

**Engine  
Workshop  
Manual  
B6-DOHC  
BP-DOHC**

**7/94** 1425-10-94G

**MAZDA**



## **WARNING**

Servicing a vehicle can be dangerous. If you have not received service-related training, the risks of injury and property damage increase. The recommended servicing procedures for the vehicle in this workshop manual were developed with Mazda-trained technicians in mind. This manual may be useful to non-Mazda trained technicians, but a technician with our service-related training and experience will be at less risk when performing servicing operations. However, all users of this manual are expected to know general safety procedures.

This manual contains "Warnings" and "Cautions" applicable to risks not normally encountered in a general technician's experience. They should be followed to reduce the risk of injury and the risk that improper service or repair may damage the vehicle or render it unsafe. It is also important to understand that the "Warnings" and "Cautions" are not exhaustive. It is impossible to warn of all the hazardous consequences that might result from failure to follow the procedures.

The procedures recommended and described in this manual are effective methods of performing service and repair. Some require tools specifically designed for a specific purpose. Nonrecommended procedures and tools should include consideration for safety of the technician and continued safe operation of the vehicle.

Parts should be replaced with genuine Mazda replacement parts, not parts of lesser quality. Use of a nonrecommended replacement part should include consideration for safety of the technician and continued safe operation of the vehicle.



# Mazda Engine Workshop Manual B6-DOHC BP-DOHC

## CONTENTS

Title	Section
General Information	GI
Engine Overhaul	B
Lubrication System	D

### FOREWORD

This manual explains the disassembly, inspection, repair, and reassembly procedures for the above-indicated engine. In order to do these procedures safely, quickly, and correctly, you must first read this manual and any other relevant service materials carefully.

The information in this manual is current up to June, 1994. Any changes that occur after that time will not be reflected in this particular manual. Therefore, the contents of this manual may not exactly match the mechanism that you are currently servicing.

**Mazda Motor Corporation  
HIROSHIMA, JAPAN**



# GENERAL INFORMATION

<b>SAFETY INFORMATION</b> .....	GI-2
LUBRICANTS .....	GI-2
<b>HOW TO USE THIS MANUAL</b> .....	GI-2
ADVISORY MESSAGES .....	GI-2
PREPARATION .....	GI-2
REPAIR PROCEDURE .....	GI-2
SYMBOLS .....	GI-3
<b>FUNDAMENTAL PROCEDURES</b> .....	GI-4
DISASSEMBLY .....	GI-4
REASSEMBLY .....	GI-4
ADJUSTMENTS .....	GI-5
RUBBER PARTS AND TUBING .....	GI-5
HOSE CLAMPS .....	GI-5
<b>UNITS</b> .....	GI-6
<b>ABBREVIATIONS</b> .....	GI-7
<b>SAE STANDARDS</b> .....	GI-8

## SAFETY INFORMATION

### LUBRICANTS

Avoid prolonged and repeated contact with petroleum-based oils. Used oil may irritate the skin, and can cause skin cancer and other skin disorders.

Wash thoroughly after working with oil. We recommend water soluble hand cleaners. Do not use kerosene, gasoline, or any other solvent, to remove oil from your skin.

If repeated or prolonged contact with oil is necessary, wear protective clothing. Soiled clothing, particularly those soiled with used oils and greases containing lead, should be cleaned at regular intervals.

## HOW TO USE THIS MANUAL

### ADVISORY MESSAGES

You'll find several **Warnings**, **Cautions**, and **Notes** in this manual.

#### Warning

- A **Warning** indicates a situation in which serious injury or death could result if the warning is ignored.

#### Caution

- A **Caution** indicates a situation in which damage to the vehicle could result if the caution is ignored.

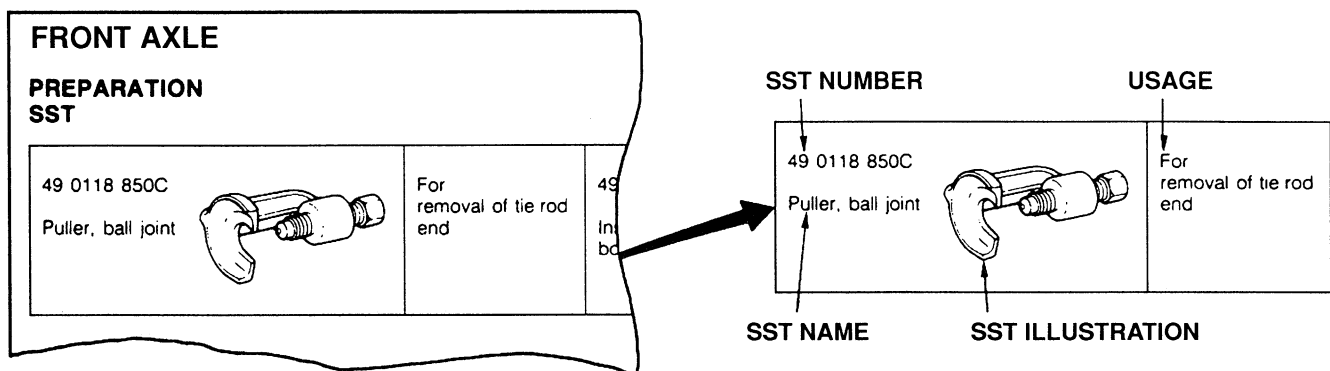
#### Note

- A **Note** provides added information that will help you to complete a particular procedure.

### PREPARATION

This points out the needed **SSTs** for the service operation. It is best to gather all necessary **SSTs** before beginning work.

#### Example:



### REPAIR PROCEDURE

1. Most repair operations begin with an overview illustration. It identifies the components, shows how the parts fit together, and describes visual part inspection. If a damaged or worn part is found, repair or replace it as necessary.
2. Expendable parts, tightening torques, and symbols for oil, grease, and sealant are shown in the overview illustration.
3. Pages related to service procedures are shown under the illustration. Refer to this information when servicing the related part.



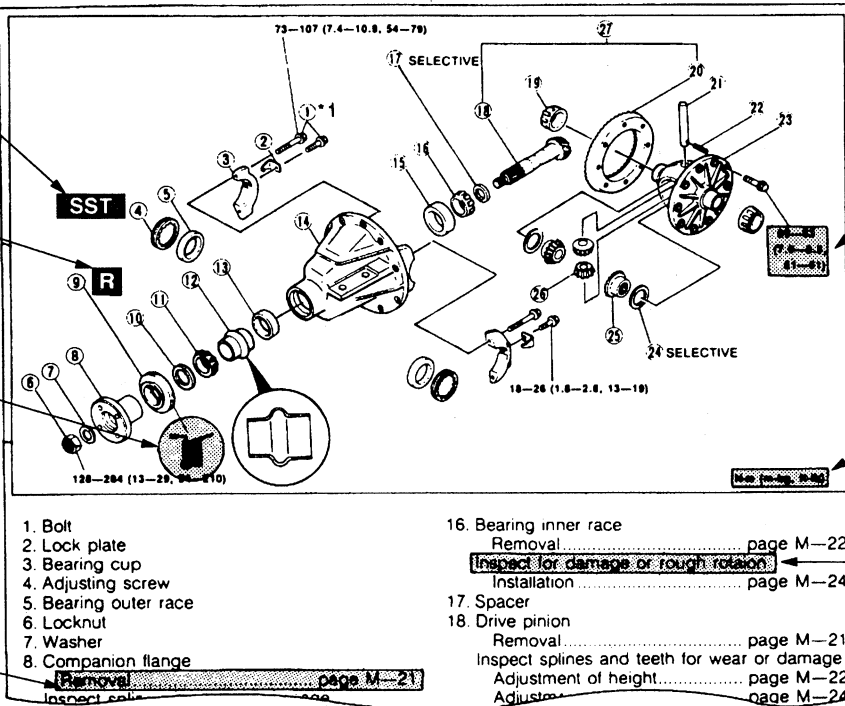
## Example:

SHOWS SPECIAL SERVICE TOOL (SST) FOR SERVICE OPERATION

SHOWS EXPENDABLE PARTS

SHOWS APPLICATION POINT OF OIL, ETC.

