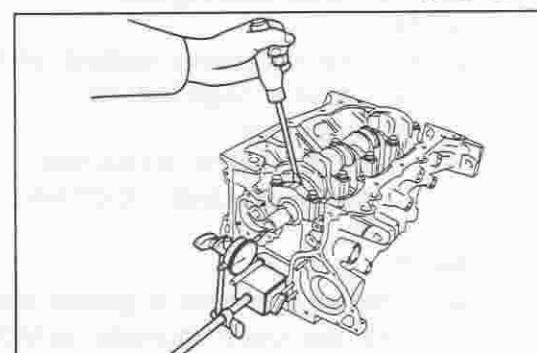
Specified Value: 0.02 - 0.22 mm

Maximum Limit: 0.30 mm

If the thrust clearance is greater than the maximum limit, replace the thrust washer as a set.

If the oversize (O/S) thrust washer is used, it is necessary to select a thrust washer so that the thrust clearance may come within the specified value.

If the employment of O/S washer fails to bring the thrust clearance within the specified value, replace the crankshaft.

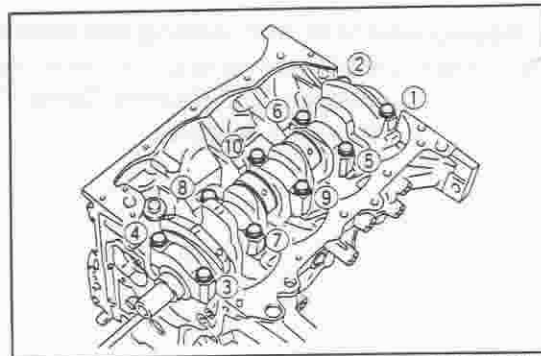


JEM00147-00143

Kind	Crankshaft thrust washer thickness
STD	1.940 - 1.990
O/S 0.125	2.003 - 2.053
O/S 0.25	2.065 - 2.115

## 22. Removal of crankshaft

- (1) Gradually loosen the main bearing cap bolts over three stages in the numerical sequence shown in the figure. Remove the bearing cap bolts.

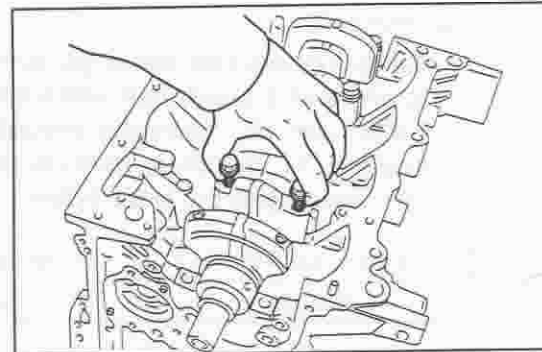


JEM00148-00144

- (2) With the main bearing cap bolts inserted into the bolt holes of the main bearing cap, wiggle the bearing cap back and forth. Remove the bearing cap together with the lower bearing.

### NOTE:

- Keep the lower bearing fitted to the main bearing cap. Arrange the removed main bearing caps in order.



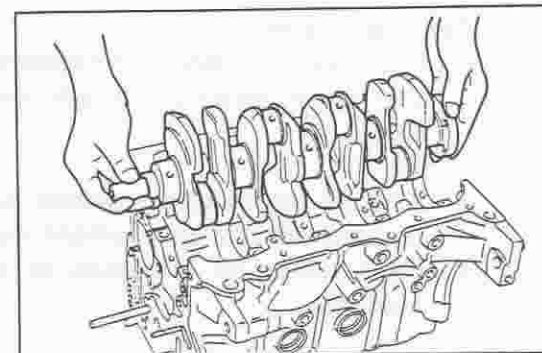
JEM00149-00145

- (3) Lift off the crankshaft.

- (4) Remove the upper bearing.

### NOTE:

- Be very careful not to allow the main bearings to be mixed with the bearings of other cylinders.
- Remove the thrust washer.



JEM00150-00146

## 23. Measure the oil clearance between the crank journal and the crankshaft bearing cap.

### NOTE:

- For the tightening method of the crankshaft bearing cap, refer to page EM-49.)

### Oil Clearance:

STD: 0.016 - 0.036 mm

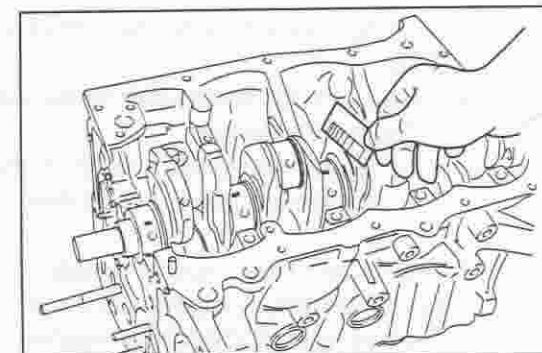
Maximum Limit: 0.07 mm

### NOTE:

- If the oil clearance is greater than maximum limit, measure the crank journals, cylinder block crank journal bore diameters and crankshaft bearing center thickness, following the procedure given below. Replace any part which will not conform to the specifications.

As an alternative method, when undersized bearings are available as replacement parts, machine the crank journal in such a way that the following formula given below may be satisfied.

Measured cylinder block crank journal bore diameter - (Measured crank journal diameter + Undersized bearing center thickness to be used  $\times 2$ ) = 0.016 - 0.036 mm



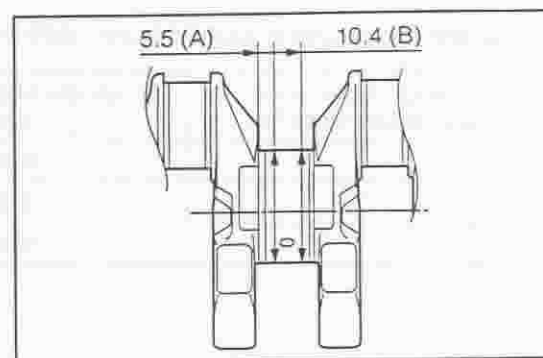
JEM000151-00147

**Measurement of crankshaft main journal diameter**

- ① Measure the crank journal outer diameter at the two points of "A" and "B", as indicated in the right figure.
- ② The greatest value among the measured diameters is regarded as the crank journal diameter.

Specified Crank Journal Diameter:

45.988 - 46.000 mm



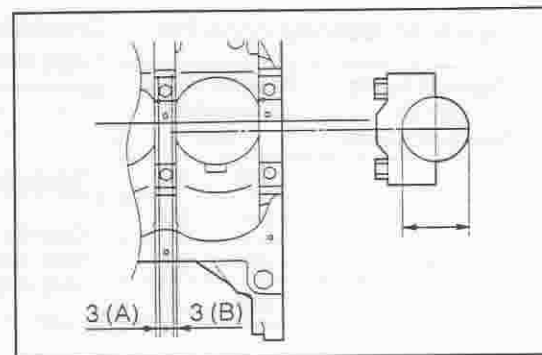
JEM00152-00148

**Measurement of cylinder block crank journal bore diameter**

- ① After the crankshaft bearings are tightened to the specified value, measure the bore diameter at the two points of "A" and "B" indicated in the right figure.
- ② The smaller value among the measured diameters is regarded as the cylinder block crank journal bore diameter.

Specified Cylinder Block Crank Journal Bore Diameter:

50.000 - 50.018 mm



JEM00153-00149

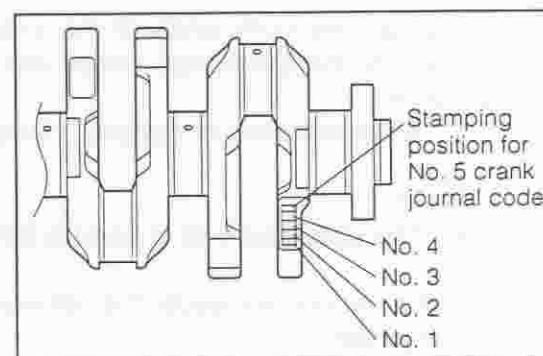
**CAUTION:**

- If the classification that has been determined by the measured value differs from the code attached to the part, be sure to carefully select the bearing.
- Since undersized bearings are available, the crank journals of a crankshaft which will not meet the specification can be machined according to the undersized bearing. In this case, perform machining of the crank journals, referring to the table below.
- When some parts only are replaced, the replacement should be done only when the classification matches with each other.

JEM00154-00000

Crank journal code No.

Crank journal code No.	Crank journal diameter (mm)
1	45.994 - 46.000
2	45.988 - 45.994



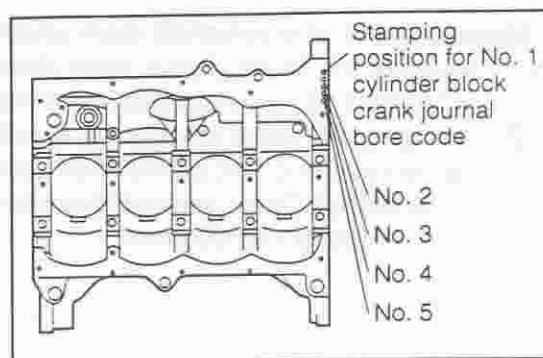
JEM00155-00150



# EM-40

Cylinder block crank journal bore code No.

Cylinder block crank journal bore code No.	Cylinder block crank journal bore diameter (mm)
1	50.000 - 50.006
2	50.006 - 50.012
3	50.012 - 50.018



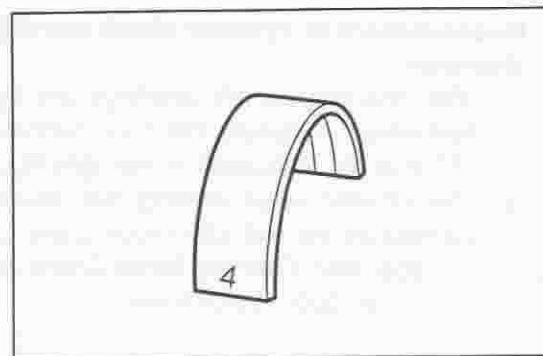
JEM00156-00151

Crankshaft bearing code No.

Crankshaft bearing code No. (Identification color)	Crankshaft bearing center thickness (mm)
2	1.988 - 1.992
3	1.991 - 1.995
4	1.994 - 1.998
5	1.997 - 2.001

Crankshaft bearing selection code No.

Crankshaft	Crankshaft main journal code No.			
	1	2	3	4
Cylinder block	1	2	3	4
Cylinder block main journal bore code No.	2	3	4	5
	3	4	5	



JEM00157-00152

Specified crank journal diameter

Kind of bearing	Cylinder block crank journal bore diameter (mm)	Crank journal diameter (mm)
U/S 0.25	50.000 - 50.006	45.730 - 45.764
	50.006 - 50.012	45.737 - 45.770
	50.012 - 50.018	45.743 - 45.776

JEM00158-00000

## INSPECTION

### Crank shaft

1. Check the main journals and bearings for pitting or scratches.  
If the main journals exhibits damage, repair or replace the crankshaft.  
If the main journal bearings are damaged, replace the main journal bearings.

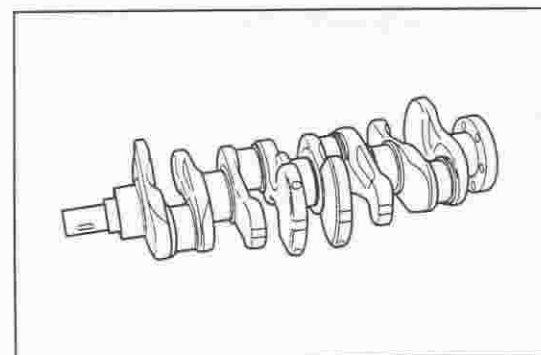
2. Support the both ends of the crankshaft with V-blocks. Measure the crankshaft runout with a dial gauge at No. 3 journal.

Allowable Limit of Runout: 0.03 mm

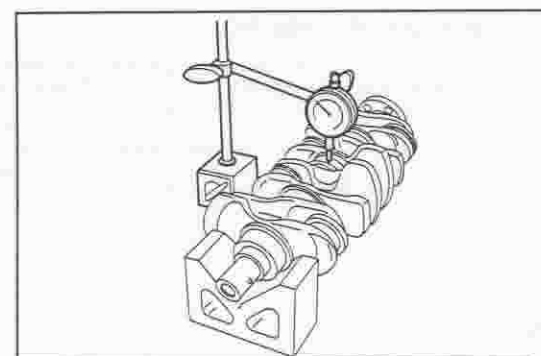
### NOTE:

- The allowable limit of bend is 0.015 mm

If the runout exceeds the allowable limit, replace the crankshaft.



JEM00159-00153



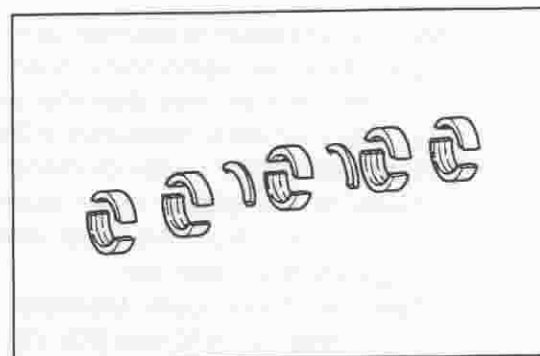
JEM00160-00154



**Crankshaft bearing & Connecting rod bearing**

Check the bearings for pitting or scratches.

If the bearings exhibits damage, replace the bearing.



JEM00161-00155

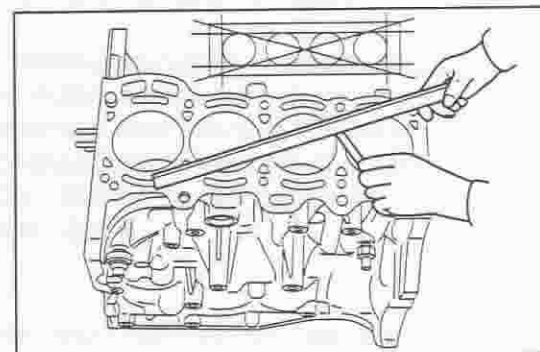
**Cylinder block**

## 1. Inspection of top surface of cylinder block

Using a precision straightedge and a thickness gauge, check the surface contacting the cylinder head gasket for warpage in the six directions as shown in the figure.

Maximum Warpage: 0.05 mm

If the warpage exceeds the allowable limit, replace the cylinder block or reface the upper gasket surface of the cylinder block, referring to the following cylinder block height as a limit.



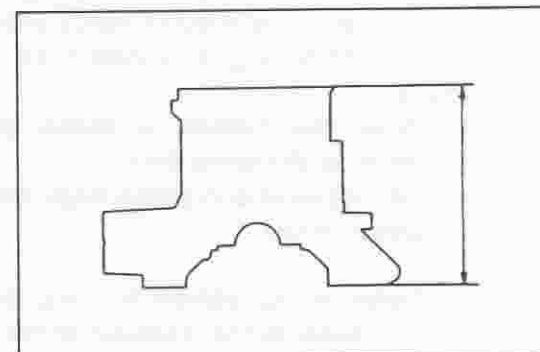
JEM00162-00156

Cylinder Block Minimum Height: 235.8 mm

(Reference)

Cylinder Block Height:

STD: 235.9 - 236.1 mm



JEM00163-00157

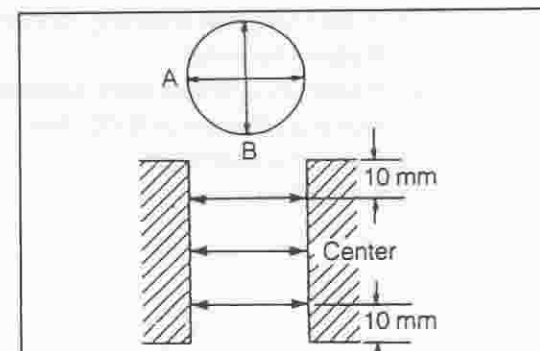
## 2. Measurement of cylinder bores

- (1) Measure the bore diameter of each cylinder at the six points shown in the right figure. Ensure that the difference between the maximum and minimum bore diameters of each cylinder is within 0.012 mm.

Specified Cylinder Bore Diameter:

72.000 - 72.012 mm

If the difference between the maximum and minimum values exceeds 0.03 mm, perform boring and/or honing for the cylinder bore in accordance with the over-sized piston.



JEM00164-00158

## 3. Inspection of piston-to-cylinder bore clearance

- (1) Calculate the piston-to-cylinder bore clearance based on the cylinder bore diameter and the piston outer diameter that were measured in Step 2.

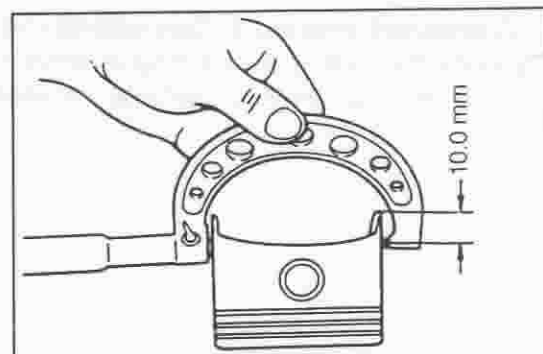
- (2) Measurement of piston diameter

Measure the piston outer diameter horizontally at a point 10 mm from the lower end of the piston at right angles to the piston pin.

Specified Piston Outer Diameter:

71.958 - 71.970 mm (K3-VE)

71.953 - 71.965 mm (K3-VE2)



JEM00165-00159

- (3) Calculation of piston-to-cylinder bore clearance

Subtract the measured piston outer diameter from the measured cylinder bore diameter.

Piston-to-Cylinder Bore Clearance:

Specified Value: 0.030 - 0.054 mm (K3-VE)

0.035 - 0.059 mm (K3-VE2)

If the piston-to-cylinder bore clearance exceeds the allowable limit, perform boring and/or honing for the cylinder bore in accordance with the oversized piston.

## 4. Boring and honing of cylinder bore

### NOTE:

- When the cylinder is bored, all cylinders should be bored at the same time.
- As for piston and piston rings, use oversized piston and piston rings.

- (1) Determining cylinder finishing diameter

- ① Measure the diameter of the oversized piston to be used, using a micrometer.

- ② Calculate the finishing dimension, as follows.

A: Piston diameter

B: Piston-to-cylinder bore clearance

C: Honing allowance 0.02 mm

D: Finishing diameter

$D = A + B - C$

(2) Hone the cylinder after the boring.

① Bore the cylinder, leaving a honing allowance of 0.02 mm.

② Hone the cylinder.

Honing Angle:  $35^{\circ} \pm 5^{\circ}$

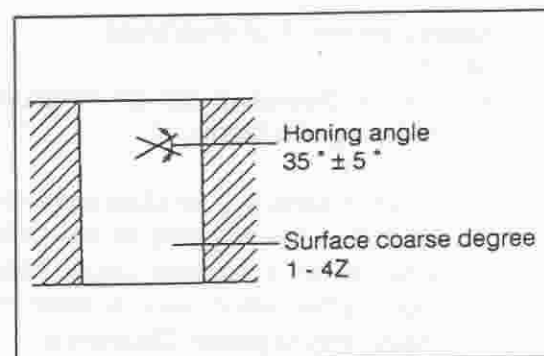
Surface Coarse Degree: 1 - 4Z

## [Reference]

- The table below shows the cylinder bore diameter when oversized pistons are used.
- However, after the diameter of the replacement piston has been measured, perform the finishing in accordance with the piston diameter.

(mm)

Kind	Engine type	Piston outer diameter	Cylinder bore
STD	K3-VE	71.958 - 71.970	72.003 - 72.015
	K3-VE2	71.953 - 71.965	71.998 - 72.010
0.50	K3-VE	72.458 - 72.470	72.503 - 72.515
	K3-VE2	72.453 - 72.465	72.498 - 72.510



JEM00166-00160

## Piston & Connecting rod

### CAUTION:

- The piston and piston pin are available only as a set so that the oil clearance may become the specified value. Therefore, if you replace a piston or a piston pin, be sure to replace them as a set. Moreover, the piston and piston pin should be handled at all times as a set. Care must be exercised so that no piston nor piston pin may be mixed with other ones.

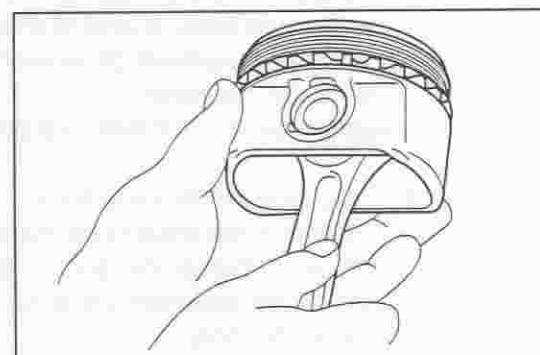
JEM00167-00000

### 1. Inspection of fit between piston and piston pin

Try to move the piston back and forth on the piston pin. If any movement is felt, inspect the piston and piston pin clearance.

### NOTE:

- When the piston is moved back and forth on the piston pin, you may encounter hard movement. However, if the piston moves smoothly without any binding, this fitting of the piston is normal.



JEM00168-00161

## 2. Measurement of oil clearance

### NOTE:

- The oil clearance can be measured, following the procedure given below.