SHOWS RELATED PAGE FOR SERVICE



SHOWS TIGHTENING TORQUE SPECIFICATIONS

SHOWS TIGHTENING TORQUE UNITS

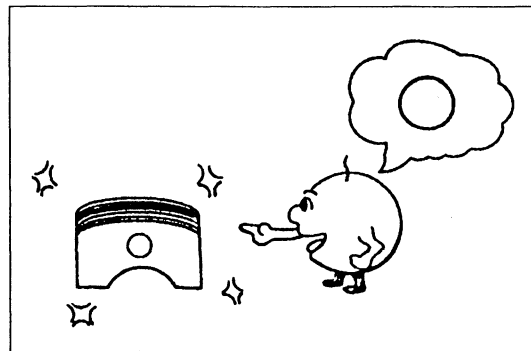
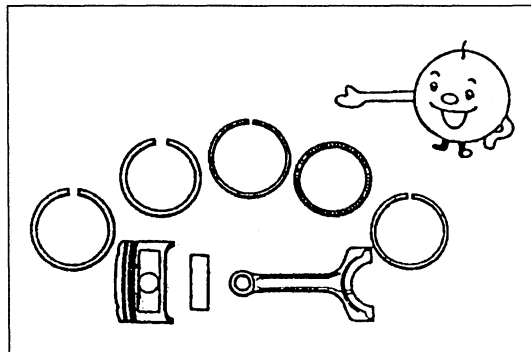
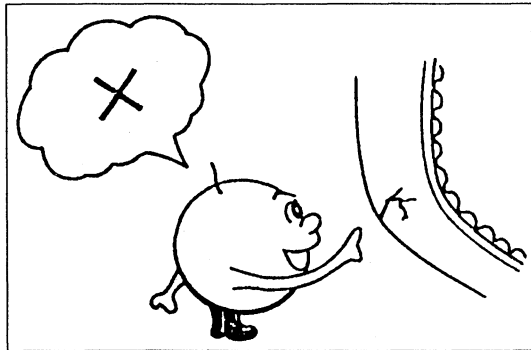
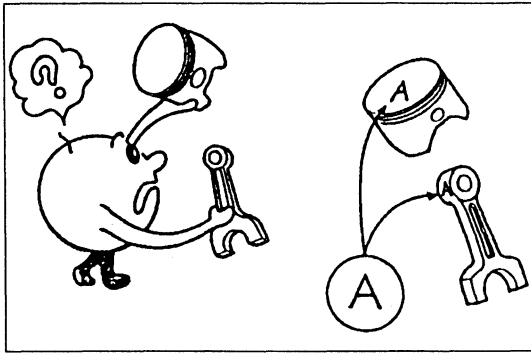
SHOWS VISUAL INSPECTION INFORMATION

\*1: The numbers (①, etc.) refer to part identification and servicing procedures.

## SYMBOLS

There are seven symbols indicating oil, grease, and sealant. These symbols show the points of applying such materials during service.

Symbol	Meaning	Kind
	Apply oil (except ATF and brake fluid)	New engine oil as appropriate
	Apply grease	Appropriate grease
	Apply sealant	Appropriate sealant
	Apply petroleum jelly	Appropriate petroleum jelly
	Replace part	O-ring, gasket, etc.



## FUNDAMENTAL PROCEDURES

### DISASSEMBLY

If the disassembly procedure is complex, requiring many parts to be disassembled, all parts should be identified in a way that will not affect their performance or appearance for easy reassembly.

#### 1. Inspection of parts

When removed, each part should be carefully inspected for malfunctioning, deformation, damage, and other problems.

#### 2. Arrangement of parts

All disassembled parts should be carefully arranged for reassembly. Be sure to separate or otherwise identify the parts to be replaced from those that will be reused.

#### 3. Cleaning parts for reuse

All parts to be reused should be carefully and thoroughly cleaned in the appropriate method.

#### Warning

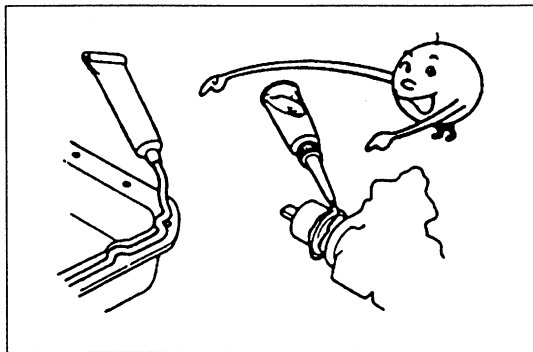
- Using compressed air can cause dirt and other particles to fly out, causing injury to the eyes. Wear protective eye wear whenever using compressed air.

### REASSEMBLY

Standard values, such as tightening torques and adjustment values must be strictly observed in the reassembly of all parts.

If removed, these parts should be replaced with new ones:

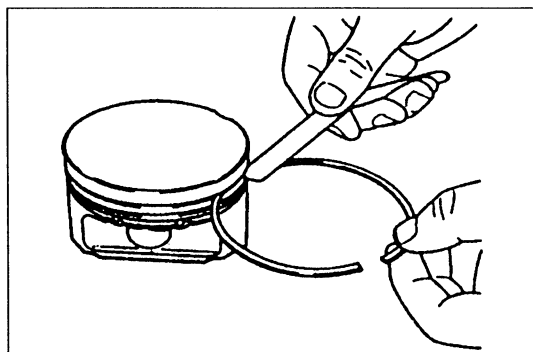
- |                |                 |
|----------------|-----------------|
| 1. Oil seals   | 2. Gaskets      |
| 3. O-rings     | 4. Lock washers |
| 5. Cotter pins | 6. Nylon nuts   |



Depending on location:

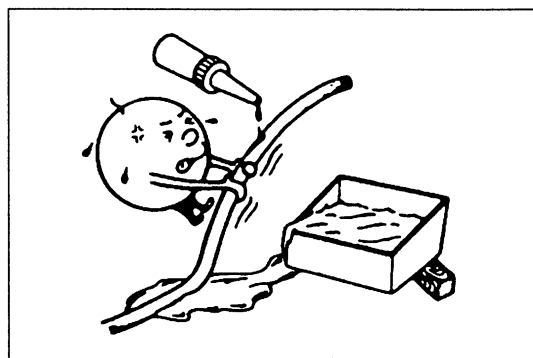
1. Sealant gasket, or both should be applied to the specified location. When sealant is applied, parts should be installed before sealant hardens. Hardened sealant causes leaks.
2. Oil should be applied to the sliding surfaces of moving parts.
3. Specified oil or grease should be applied at the prescribed locations (such as oil seals) before reassembly.