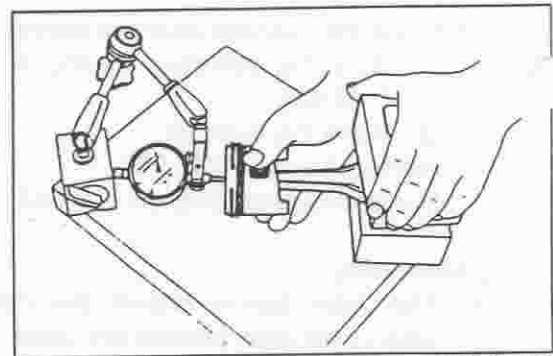
- When measuring oil clearance without disassembling: Interpose the big end of the connecting rod between V-block on a surface plate. Measure the play while moving the piston, as indicated in the right figure.

### Piston Pin-to-piston Clearance:

STD: 0.005 - 0.011 mm

Limit: 0.05 mm

If the oil clearance does not conform to the specification, replace the piston and piston pin. (There are no replacement parts for the piston only nor the piston pin only.)



JEM00169-00162

- When measuring oil clearance after disassembling (For disassembling procedure refer to the page EM-45.)

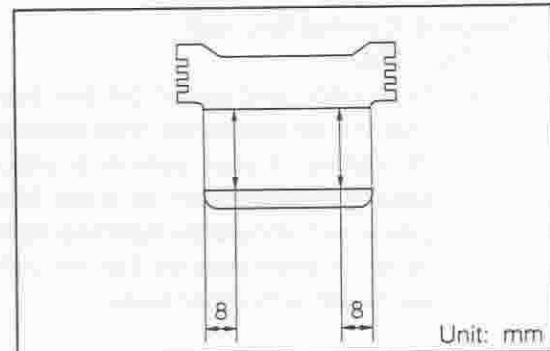
- ① Measure the diameter of the whole circumference at the positions A and B indicated in the right figure. The minimum dimension should be the piston pin hole diameter.

Specified Value: 18.007 - 18.010 mm

- ② Measure the diameter of the whole circumference at the positions A and B indicated in the right figure. The maximum dimension should be the piston pin outer diameter.

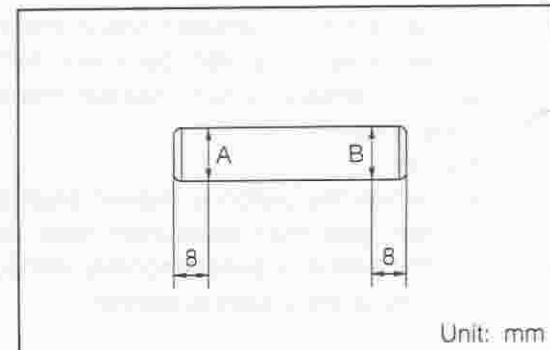
Specified Value: 17.999 - 18.002 mm

- ③ Calculate the oil clearance. If the oil clearance does not conform to the specification, replace the piston and piston pin. (There are no replacement parts for the piston only nor the piston pin only.)



Unit: mm

JEM00170-00163



Unit: mm

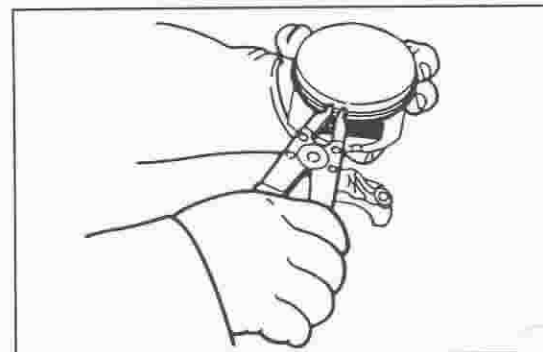
JEM00171-00164

## 3. Removal of piston rings

### NOTE:

- Arrange the removed piston rings in order so that their installation positions may be known readily.
- Do not expand the piston ring unnecessarily beyond the required extent.

- Remove the piston rings No. 1 and No. 2 using a piston ring expander.
- Remove the oil ring side rails by hand.
- Remove the oil ring expander by hand.



JEM00172-01

#### 4. Inspection of piston ring groove side clearance

Measure the side clearances of the piston rings over the entire periphery of each groove, using a thickness gauge. The maximum measured value is regarded as the piston ring side clearance.

Piston ring side clearance

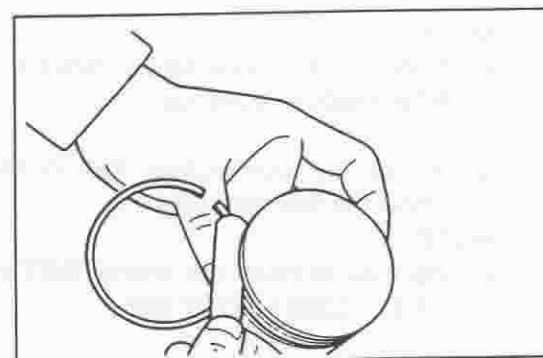
(mm)

		Specified value	Allowable limit
Compression ring No. 1	Unleaded	0.035 - 0.080	0.12
	Leaded	0.030 - 0.080	
Compression ring No. 2	Unleaded	0.020 - 0.060	0.11
	Leaded	0.020 - 0.060	
Oil ring	Unleaded	0.030 - 0.110	—
	Leaded	0.070 - 0.150	

Replace the piston ring and/or piston so that the piston ring side clearance may become less than the allowable limit.

#### NOTE:

- When replacing the piston rings, a set of piston rings for one cylinder should be replaced.



JEM00173-00166

#### 5. Inspection of piston ring end gap

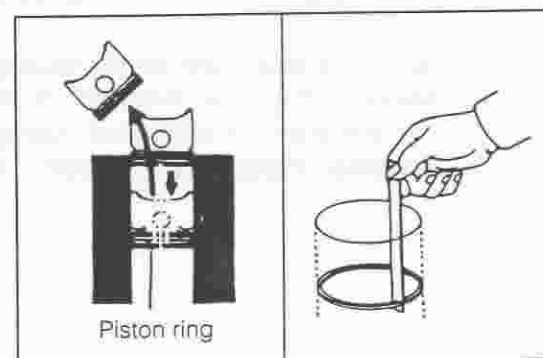
- Apply engine oil to the cylinder walls.
- Insert the piston rings into the cylinder bore.
- Using a piston, push down the piston ring to a point 45 mm from the cylinder block upper surface.
- Measure the piston ring end gap, using a thickness gauge or a feeler gauge.

Piston ring end gap

(mm)

		Specified value	Allowable limit
Compression ring No. 1		0.20 - 0.30	0.65
Compression ring No. 2	Unleaded	0.40 - 0.55	0.65
	Leaded	0.35 - 0.50	
Oil ring (Side rail)	Unleaded	0.15 - 0.50	0.69
	Leaded	0.20 - 0.50	

If the piston ring end gap exceeds the allowable limit, a set of piston rings for one cylinder should be replaced.



JEM00174-00167

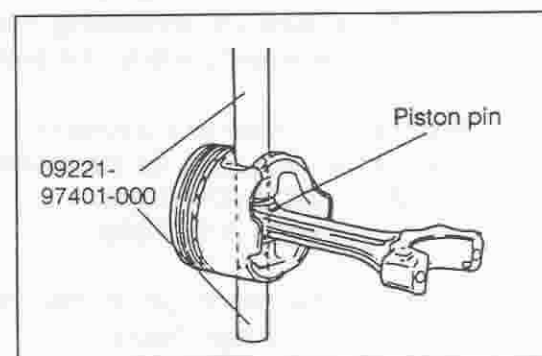
#### 6. Disassembly of piston and connecting rod

Use the following SSTs for the disassembling operation.

SST: 09221-97401-000

09221-87207-000

- Set the SST to the piston as shown in the right figure.



JEM00175-00168

**NOTE:**

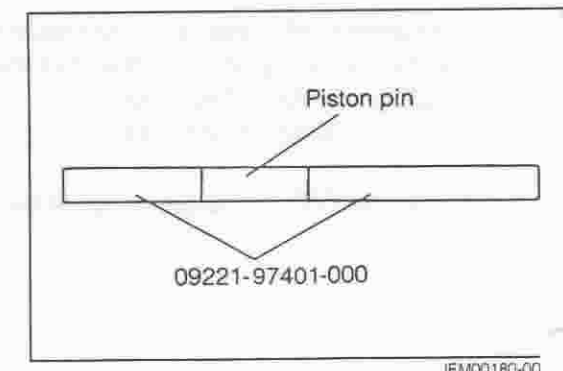
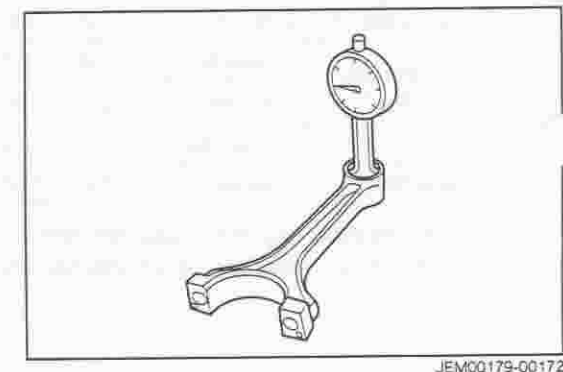
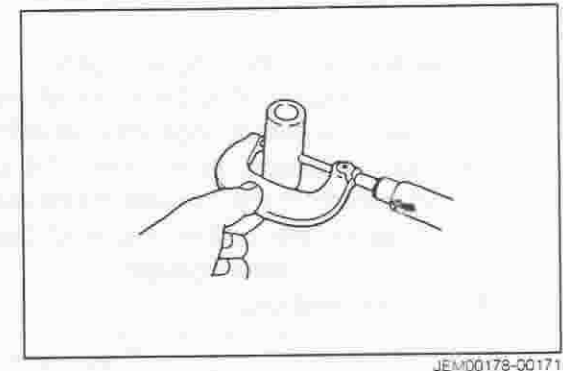
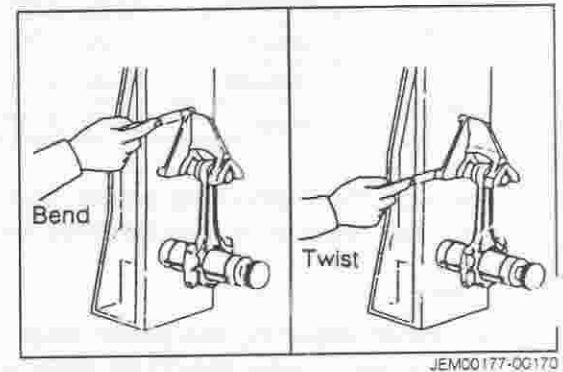
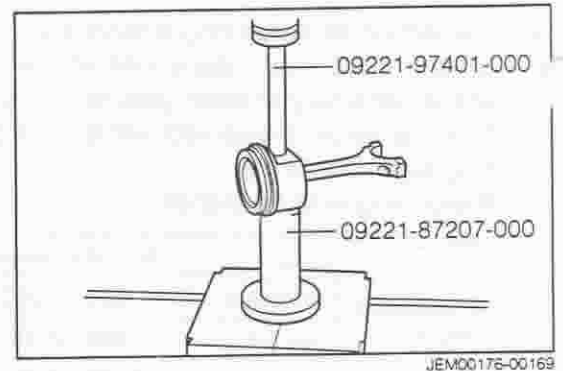
- Prior to this operation, remove the spacer 09221-97401-000 in advance.

- (2) Install the connecting rod in the following SST as shown in the right figure.

**NOTE:**

- Be sure to insert the shorter SST into the base side.  
SST: 09221-87207-000

- (3) Press off the piston pin, using a hydraulic press.



**7. Inspection of connecting rods**

- (1) Visually inspect the connecting rods for damage or cracks.
- (2) Check the connecting rod for bend and twist, using a connecting rod aligner.  
Maximum Bend: 0.05 mm  
Maximum Twist: 0.05 mm

If the bend and/or twist is greater than the maximum limit, replace the connecting rod assembly.

**8. Inspection of piston pin-to-connecting rod interference fit**

- (1) Measure the outer diameter of the piston pin contacting with the connecting rod, using a micrometer.  
Specified Piston Pin Diameter: 17.999 - 18.002 mm

- (2) Measure the inner diameter of the connecting rod, using a bore dial gauge.  
Specified Connecting Rod Inner Diameter: 17.965 - 17.985 mm

- (3) Determine the interference fit by subtracting the outer diameter of the piston pin from the inner diameter of the connecting rod.  
Interference Fit: 0.014 - 0.037 mm

If the interference fit does not conform to the specification, replace the connecting rod or piston. (There are no replacement parts for the piston pin only.)

**9. Assembly of piston and connecting rod**

Use the following SSTs for the assembling operation.

SST: 09221-97401-000  
09221-87207-000

- (1) Install the piston pin to the following SST in a way shown in the right figure.  
SST: 09221-97401-000

- (2) Install the piston and connecting rod in the SST in a way shown in the right figure. Insert the SST with the piston pin installed into the piston pin hole.

**NOTE:**

- The piston and connecting rod should be assembled in such a way that the piston front mark and connecting rod front mark come in the same direction.
- Prior to this operation, install the spacer 09221-87207-000 in advance.

- (3) Press the piston pin into the piston and connecting rod, using a hydraulic press.
- (4) Remove the piston and connecting rod assembly from the SST. Remove the SST from the piston pin.



JEM00181-00174

## Rear oil seal retainer

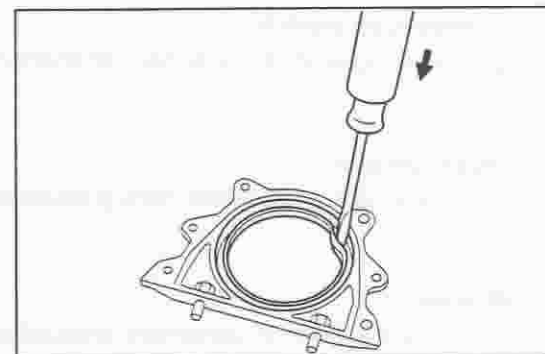
### Replacement of rear oil seal

#### 1. Removal of rear oil seal

Remove the rear oil seal from the rear oil seal retainer, using a pin punch.

**NOTE:**

- Be very careful not to damage the oil seal retainer.



JEM00182-00175

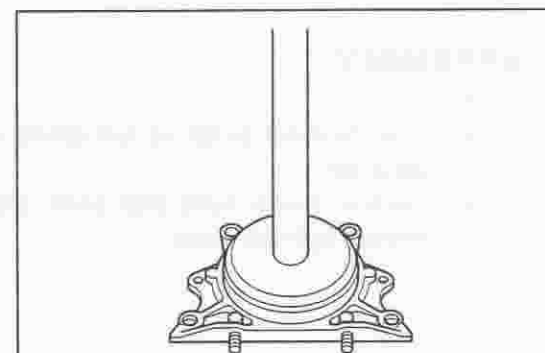
#### 2. Installation of rear oil seal

Drive a new rear oil seal into position, using the following SST.

SST: 09608-87302-000

**NOTE:**

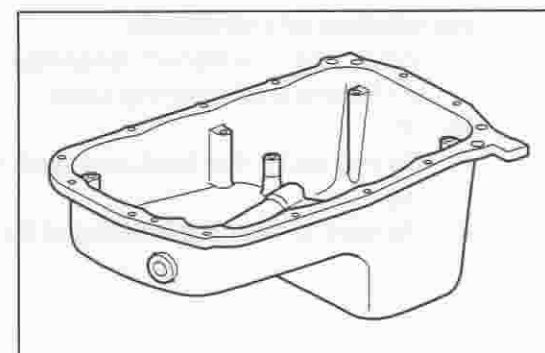
- Care must be exercised to ensure that the oil seal is not driven in a tilted state.



JEM00183-00176

## Oil pan

Visually inspect the oil pan for damage or cracks. Replace the oil pan, as required.



JEM00184-00177

## Flywheel

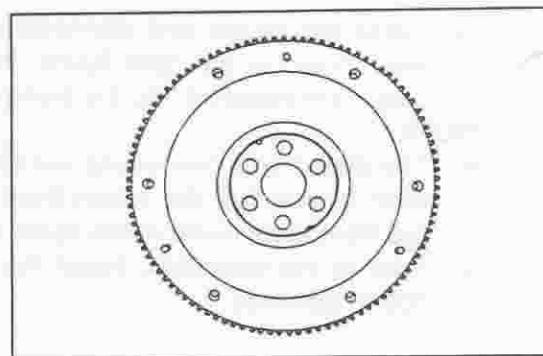
Inspect the flywheel for cracks or damage.

Inspect the ring gear for damage.

Replace the flywheel if it exhibits defects.

### CAUTION:

- Never disassemble the flexible type flywheel by removing the flex-plate from the flywheel subassembly. If the flywheel has undergone disassembling, it would cause breakage of the flywheel due to unbalanced flywheel mass, while the engine is running.
- Never expose the flexible type flywheel to flame of a burner, etc. If the flywheel is exposed to flame of a burner, for example, at the time of replacement of the ring gear, the quenched state of the flex-plate will be weakened. This may lead to breakage during the engine running.



JEM00185-00173

## Oil pressure switch

For checking and replacement procedure, refer to the LU section.

## Knock sensor

For checking and replacement procedure, refer to the EF section.

## Oil filter

For checking and replacement procedure, refer to the LU section.

JEM00186-00000

## ASSEMBLY

### NOTE:

- The cylinder block is furnished along with the pistons as a set.
- Hence, make sure that each piston is installed in the mated cylinder bore.

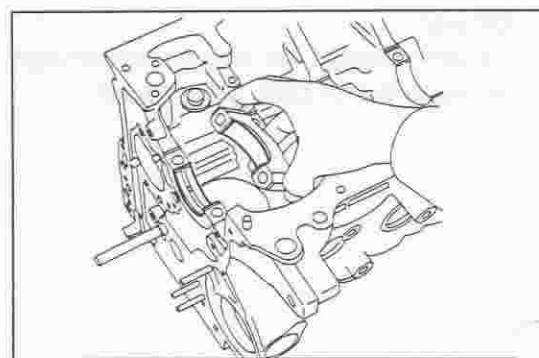
JEM00187-00000

### 1. Installation of crankshaft

- (1) Install the crankshaft bearings to the cylinder block and crankshaft bearing caps.

### NOTE:

- Do not touch the front and back surfaces of each bearing.
- Be sure to hold the bearing at its edge surfaces.



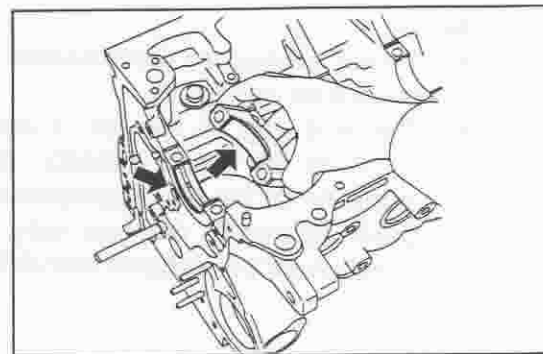
JEM00188-00112



(2) Apply engine oil to the surface of each bearing.

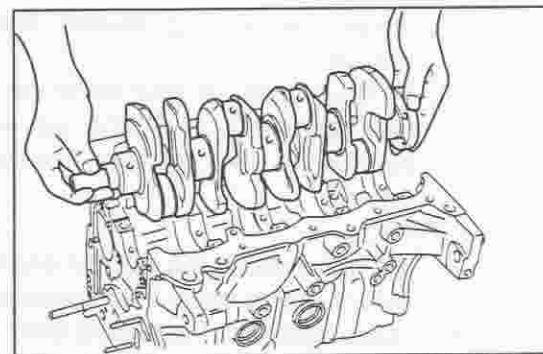
NOTE:

- Do not apply oil to the backside of the bearing.



JEM00189-0018C

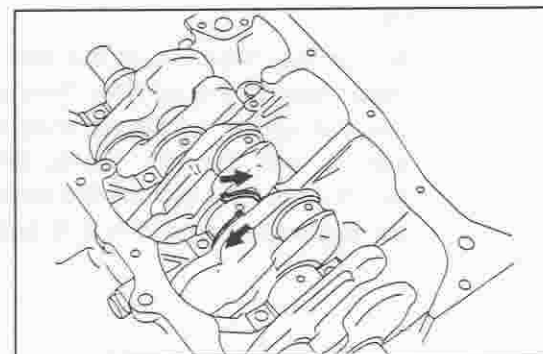
(3) Install the crankshaft in the cylinder block.



JEM00190-00181

(4) Install the thrust washer on each side of the No. 3 journal of the cylinder block.

- Apply engine oil to the two thrust washers.
- With the oil groove of the thrust washer facing toward the outside, slip the thrust washer into the gap between the cylinder block and the crankshaft, starting from the side without the notch.

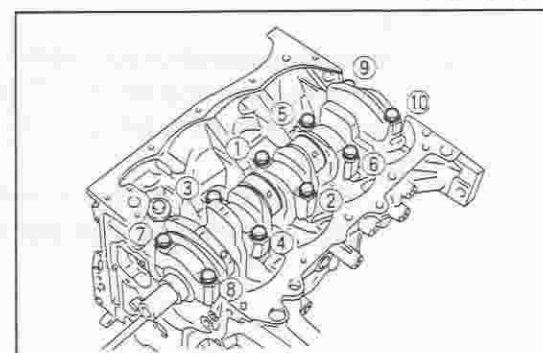


JEM00191-00182

(5) Install the crankshaft bearing caps with the arrow marks facing toward the oil pump side and also in the numerical sequence.