GI



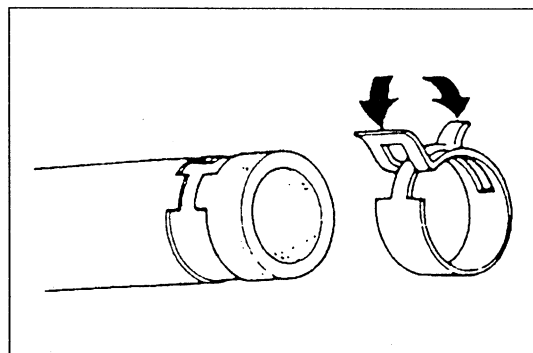
**ADJUSTMENTS**

Use gauges and/or tester when making adjustments.



**RUBBER PARTS AND TUBING**

Prevent gasoline or oil from getting on rubber parts or tubing.



**HOSE CLAMPS**

When reinstalling, position the hose clamp in the original location on the hose, and squeeze the clamp lightly with large pliers to ensure a good fit.

## UNITS

Electrical current	A (ampere)
Electric potential	V (volt)
Electric power	W (watt)
Length	mm (millimeter) in (inch)
Negative pressure	kPa (kilo Pascal) mmHg (millimeters of mercury) inHg (inches of mercury)
Positive pressure	kPa (kilo Pascal) kgf/cm <sup>2</sup> (kilogram force per square centimeter) psi (pounds per square inch)
Resistance	Ω (ohm)
Torque	N·m (Newton meter) kgf·m (kilogram force per meter) kgf·cm (kilogram force per centimeter) ft·lbf (foot pound) in·lbf (inch pound)
Volume	L (liter) US qt (U.S. quart) Imp qt (Imperial quart) ml (milliliter) cc (cubic centimeter) cu in (cubic inch) fl oz (fluid ounce)
Weight	g (gram) oz (ounce)

**Conversion to SI Units (Système International d'Unités)**

All numerical values in this manual are based on SI units. Numbers shown in conventional units are converted from these values.

**Rounding off**

Converted values are rounded off to the same number of places as the SI unit value. For example, if the SI unit value is 17.2 and the value after conversion is 37.84, the converted value will be rounded off to 37.8.

**Upper and lower limits**

When the data indicates upper and lower limits, the converted values are rounded down if the SI unit value is an upper limit and rounded up if the SI unit value is a lower limit. Therefore, converted values for the same SI unit value may differ after conversion. For example, consider 2.7 kgf/cm<sup>2</sup> in the following specifications:

- 210—260 kPa { 2.1—2.7 kgf/cm<sup>2</sup> , 30—38 psi }
- 270—310 kPa { 2.7—3.2 kgf/cm<sup>2</sup> , 39—45 psi }

The actual converted values for 2.7 kgf/cm<sup>2</sup> are 264 kPa and 38.4 psi. In the top specification, 2.7 is used as an upper limit, so its converted values are rounded down to 260 and 38. In the bottom specification, 2.7 is used as a lower limit, so its converted values are rounded up to 270 and 39.

## ABBREVIATIONS

ATX .....	Automatic transaxle
BDC .....	Bottom dead center
EX .....	Exhaust
HLA .....	Hydraulic lash adjuster
IN .....	Intake
LH .....	Left hand
MAX .....	Maximum
MBSP .....	Main bearing support plate
MIN .....	Minimum
MTX .....	Manual transaxle
O.S .....	Over size
P/S .....	Power steering
RH .....	Right hand
SST .....	Special service tool
STD .....	Standard
TDC .....	Top dead center
U.S .....	Under size
VRAS .....	Vibration reducing aluminum stiffener

## SAE STANDARDS

In accordance with new regulations, SAE (Society of Automotive Engineers) standard names and abbreviations are now used in this manual. The table below lists the names and abbreviations that have been used in Mazda manuals up to now and their SAE equivalents.

Previous Standard		SAE Standard		
Abbreviation	Name	Abbreviation	Name	Remark
—	Accelerator Pedal	AP	Accelerator Pedal	
—	Air Cleaner	ACL	Air Cleaner	
—	Air Conditioning	A/C	Air Conditioning	
—	Airflow Meter	VAF	Volume Air Flow Sensor	
—	Airflow Sensor	MAF	Mass Air Flow Sensor	
—	Alternator	GEN	Generator	
—	ATF Thermosensor	—	Transmission (Transaxle) Fluid Temperature Sensor	
—	Atmospheric Pressure	BARO	Barometric Pressure	
Vb	Battery Voltage	B+	Battery Positive Voltage	
—	Catalytic Converter	OC	Oxidation Catalytic Converter	
		TWC	Three Way Catalytic Converter	
		WU-TWC	Warm Up Three Way Catalytic Converter	#1
—	Circuit Opening Relay	FPR	Fuel Pump Relay	#2
—	Clutch Position	CPP	Clutch Pedal Position	
—	Crank Angle Sensor	CMP	Camshaft Position Sensor	
—	Crank Angle Sensor 2	CKP	Crankshaft Position Sensor	
—	Diagnosis Connector	DLC	Data Link Connector	
—	Diagnosis/Self-Diagnosis	OBD	On-Board Diagnostic	
—	Direct Ignition	DLI	Distributorless Ignition	
—	EC-AT Control Unit	TCM	Transmission (Transaxle) Control Module	
EGL	Electronic Gasoline Injection System	CIS	Continuous Fuel Injection System	
—	Electronic Spark Ignition	EI	Electronic Ignition	#3
ECU	Engine Control Unit	PCM	Powertrain Control Module	#4
		ECM	Engine Control Module	
—	Engine Modification	EM	Engine Modification	
—	Engine RPM Signal	—	Engine Speed Input Signal	
—	Engine Speed	RPM	Engine Speed	
—	Evaporative Emission	EVAP	Evaporative Emission	
—	Exhaust Gas Recirculation	EGR	Exhaust Gas Recirculation	
—	Fan Control	FC	Fan Control	
—	Feedback System	CLS	Closed Loop System	
—	Flexible Fuel	FF	Flexible Fuel	
—	Fuel Pump	FP	Fuel Pump	
—	Fully Closed	CTP	Closed Throttle Position	
—	Fully Open	WOT	Wide Open Throttle	
—	Ground/Earth	GND	Ground	

#1: Directly connected to exhaust manifold

#2: In some models, there is a fuel pump relay that controls pump speed. That relay is now called the fuel pump relay (speed).