(6) Thinly apply engine oil to the crankshaft bearing cap bolts. Tighten the bolts to the specified torque over two or three stages in the sequence shown in the right figure.

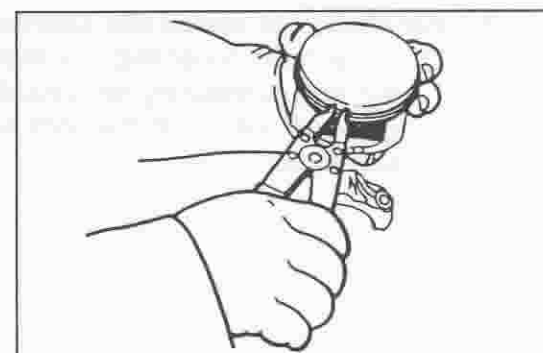
Tightening Torque: 53.0 - 65.0 N·m



JEM00192-00183

## 2. Assembly of piston

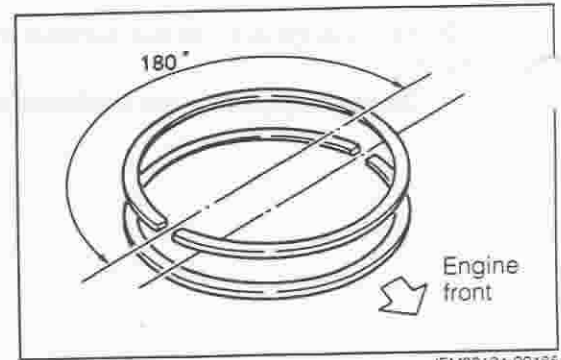
(1) Install the compression rings No. 1 and No. 2 with the stamped mark facing upward, using a piston ring expander.



JEM00193-00184

## NOTE:

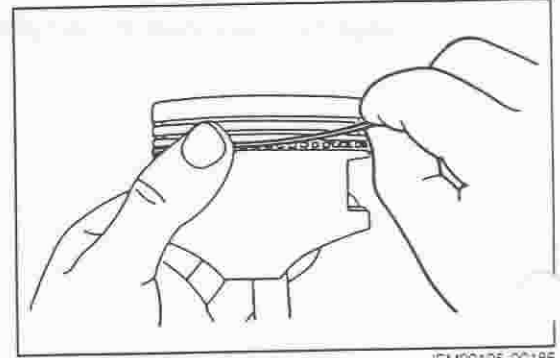
- Do not expand the compression ring to an extent that is more than necessary.
- The end gap of the No. 1 compression ring should come at the thrust direction (at the intake manifold side). As for the No. 2 compression ring, turn it 180 degrees so that its end gap may come at the anti-thrust direction (at the exhaust manifold side).



- Install the oil ring spacer expander in the oil ring groove.
- Fit the upper rail and lower rail into position in such a manner that it is wound up while pushing the edge section of the oil ring spacer expander with your thumb.

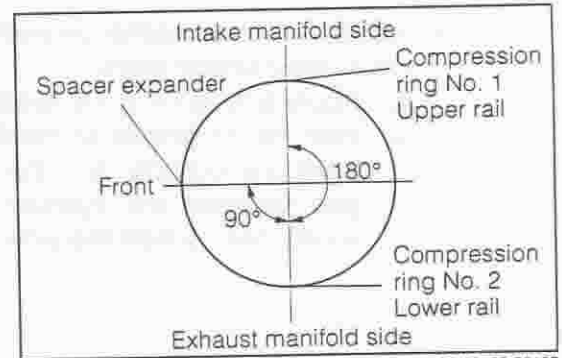
## NOTE:

- Do not expand the spacer expander and the rail to an extent that is more than necessary.
- Make sure that the oil ring can be turned smoothly.



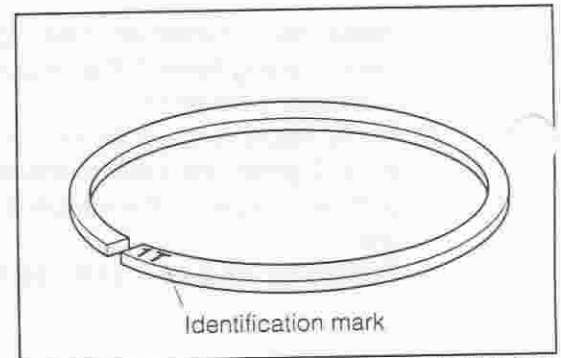
## NOTE:

- As for the direction of the end gaps of the upper and lower rails of the oil ring, they should be assembled so that the upper rail should come in the same direction as with the No. 1 ring; the lower rail, as with the No. 2 ring. The end of the spacer expander should be 90 degrees off from the end gap of the rail.



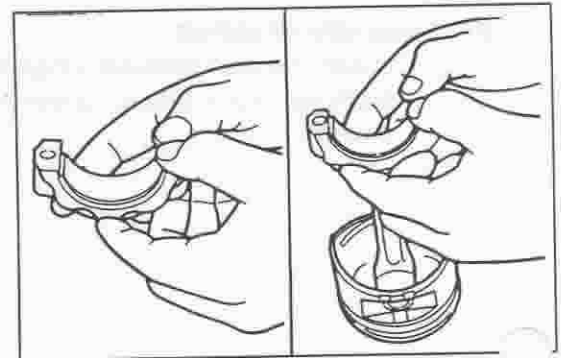
## NOTE:

- Piston ring identification mark
- Compression Ring No. 1: T (leaded), 1R (unleaded)
- Compression Ring No. 2: IT (leaded), R (unleaded)
- Oil Ring:
- Brown color paint mark on the end gap (leaded)
- No paint mark on end gap section (unleaded)



## 3. Installation of piston and connecting rod

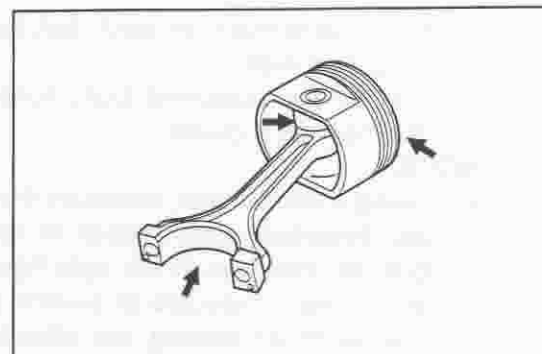
- Install the connecting rod bearings on the connecting rod and connecting rod cap, making sure that your fingers will not touch the front and back surfaces of the bearings.



- (2) Apply engine oil to the piston rings, piston pins, connecting rod bearings, cylinder walls and crankpin journals.

**NOTE:**

- Apply a small amount of engine oil to each cylinder bore.
- Apply a small amount of engine oil to each piston ring section.



JEM00199-00190

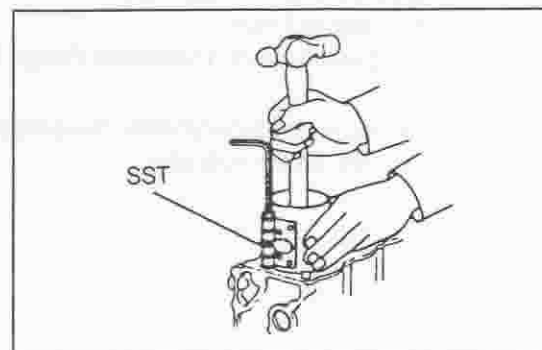
- (3) Compress the piston rings by means of the piston ring compressor SST, making sure that the piston ring ends will not move during the installation.

SST: 09217-87001-000

- (4) Push the piston by hand into the cylinder bore with the front mark facing toward the oil pump side.

**NOTE:**

- Be very careful to avoid damaging the connecting rod bearings during the installation.
- Care must be exercised to ensure that the crankpin is not scratched by the connecting rod.



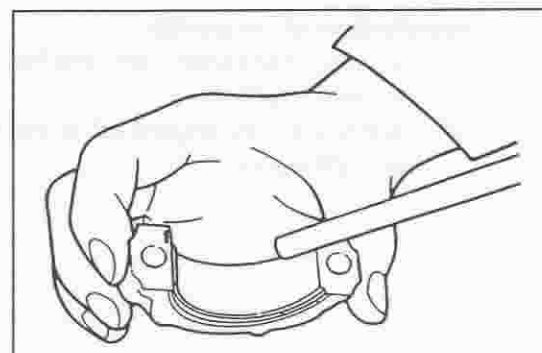
JEM00200-00191

- (5) Push the piston with a suitable tool, until the connecting rod reaches the crankpin journal.

- (6) Apply engine oil to the bearing surface of each connecting rod bearing.

**NOTE:**

- Do not touch the bearing front surface.



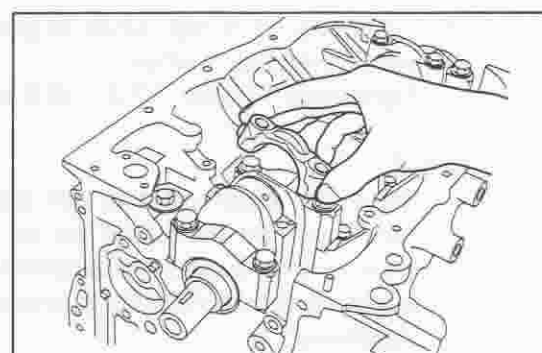
JEM00201-00192

- (7) With the front mark of the connecting rod facing toward the oil pump side, install the connecting rod cap, while fitting the knock pin of the connecting rod cap into the knock pin hole of the connecting rod.

- (8) Apply a small amount of oil to the seat surface of the connecting rod cap bolt and its threaded portion.

- (9) Tighten the connecting rod cap bolt over several stages to the specified torque.

Tightening Torque: 19.5 - 24.5 N·m



JEM00202-00193

**NOTE:**

- Prevent the crankshaft from turning, using the following SST.

SST: 09210-87701-000

- (10) Put a paint mark on each bolt head section at the engine front side.
- (11) Tighten the attaching bolts further 90 degrees, using the mark as a guide.

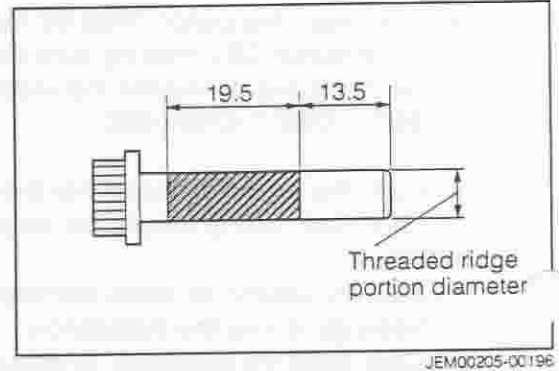
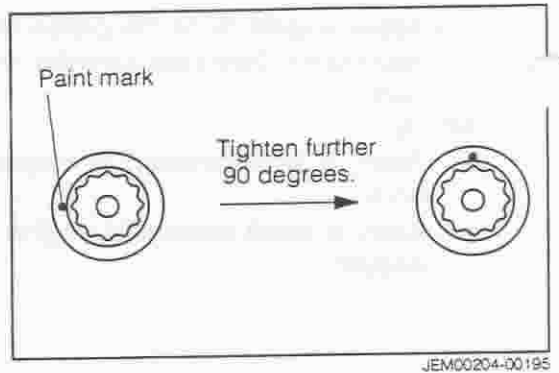
**NOTE:**

- Using a micrometer, measure the diameter of the shaded, threaded ridge portion of the connecting rod cap bolt, as indicated in the right figure. This measurement should be conducted at several points. If the diameter has worn exceeding the allowable limit, replace the connecting rod cap bolt.

Allowable Limit:

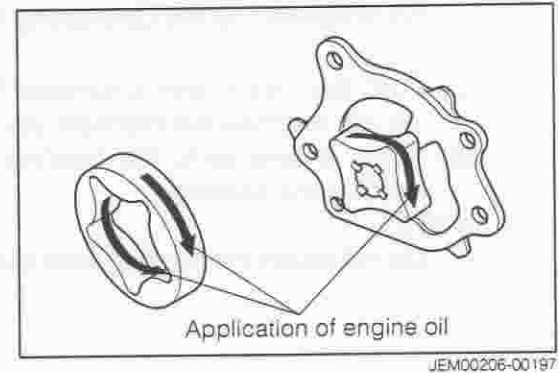
Diameter of Threaded Ridge Diameter: 7.7 mm

- (12) Perform the operations described in Steps (1) through (11) for each cylinder.



## 4. Installation of oil pump

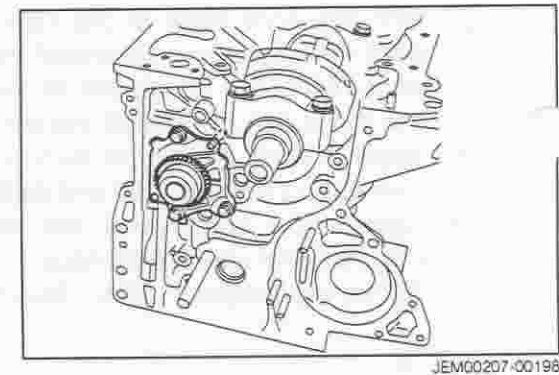
- (1) Turn the crankshaft, until the No. 1 cylinder is set to the top dead center.
- (2) Liberally apply engine oil to the section as indicated in the right figure.



- (3) Install the oil pump, while aligning the positions of the knock pins each other.
- Tightening Torque: 7.2 - 10.8 N·m

**NOTE:**

- Since the outer rotor is not secured to the oil pump, care must be exercised so as not to allow the outer rotor to drop during the installation.
- Make sure that no foreign matter is lodged during the installation.



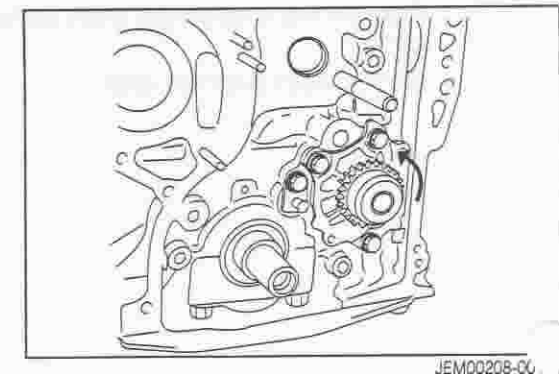
- (4) After completion of the assembly, turn the sprocket more than one turn so that engine oil may be circulated thoroughly over the entire surface of the rotor.

**NOTE:**

- Ensure that the sprocket can be turned smoothly.

- (5) Install the chain nozzle.

Tightening Torque: 5.3 - 9.7 N·m



## 5. Installation of rear oil seal retainer

- (1) Apply engine oil to the inner surface of the oil seal.
- (2) Apply the liquid gasket or equivalent to the flange surface in such a way that the sealing may be formed without any discontinued spot, in a size equivalent to a 3 mm to 4 mm diameter, following the procedure given in the right figure.

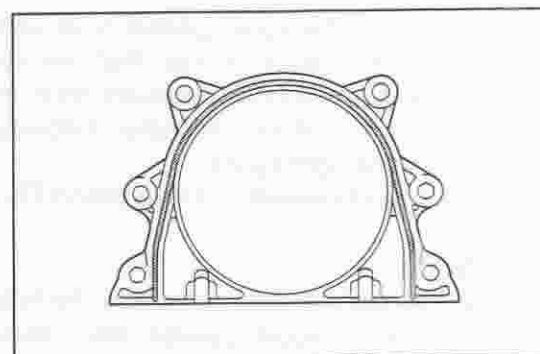
Liquid Gasket: Three Bond TB 1280E or equivalent

### NOTE:

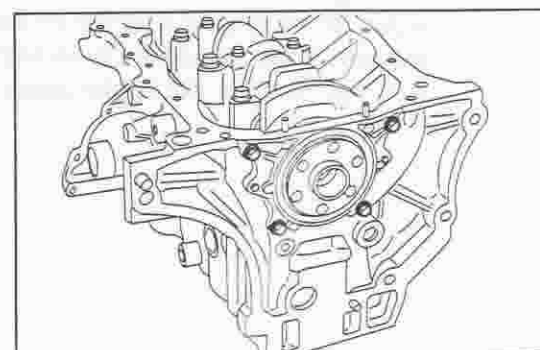
- The assembling should be carried out within three minutes after the application of liquid gasket.

- (3) With the rear oil seal retainer aligned with the knock pin, install the rear oil seal retainer to the cylinder block.

Tightening Torque: 6.8 - 10.2 N·m



JEM00209-00200



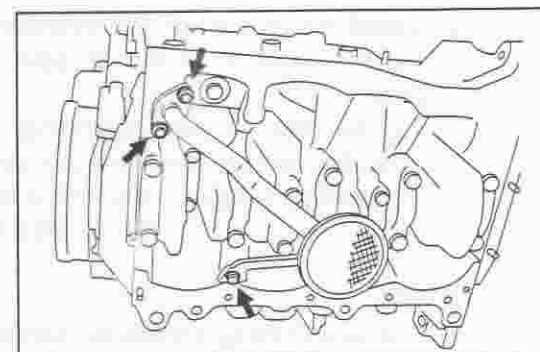
JEM00210-00201

## 6. Installation of oil pump strainer

(M101 series)

Install the oil strainer to the cylinder block.

Tightening Torque: 6.0 - 11.0 N·m

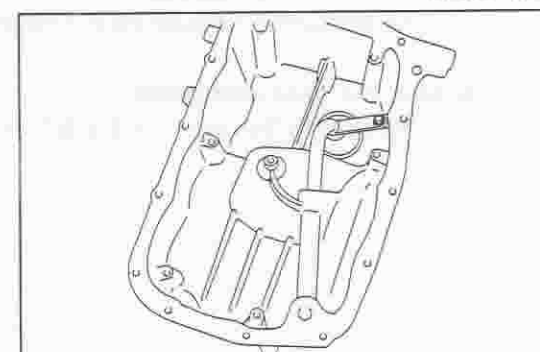


JEM00237-00221

(J102 series)

Install the oil strainer to the oil pan.

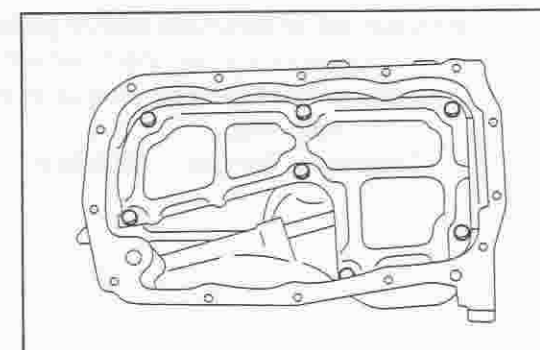
Tightening Torque: 6.0 - 11.0 N·m



JEM00211-00202

## 7. Installation of oil pan

- (1) Install the baffle plate.
- (2) Thoroughly remove any foreign matters (grease and water, etc.) from both the oil pan attaching surface of the cylinder block and the cylinder block attaching surface of the oil pan.



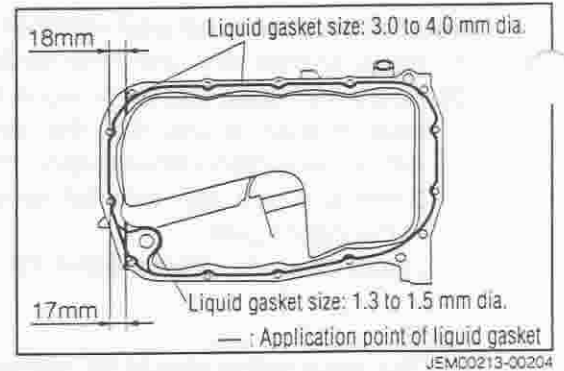
JEM00212-00203

- (3) Apply the liquid gasket or equivalent to the flange surface in such a way that the sealing may be formed without any discontinued spot, in a size equivalent to a 3 mm to 4 mm diameter, following the procedure given in the right figure.

Liquid Gasket: Three Bond TB 1280E or equivalent

**NOTE:**

- As for the start point and the finish point of the application of liquid gasket, they should be avoided at the sealing surfaces of the chain cover at the front & rear sides of the engine and the oil seal retainer. Instead, they should be selected at the sealing surface with the block at the intake side or the exhaust side.



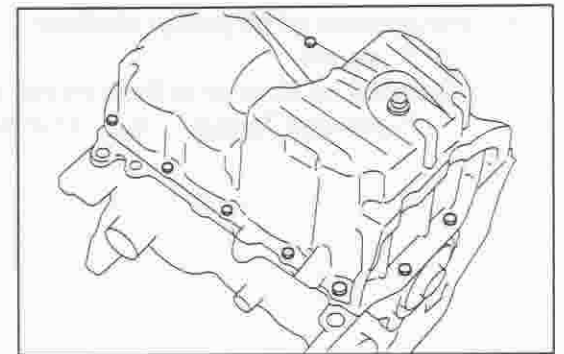
- (4) Install the oil pan on the cylinder block, after determining the location of the oil pan, using the two straight pins.

- (5) Tighten the oil pan attaching nuts and bolts to the specified torque over two or three stages.