#3: Controlled by the ECM (PCM)

#4: Device that controls engine and powertrain

Previous Standard		SAE Standard		
Abbreviation	Name	Abbreviation	Name	Remark
—	IC Regulator	VR	Voltage Regulator	
—	Idle Speed Control	IAC	Idle Air Control	
—	Idle Switch	—	Closed Throttle Position Switch	
—	Igniter	ICM	Ignition Control Module	
—	Inhibitor Position	TR	Transmission (Transaxle) Range	
—	Intake Air Pressure	MAP	Manifold Absolute Pressure	
—	Intake Air Thermo	IAT	Intake Air Temperature	
—	Intercooler	CAC	Charge Air Cooler	
—	Knock Sensor	KS	Knock Sensor	
—	Line Pressure Solenoid Valve	—	Pressure Control Solenoid	
—	Lock-up Position	TCC	Torque Converter Clutch	
—	Malfunction Indicator Light	MIL	Malfunction Indicator Lamp	
—	Multiport Fuel Injection	MFI	Multiport Fuel Injection	
—	Open Loop	OL	Open Loop	
—	Overdrive	4GR	Fourth Gear	
—	Oxygen Sensor	HO2S	Heated Oxygen Sensor	With heater
		O2S	Oxygen Sensor	
—	Park/Neutral Range	PNP	Park/Neutral Position	
—	Power Steering Pressure	PSP	Power Steering Pressure	
—	Pulse Generator	—	Input/Turbine Speed Sensor	
—	Reed Valve	SAPV	Secondary Air Pulse Valve	
—	Secondary Air Injection System	PAIR	Pulsed Secondary Air Injection	Pulsed injection
		AIR	Secondary Air Injection	Inject with compressor
—	Sequential Fuel Injection	SFI	Sequential Multipoint Fuel Injection	
—	Service Code(s)	DTC	Diagnostic Trouble Code(s)	
—	Spark Ignition	DI	Distributor Ignition	
—	Stoplight Switch	—	Brake Switch	
—	Test Mode	DTM	Diagnostic Test Mode	#5
—	Throttle Body	TB	Throttle Body	
—	Throttle Sensor	TP	Throttle Position Sensor	
—	Turbocharger	TC	Turbocharger	
—	Vehicle Speed Sensor	VSS	Vehicle Speed Sensor	
—	Vehicle Speed Sensor 1	—	Output Speed Sensor	
—	Water Thermo	ECT	Engine Coolant Temperature	
—	1-2 Shift Solenoid Valve	—	Shift Solenoid A	
—	2-3 Shift Solenoid Valve	—	Shift Solenoid B	
—	3-4 Shift Solenoid Valve	—	Shift Solenoid C	
—	3rd Gear	3GR	Third Gear	
—	—	—	Incorrect Gear Ratio	

#5: Diagnostic trouble codes depend on the diagnostic test mode



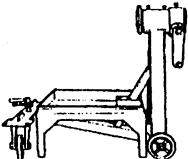

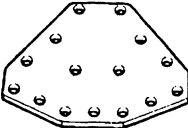



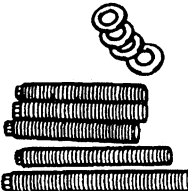



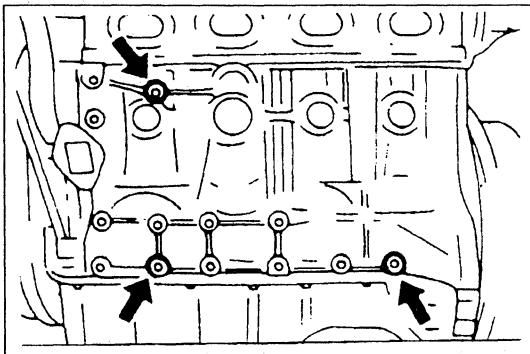
# ENGINE OVERHAUL

<b>ENGINE STAND MOUNTING/DISMOUNTING</b> .....	B- 2
PREPARATION .....	B- 2
MOUNTING .....	B- 2
DISMOUNTING .....	B- 3
<b>DISASSEMBLY / ASSEMBLY</b> .....	B- 4
PREPARATION .....	B- 4
TIMING BELT .....	B- 6
CYLINDER HEAD (I) .....	B-11
CYLINDER HEAD (II) .....	B-14
CYLINDER BLOCK (EXTERNAL PARTS) .....	B-17
CYLINDER BLOCK (INTERNAL PARTS) .....	B-22
<b>INSPECTION / REPAIR</b> .....	B-25
PREPARATION .....	B-25
CYLINDER HEAD .....	B-26
VALVE, VALVE GUIDE .....	B-26
VALVE SEAT .....	B-28
VALVE SPRING .....	B-29
CAMSHAFT .....	B-29
HLA .....	B-31
CYLINDER BLOCK .....	B-31
OIL JET .....	B-32
PISTON, PISTON RING, AND PISTON PIN .....	B-32
CONNECTING ROD .....	B-33
CRANKSHAFT .....	B-35
TENSIONER SPRING .....	B-36

### ENGINE STAND MOUNTING/DISMOUNTING

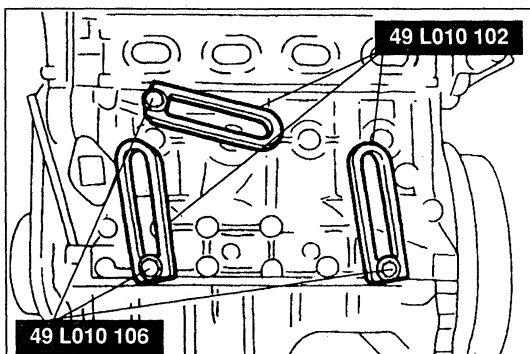
#### PREPARATION SST

<p>49 0107 680A Engine stand</p> 	<p>For disassembly and assembly of engine</p>	<p>49 L010 1A0 Hanger set, engine stand</p> 	<p>For disassembly and assembly of engine</p>
<p>49 L010 101 Plate (Part of 49 L010 1A0)</p> 	<p>For disassembly and assembly of engine</p>	<p>49 L010 102 Arms (Part of 49 L010 1A0)</p> 	<p>For disassembly and assembly of engine</p>
<p>49 L010 103 Hooks (Part of 49 L010 1A0)</p> 	<p>For disassembly and assembly of engine</p>	<p>49 L010 104 Nuts (Part of 49 L010 1A0)</p> 	<p>For disassembly and assembly of engine</p>
<p>49 L010 105 Bolts (Part of 49 L010 1A0)</p> 	<p>For disassembly and assembly of engine</p>	<p>49 L010 106 Bolts (Part of 49 L010 1A0)</p> 	<p>For disassembly and assembly of engine</p>

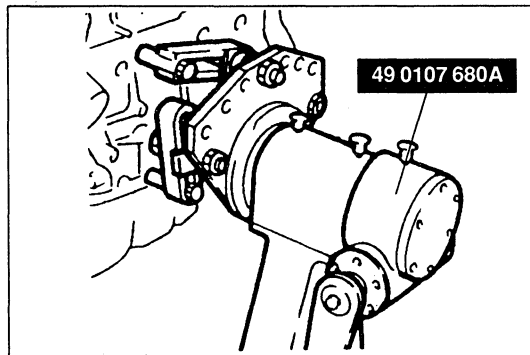
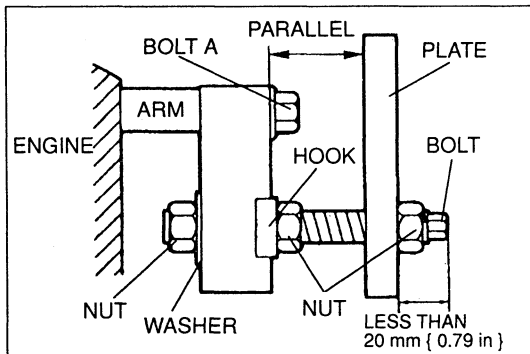
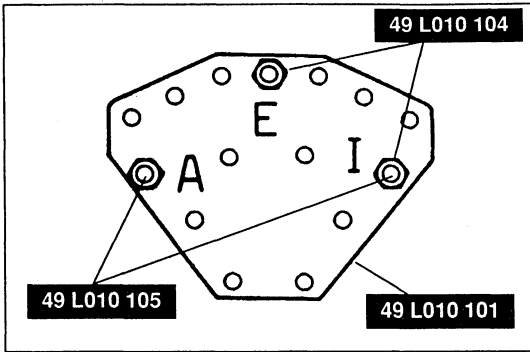


#### MOUNTING

1. Use the holes shown in the figure.



2. Install the **SST** (arms) to the holes as shown in the figure, and hand tighten the **SST** (bolts).



3. Assemble the **SST** (bolts, nuts, and plate) in the specified positions marked A, E, and I.

**B**

4. Install the **SST** assembled in step 3 to the respective arms.
5. Adjust the **SST** (bolts) so that less than **20 mm { 0.79 in }** of thread is exposed.
6. Make the **SST** (plate and arms) parallel by adjusting the **SST** (bolts and nuts).
7. Tighten the **SST** (bolts and nuts) to affix the **SST** firmly.

8. Mount the engine on the **SST** (engine stand).

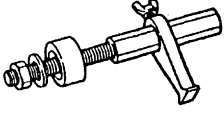
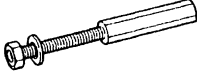


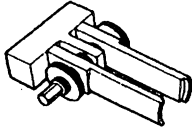
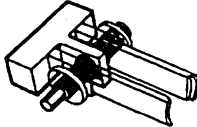
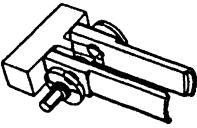
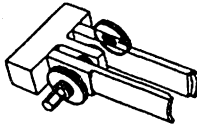

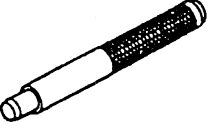
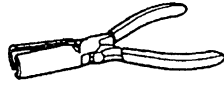
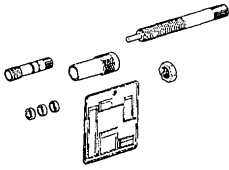

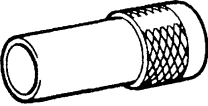

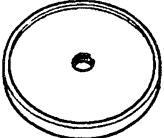
**DISMOUNTING**


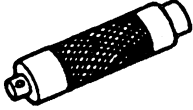
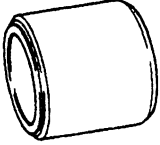
Dismount in the reverse order of mounting.

### DISASSEMBLY / ASSEMBLY

#### PREPARATION

#### SST

<p>49 E011 1A0</p> <p>Brake set, ring gear</p> 	<p>For prevention of crankshaft rotation</p>	<p>49 E011 103</p> <p>Shaft (Part of 49 E011 1A0)</p> 	<p>For prevention of crankshaft rotation</p>
<p>49 E011 104</p> <p>Collar (Part of 49 E011 1A0)</p> 	<p>For prevention of crankshaft rotation</p>	<p>49 E011 105</p> <p>Stopper (Part of 49 E011 1A0)</p> 	<p>For prevention of crankshaft rotation</p>
<p>49 B012 0A2</p> <p>Pivot</p> 	<p>For removal / installation of valves</p>	<p>49 B012 012</p> <p>Body (Part of 49 B012 0A2)</p> 	<p>For removal / installation of valves</p>
<p>49 B012 013</p> <p>Foot (Part of 49 B012 0A2)</p> 	<p>For removal / installation of valves</p>	<p>49 B012 014</p> <p>Locknut (Part of 49 B012 0A2)</p> 	<p>For removal / installation of valves</p>
<p>49 0636 100B</p> <p>Lifter arm, valve spring</p> 	<p>For removal / installation of valves</p>	<p>49 0221 061A</p> <p>Installer, piston pin</p> 	<p>For installation of piston pins</p>
<p>49 S120 170</p> <p>Remover, valve seal</p> 	<p>For removal of valve seals</p>	<p>49 L012 0A0</p> <p>Installer set, valve seal &amp; valve guide</p> 	<p>For installation of valve seals</p>
<p>49 L012 001</p> <p>Installer (Part of 49 L012 0A0)</p> 	<p>For installation of valve seals</p>	<p>49 L012 002</p> <p>Body (Part of 49 L012 0A0)</p> 	<p>For installation of valve seals</p>
<p>49 L012 005</p> <p>Spacer (Part of 49 L012 0A0)</p> 	<p>For installation of valve seals</p>	<p>49 W033 105</p> <p>Installer, oil seal</p> 	<p>For installation of rear oil seal</p>

<p>49 G030 795 Installer, oil seal</p> 	<p>For installation of rear oil seal</p>	<p>49 G030 797 Handle (Part of 49 G030 795)</p> 	<p>For installation of rear oil seal</p>
<p>49 B014 001 Installer, oil seal</p> 	<p>For installation of front oil seal</p>	<p>—</p>	<p>—</p>