Tightening Torque: 6.0 - 11.0 N·m (M6 × 1.0)  
29.4 - 54.6 N·m (M10 × 1.25)

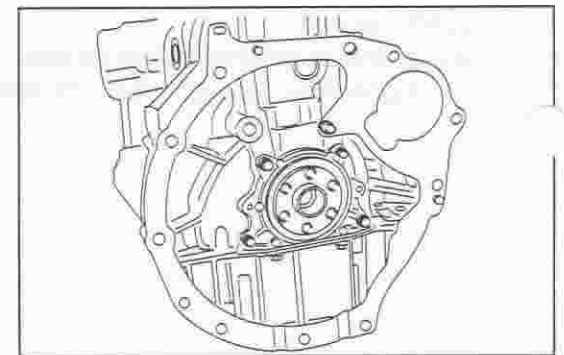
**NOTE:**

- The assembling should be carried out within three minutes after the application of liquid gasket. Furthermore, the tightening should be performed within 15 minutes.



**8. Install the rear end plate.**

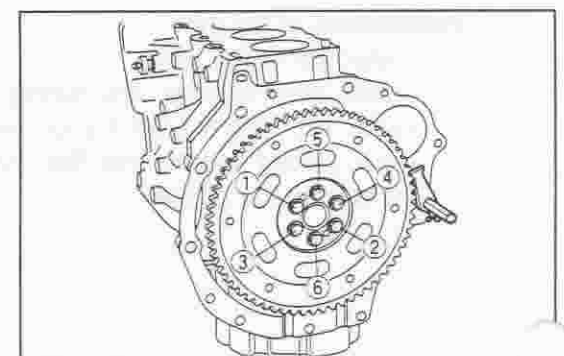
Tightening Torque: 5.3 ± 9.7 N·m



**9. Installation of flywheel (drive plate)**

- (1) Temporarily tighten the flywheel (drive plate) attaching bolts to the following torque in the sequence indicated in the next step.

Tightening Torque: 32.0 N·m

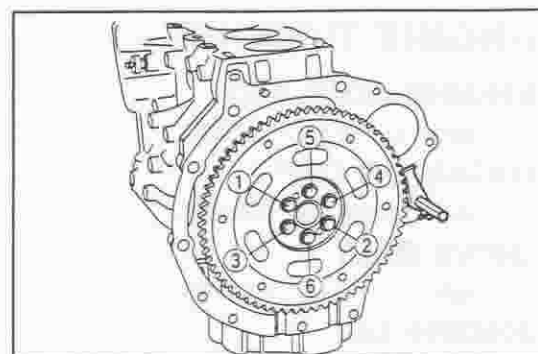


- (2) Tighten the flywheel (drive plate) attaching bolts to the specified torque in the sequence indicated in the right figure.

Tightening Torque: 73.3 - 82.7 N·m

**NOTE:**

- Prevent the crankshaft from turning at the ring gear section, using the following SST.  
SST: 09210-87701-000
- If the bolts are used again, be sure to apply liquid gasket on the threaded portions of the bolts.  
Liquid Gasket: Three Bond TB 1324 or equivalent



JEM00217-00206

10. Check the flywheel runout. (For checking procedure, refer to the page EM-34.)

11. Install the clutch cover and clutch disc.

**NOTE:**

Prevent the clutch cover from turning, using the following SST.

SST: 09210-87701-000

12. Install the water pump and gasket.

Tightening Torque: 7.2 - 11.7 N·m

13. Install the oil filter bracket.

Tightening Torque: 6.0 - 11.0 N·m

14. Install the oil pressure switch with the sealing agent applied to its threaded portion.

Sealing Agent: Locktight 525 or equivalent

Tightening Torque: 10.5 - 19.5 N·m

**NOTE:**

- Be very careful not to get the sealing agent to the oil entering hole.

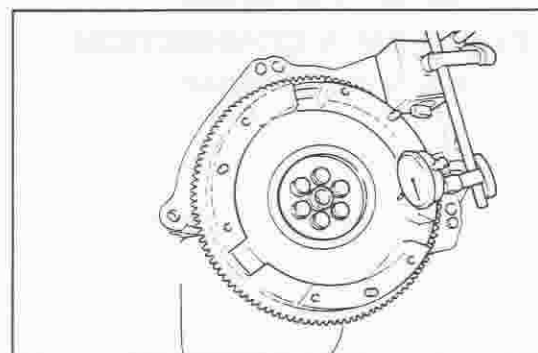
15. Install the water drain cock.

16. Install the knock sensor. (Except European specifications)

Tightening Torque: 35.2 - 52.8 N·m

17. Install the cylinder head. (For installation procedure, refer to the "CYLINDER HEAD" section.)

18. Install the timing chain. (For installation procedure, refer to the "TIMING CHAIN" section.)



JEM00218-00209



# EM-56

## ENGINE TUNE-UP

### ENGINE COOLANT

Refer to the CO section.

### RADIATOR CAP

Refer to the CO section.

### DRIVE BELT

Refer to the CH section.

### ENGINE OIL

Refer to the LU section.

### SPARK PLUG

Refer to the IG section.

### VALVE CLEARANCE

Refer to the EM-29.

### IGNITION TIMING

Refer to the IG section.

### BATTERY

Refer to the CH section.

### CHARCOAL CANISTER

Refer to the EC section.

### FUEL LINE & CONNECTION

Refer to the EC section.

JEM00219-00000

## COMPRESSION CHECK

### NOTE:

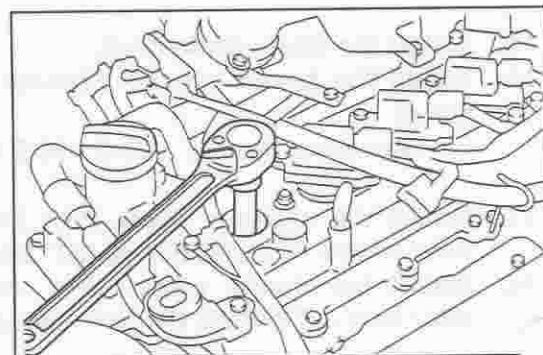
- After completion of the engine tune-up, if the engine exhibits lack of power, excessive oil consumption or poor fuel economy, measure the cylinder compression pressure.

1. Warm up the engine thoroughly.
2. Turn OFF the ignition key switch.
3. Remove the fuel pump relay from the relay box.
4. Remove the spark plug from the cylinder head.
5. Measurement of cylinder compression pressure

### NOTE:

- Perform the measurement in the shortest possible time.
- Crank the engine for the same duration for each cylinder.
- Always use a fully charged battery so that at least a revolution speed of 400 rpm is attained.

JEM00220-00000



JEM00221-00000



- (1) Insert a compression gauge into the spark plug hole.
- (2) Depress the accelerator pedal fully.
- (3) While cranking the engine, measure the compression pressure.

Compression Pressure:

(K3-VE)

1471 kPa at 330 rpm

Limit: 1079 kPa at 330 rpm

(K3-VE2)

1285 kPa at 300 rpm

Limit: 892 kPa

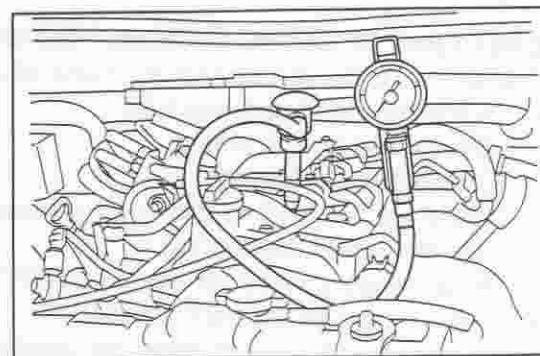
Difference Between Cylinders:

(K3-VE)

147 kPa at 330 rpm

(K3-VE2)

147 kPa at 300 rpm



JEM00222-00212

- (4) Repeat the step (1) through (3) for each cylinder.
- (5) If the compression of one or more cylinders is low, pour a small amount of engine oil into that cylinder through the spark plug hole and repeat the steps (1) through (3) for the cylinder with low compression.
  - If adding oil helps the compression to improve, chances are that the piston rings and/or cylinder bores are worn or damaged.
  - If the pressure remains low after the operation described in the step (5) has been performed, the valve may be sticking or seated improperly, or there may be leakage past the gasket.

6. Install the spark plug to the cylinder head.

7. Install the fuel pump relay to the relay box.

JEM00223-00000

## CHECKING OF CO/HC CONCENTRATIONS

Preparation to be made prior to check of CO/HC concentrations.

- Apply the parking brake fully.
- Check the ignition timing.
- Check the idle speed.
- Warm up the engine thoroughly. (continue engine warm-up for another 10 minutes after the fan motor has started its operation.)
- All accessory switches are turned OFF.
- The air cleaner element is installed.
- All pipes and vacuum hose are connected.
- Ensure that the intake system exhibits no air leakage.
- Ensure that the exhaust system exhibits no gas leakage.
- On the automatic transmission vehicle, the shift lever is placed in the [N] or [P] range.
- On the manual transmission vehicle, the shift lever is placed in the neutral position.
- Position the steering wheel to straight-ahead direction.
- Prior to the use, be sure to prepare the CO/HC meter, following the instructions of the manufacturer.

### NOTE:

- This check is only for determining whether or not the idle HC/CO emission complies with the specified values.

### Specified Values:

CO: 0.5 % or less

HC: 400 ppm or less

If the CO/HC concentrations will not conform to the specified values, check the A/F control system and/or replace the exhaust manifold.

JEM00224-00000

## CHECKING OF A/F (Air/Fuel) CONTROL SYSTEM

### NOTE:

- Since the A/F adjustment is performed by a computer, you are not able to perform this adjustment. Your check ensures that the computer control is being properly performed. Your check is not for performing the adjustment.
1. Connect the test terminal and the ground terminal with a jumper wire of the diagnosis connector.
  2. While keeping the engine revolution speed at a speed in excess of 1200 rpm (aiming at a speed of around 3000 rpm), measure the voltage between the terminal VF of the diagnosis connector and the body.
  3. Check that the measured value changes between 0 V and 5 V.
  4. If the voltage described in Step 3 above is not obtained, it means that the computer control is not functioning properly. Perform the check of EFI ECU, referring to the EF section.