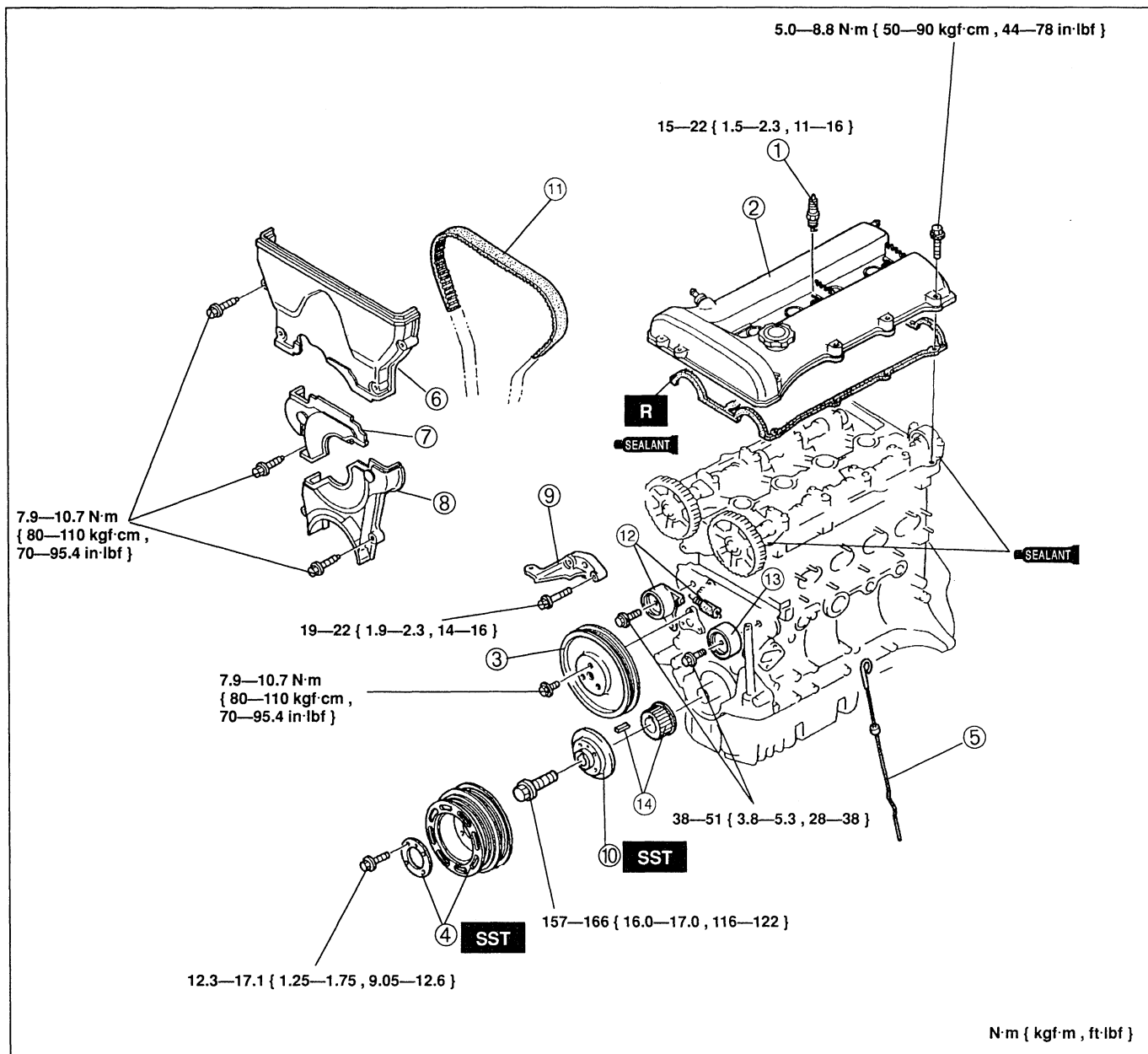
**B**

### Warning

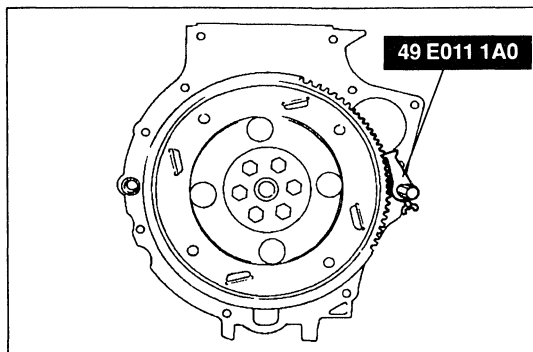
- Continuous exposure with USED engine oil has caused skin cancer in laboratory mice. Protect your skin by washing with soap and water immediately after this work.

### TIMING BELT

1. Disassemble in the order shown in the figure, referring to **Disassembly Note**.
2. Assemble in the reverse order of disassembly, referring to **Assembly Note**.



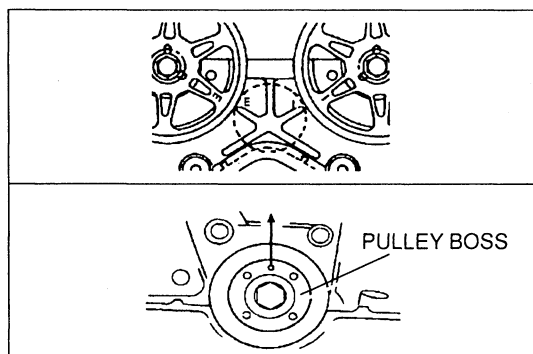
1. Spark plug	
2. Cylinder head cover	
Assembly Note	page B-10
3. Water pump pulley	
4. Crankshaft pulley and plate	
Disassembly Note	page B- 7
Assembly Note	page B- 9
5. Dipstick	
6. Timing belt cover, upper	
7. Timing belt cover, middle	
8. Timing belt cover, lower	
9. No.3 engine mount bracket	
10. Pulley boss	
Disassembly Note	page B- 7
Assembly Note	page B- 8
11. Timing belt	
Disassembly Note	page B- 7
Assembly Note	page B- 8
12. Tensioner and tensioner spring	
Assembly Note	page B- 8
13. Idler	
14. Timing belt pulley and key	
Assembly Note	page B- 8



### Disassembly Note Crankshaft pulley and plate

1. Hold the flywheel (MTX) or drive plate (ATX) by using the **SST**.
2. Remove the crankshaft pulley and plate.

B

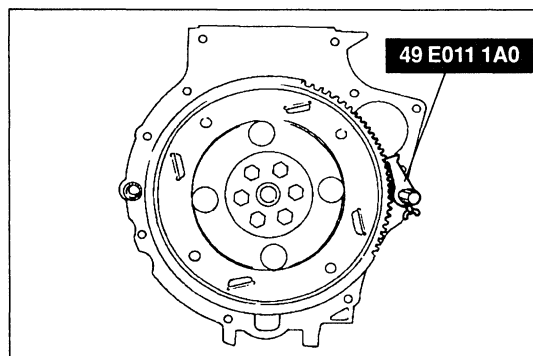


### Pulley boss

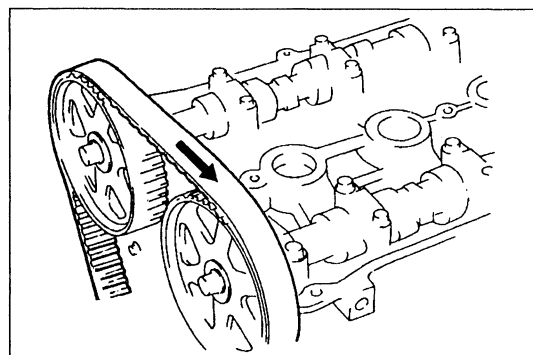
1. Turn the crankshaft clockwise and align the timing marks of the pulleys.

#### Note

- For the crankshaft side, face the locating pin on the pulley boss straight up.



2. Hold the flywheel (MTX) or drive plate (ATX) by using the **SST**.
3. Remove the pulley boss.

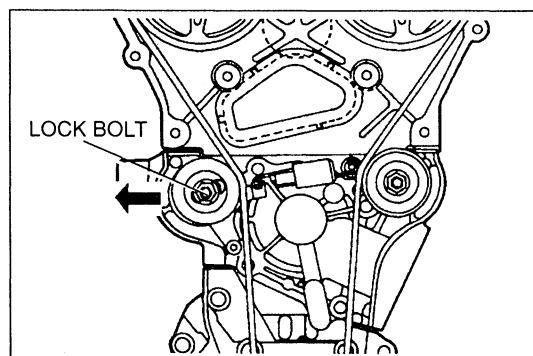


### Timing belt

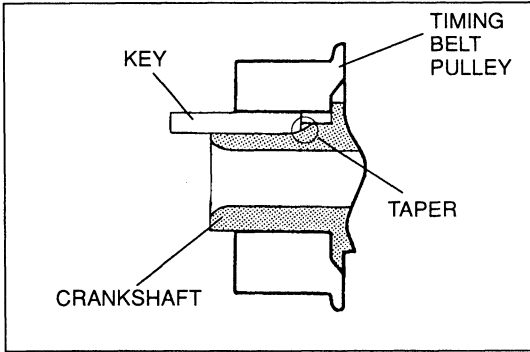
#### Caution

- The following will damage the belt and shorten its life; Forcefully twisting it, turning it inside out, or allowing oil or grease on it.

1. Mark the timing belt rotation on the belt for proper reinstallation.



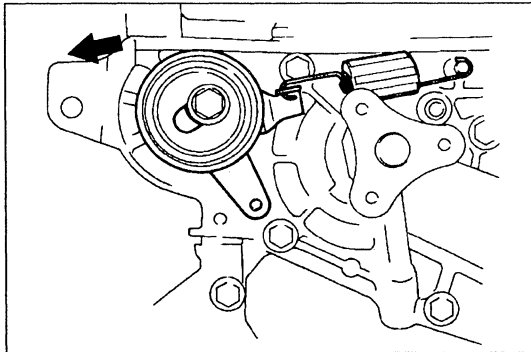
2. Loosen the tensioner lock bolt.
3. Push the tensioner in the direction of the arrow and hand tighten the lock bolt.
4. Remove the timing belt.



### Assembly Note

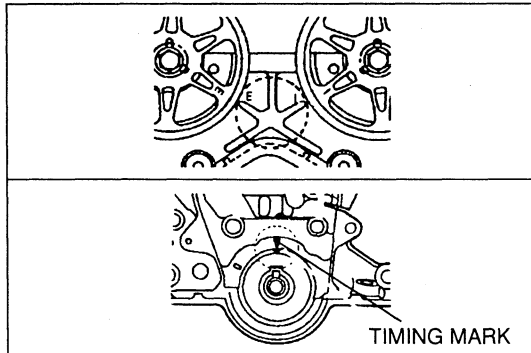
#### Timing belt pulley and key

Insert the key into the timing belt pulley, facing the tapered side downward. Push the key until it stops.



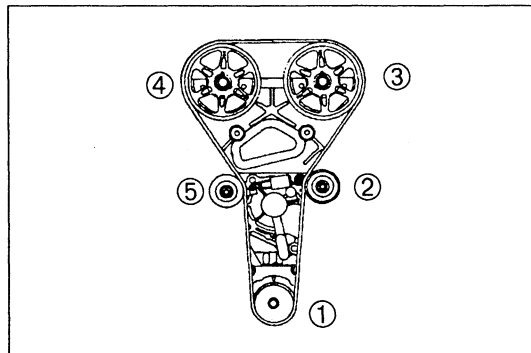
### Tensioner and tensioner spring

1. Install the tensioner spring as shown.
2. Push the tensioner in the direction of the arrow and hand tighten the lock bolt.



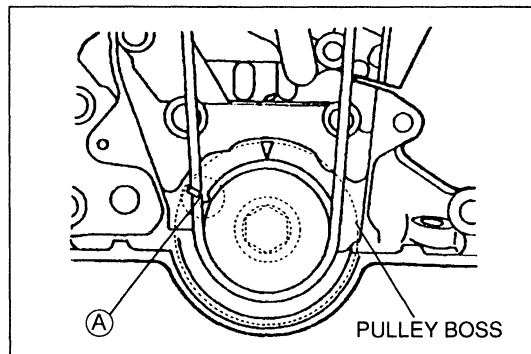
### Timing belt

1. Verify that all timing marks are correctly aligned.



2. Install the timing belt on the pulleys in the order shown below.

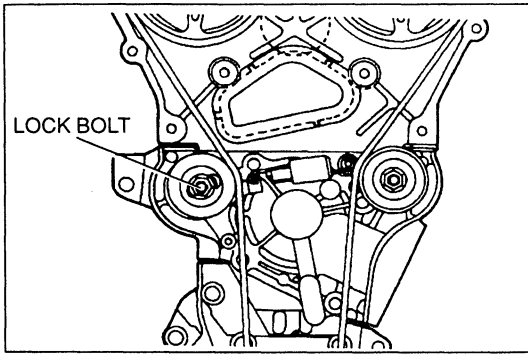
- ① Timing belt pulley
- ② Idler pulley
- ③ Camshaft pulley (LH)
- ④ Camshaft pulley (RH)
- ⑤ Tensioner



### Pulley boss

1. Install the pulley boss and pulley lock bolt. Turn the crankshaft clockwise 1 and 5/6 times, and verify that the timing mark and the tension set mark (A) are aligned.

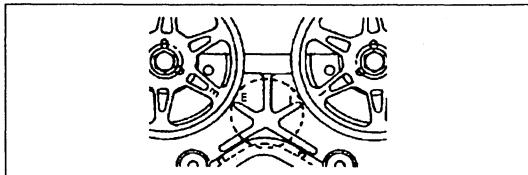




2. Loosen the tensioner lock bolt to apply tension to the timing belt. Do not apply tension other than that of the tensioner spring.
3. Tighten the tensioner lock bolt.

**Tightening torque:**

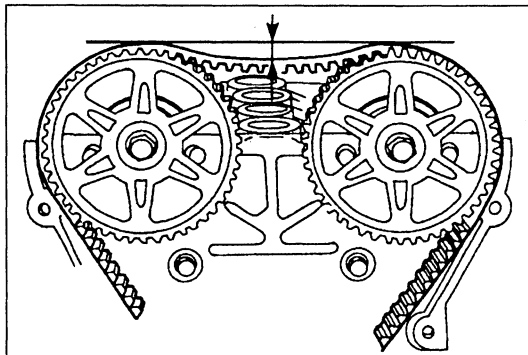
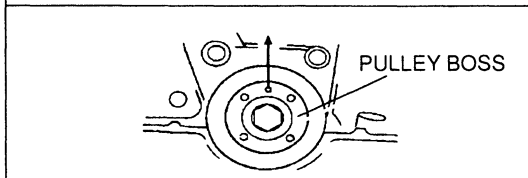
**38—51 N·m { 3.8—5.3 kgf·m , 28—38 ft·lbf }**



4. Turn the crankshaft clockwise 2 and 1/6 times, and verify that all timing marks are correctly aligned.

**Note**

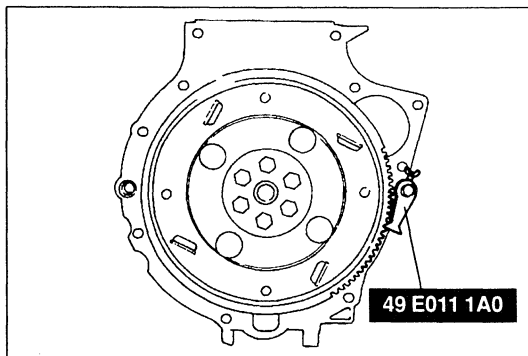
- For the crankshaft side, face the locating pin on the pulley boss straight up.