JEM00225-00000

## SERVICE SPECIFICATIONS

Item		Engine type	K3-VE	K3-VE2
Kind			Gasoline, 4 cycle, EFI	
Number of cylinders			4-cylinder-in-line	
Combustion chamber type			Pent roof type	
Valve mechanism			Chain Driver, DOHC (DWVT)	
Bore x stroke		(mm)	$\phi 72.0 \times 79.7$	
Total displacement		(cc)	1298	
Compression ratio			$10.0 \pm 0.3$	$11.0 \pm 0.3$
Compression pressure			1471 kPa at 330 rpm	1285 kPa at 300 rpm
Maximum output		(kW/rpm)	63.0/6000	74.0/7000
Maximum torque		(N·m/rpm)	120.0/3200	120.0/4400
Number of piston ring	Compression ring		2	
	Oil ring		1	
Valve timing	Intake	Open	BTDC $30^\circ - -12^\circ$	BTDC $52^\circ - 10^\circ$
		Close	ABDC $10^\circ - 52^\circ$	ABDC $28^\circ - 70^\circ$
	Exhaust	Open	BBDC $30^\circ$	BBDC $45^\circ$
		Close	ATDC $2^\circ$	ATDC $2^\circ$
Valve clearance	Intake (Cold)	(mm)	$0.18 \begin{smallmatrix} +0.055 \\ -0.035 \end{smallmatrix}$	
	Exhaust (Cold)	(mm)	$0.31 \begin{smallmatrix} +0.055 \\ -0.035 \end{smallmatrix}$	
Idling speed		(rpm)	700	


JEM00226-00000

Camshaft	Camshaft journal outer dia.	IN	No. 1	33.984 - 34.000 mm	
		EX	No.1	25.979 - 25.995 mm	
		IN, EX	No. 2 - No. 5	22.979 - 22.995 mm	
	Camshaft bearing cap inner dia.	IN	No. 1	34.025 - 34.045 mm	
			No. 2 - No. 5	23.032 - 23.052 mm	
		EX	No. 1	26.032 - 26.052 mm	
			No. 2 - No. 5	23.032 - 23.052 mm	
	Oil clearance	IN	No. 1	0.025 - 0.061 mm	
			No. 2 - No. 5	0.037 - 0.073 mm	
		EX	No. 1 - No. 5	0.037 - 0.073 mm	
	Camshaft thrust clearance (IN, EX)				0.10 - 0.24 mm
	Cam lobe height	K3-VE	IN	40.45 mm	
			EX	39.96 mm	
		K3-VE2	IN	40.75 mm	
EX			40.69 mm		
Camshaft for runout				0.03 mm	
Cylinder head	Warpage	Cylinder block side		0.04 mm	
		Intake manifold side		0.1 mm	
		Exhaust manifold side		0.05 mm	
	Cylinder head height				112.7 mm
	Valve seat angle	IN	45°		
		EX	45°		
	Valve lifter outer dia.				27.975 - 27.985 mm
	Inner dia. of the cylinder head valve lifter bore				28.000 - 28.021 mm
	Valve lifter oil clearance				0.015 - 0.046 mm
	Valve	Valve stem dia.	IN	4.975 - 4.990 mm	
EX			4.965 - 4.980 mm		
Inner dia. of valve guide bush				5.010 - 5.022 mm	
Valve stem oil clearance		IN	0.020 - 0.047 mm		
		EX	0.030 - 0.057 mm		
Valve length		IN	Unleaded	88.15 mm	
			Leaded	88.35 mm	
		EX	89.1 mm		
Valve face angle (IN, EX)				45.5°	
Valve stock thickness		IN	Unleaded	0.8 ± 0.2 mm	
			Leaded	1.0 ± 0.2 mm	
		EX	1.0 ± 0.2 mm		
Valve recession		IN	9.0 mm		
		EX	8.0 mm		
Width of the contact surface of valve seat				1.4 ± 0.2 mm	
Valve stem oil seal installed position		IN	15.8 mm		
	EX	15.8 mm			
Valve spring	Free length	K3-VE	45.55 mm		
		K3-VE2	47.90 mm		
	Valve spring for squareness	K3-VE	1.59 mm or less		
		K3-VE2	1.67 mm or less		

Valve spring	Minimum tension/installation height		K3-VE	147 ± 8.0 N/37.70 mm
			K3-VE2	140.1 ± 7.0 N/37.70 mm
Cylinder block	Surface contacting the cylinder head gasket for warpage			0.05 mm
	Cylinder block height			235.9 - 236.1 mm
	Cylinder bore dia.			72.000 - 72.012 mm
	Piston outer dia.	K3-VE	71.958 - 71.970 mm	
		K3-VE2	71.953 - 71.965 mm	
	Piston-to-cylinder bore oil clearance	K3-VE	0.030 - 0.054 mm	
		K3-VE2	0.035 - 0.059 mm	
	Crankshaft thrust clearance			0.02 - 0.22 mm
	Connecting rod thrust clearance			0.10 - 0.30 mm
	Width of big end of connecting rod in thrust direction			17.79 - 17.84 mm
Side width of crankpin journal			17.94 - 18.09 mm	
Connecting rod	Connecting rod big end bore dia.			43.000 - 43.008 mm
	Crankpin dia.			39.992 - 40.000 mm
	Oil clearance between the crankpin journal and the connecting rod cap			0.016 - 0.040 mm
	Connecting rod for bend			0.05 mm
	Connecting rod for twist			0.05 mm
Crankshaft	Crankshaft main journal dia.			45.988 - 46.000 mm
	Cylinder block main journal dia.			50.000 - 50.018 mm
	Oil clearance between the crankshaft main journal and crankshaft bearing cap			0.016 - 0.036 mm
	Crankshaft for runout			0.07 mm
Piston	Piston pin outer dia.			17.999 - 18.002 mm
	Piston pin hole of piston dia.			18.007 - 18.010 mm
	Piston-to-piston pin oil clearance			0.005 - 0.011 mm
	Connecting rod small end bore dia.			17.965 - 17.989 mm
	Connecting rod-to-piston pin interference fit			0.014 - 0.037 mm
	Piston ring groove side clearance	No. 1	Unleaded	0.035 - 0.080 mm
			Leaded	0.030 - 0.080 mm
		No. 2	Unleaded	0.020 - 0.060 mm
			Leaded	0.020 - 0.060 mm
		Oil ring	Unleaded	0.030 - 0.110 mm
			Leaded	0.070 - 0.150 mm
	Piston ring end gap	No. 1		0.20 - 0.30 mm
		No. 2	Unleaded	0.40 - 0.55 mm
			Leaded	0.35 - 0.50 mm
Oil ring		Unleaded	0.15 - 0.50 mm	
		Leaded	0.20 - 0.50 mm	
Flywheel	Flywheel for runout			0.1 mm

# EM-62

## SSTs

Shape	Part number	Part name	Remarks
	09210-87701-000	Fly wheel holder	
	09278-87201-000	Timing belt pulley holding tool	
	09202-87002-000	Valve cotter remover & replacer	
	09202-87002-0A0	Valve cotter attachment	
	09032-00100-000	Oil pan seal cutter	
	09221-87207-000	Piston pin body remover & replacer	
	09221-97401-000	Piston pin guide remover & replacer	
	09608-87302-000	Axle hub & drive pinion bearing tool set	
	09217-87001-000	Piston replacing guide	

JEM00228-00214

## TIGHTENING TORQUE

Components	N·m	kgf·m	Remarks
Cylinder head × Ignition coil	6.0 - 9.0	0.6 - 0.9	
Cylinder head × Spark plug	14.4 - 21.6	1.5 - 2.2	
Cylinder head × Cylinder head cover	7.2 - 10.8	0.7 - 1.1	Cap nut
	8.8 - 13.2	0.9 - 1.3	Nut
Cylinder head × Fuel delivery pipe	16.8 - 25.2	1.7 - 2.6	
Cylinder head × Intake manifold	15.2 - 22.8	1.6 - 2.3	
Cylinder head × Exhaust manifold	21 - 29	2.1 - 2.9	
Cylinder head × Water inlet	7.2 - 10.8	0.7 - 1.1	
Cylinder head × Cam angle sensor	5.3 - 9.8	0.5 - 1.0	
Cylinder head × Engine coolant temperature	16 - 24	1.6 - 2.4	
Cylinder block × Oil filter bracket	6.0 - 11.0	0.6 - 1.1	
Cylinder block × Chain arm	15.2 - 22.8	1.6 - 2.3	
Cylinder block × Chain guide	5.3 - 9.8	0.5 - 1.0	
Cylinder block × Chain guide No. 2	5.3 - 9.8	0.5 - 1.0	
Cylinder block × Water pump	7.2 - 11.7	0.7 - 1.2	
Cylinder block × Chain oil nozzle	5.3 - 9.7	0.5 - 1.0	
Cylinder block × Oil pressure switch	10.5 - 19.5	1.1 - 2.0	
Cylinder block × DVVT oil filter	17.1 - 31.9	1.7 - 3.3	
Cylinder block × Chain cover	14.4 - 21.6	1.5 - 2.2	M8 × 1.25
	7.2 - 10.8	0.7 - 1.1	M6 × 1.0
Cylinder block × Cylinder head	32.0 - 34.0	3.2 - 3.4	Tighten further by turning $90^\circ \pm 10^\circ$
Cylinder block × Rear oil seal retainer	6.8 - 10.2	0.7 - 1.0	
Cylinder block × Rear end plate	5.3 - 9.7	0.5 - 1.0	
Cylinder block × Oil pan	6.0 - 11.0	0.6 - 1.1	M6 × 1.0
	29.4 - 54.6	3.0 - 5.6	M10 × 1.25
Cylinder block × Oil pump	7.2 - 10.8	0.7 - 1.1	
Cylinder block × Knock sensor	35.2 - 52.8	3.6 - 5.4	Except European specifications
Cylinder head × Tensioner	7.2 - 10.8	0.7 - 1.1	
Cylinder head × Ignitor bracket	5.3 - 9.8	0.5 - 1.0	
Cylinder head × Throttle body	5.3 - 9.8	0.5 - 1.0	
Chain cover × Idler pulley	35.2 - 52.8	3.6 - 5.3	
Chain cover × Crank angle sensor	5.3 - 9.8	0.5 - 1.0	
Chain cover × Oil control valve	5.3 - 9.8	0.5 - 1.0	
Throttle body × Throttle body bracket	10.8 - 25.2	1.1 - 2.6	
Oil level gauge bracket × Intake manifold	6.0 - 11.1	0.6 - 1.1	
Water inlet × Radiator thermo control switch	30 - 40	3.1 - 4.1	
Cylinder block × Oil strainer	6.0 - 11.0	0.6 - 1.1	M101 series
Oil pan × Oil strainer	6.0 - 11.0	0.6 - 1.1	J102 series
Oil pan drain plug	23.6 - 35.4	2.4 - 3.6	
Camshaft cap No.1, No. 2	10.5 - 14.5	1.1 - 1.5	
Water pump pulley × Water pump	8.1 - 15.0	0.8 - 1.5	
DVVT controller × Intake camshaft	40 - 54	4.1 - 5.5	
Exhaust manifold × Oxygen sensor	29.0 - 39.0	2.9 - 3.9	

# EM-64

Components	N·m	kgf·m	Remarks
Exhaust manifold x Exhaust manifold cover	5.3 - 9.8	0.5 - 1.0	
Connecting rod cap nut bolt	19.5 - 24.5	2.0 - 2.5	Tighten further by turning $90^\circ \pm 10^\circ$
Crankshaft bearing cap bolt	53 - 65	5.4 - 6.6	
Crankshaft pulley set bolt	120 - 140	12.2 - 14.3	
Crankshaft x Flywheel	32	3.3	Temporarily tightening
	73.3 - 82.7	7.5 - 8.4	

JEM00229-00000