5. Check the belt deflection at the point indicated by applying moderate pressure **98 N { 10 kgf , 22 lbf }**.

**Deflection: 9.0—11.5 mm { 0.36—0.45 in }**

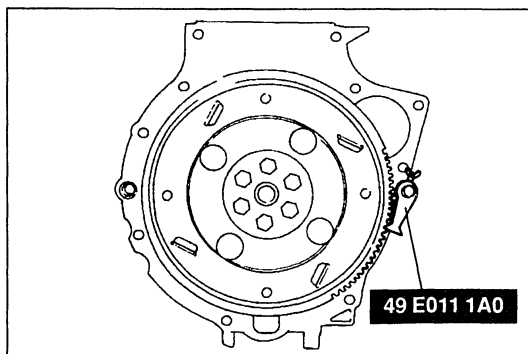
6. If the timing belt deflection is not correct, remove the timing belt and repeat from timing belt assembly note step 1.



7. Hold the drive plate (ATX) or flywheel (MTX) by using the **SST**.
8. Tighten the pulley lock bolt.

**Tightening torque: 157—166 N·m**

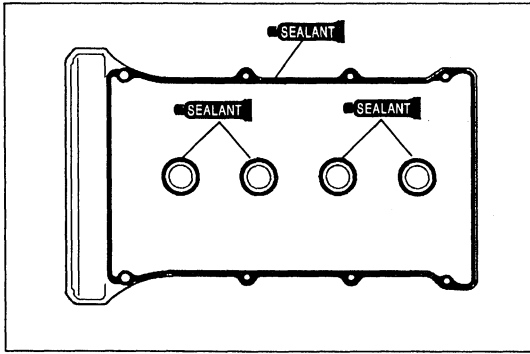
**{ 16.0—17.0 kgf·m , 116—122 ft·lbf }**

**Crankshaft pulley and plate**

1. Hold the drive plate (ATX) or flywheel (MTX) by using the **SST**.
2. Install the crankshaft pulley and plate.

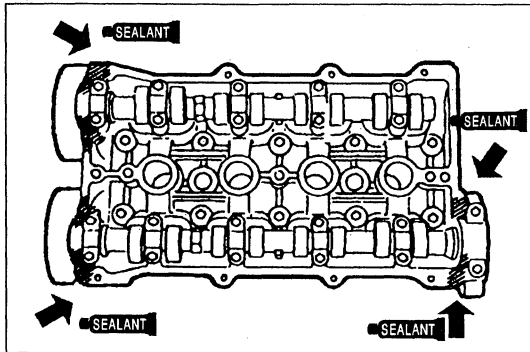
**Tightening torque: 12.3—17.1 N·m**

**{ 1.25—1.75 kgf·m , 9.05—12.6 ft·lbf }**

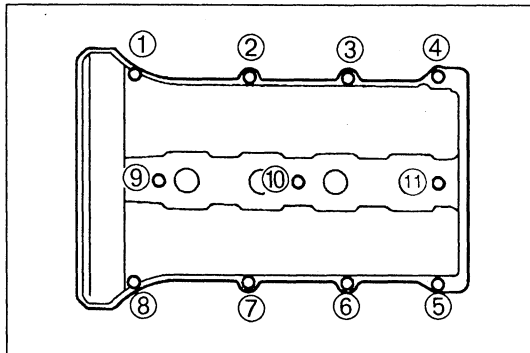


### Cylinder head cover

1. Remove all foreign material from the cylinder head cover groove.
2. Apply silicone sealant to the cylinder head cover as shown.
3. Install the new cylinder head cover gasket into the cylinder head cover.



4. Apply silicone sealant to the shaded areas as shown.
5. Install the cylinder head cover.



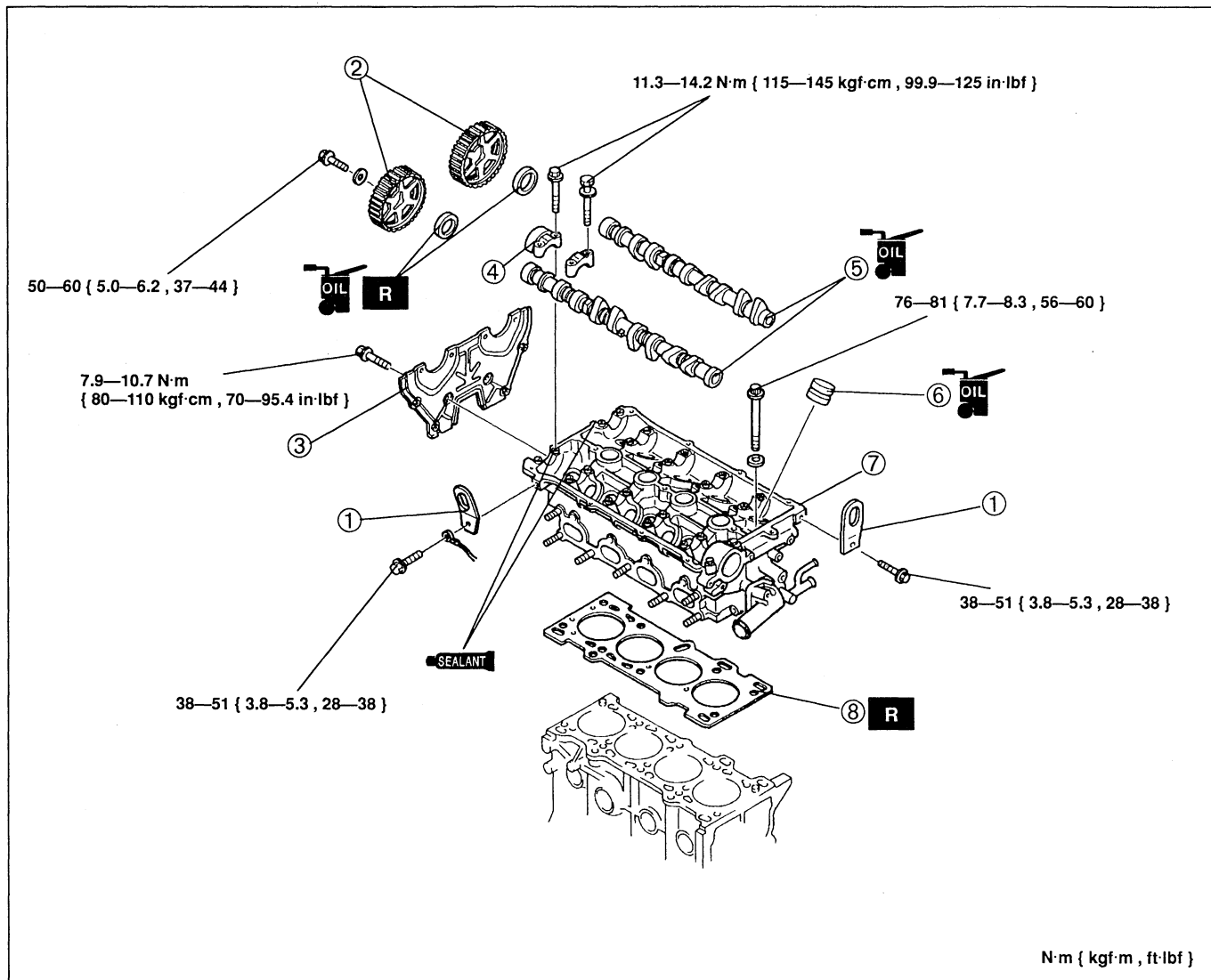
6. Tighten the cylinder head cover bolts in five or six steps in the order shown.

### Tightening torque:

5.0—8.8 N·m { 50—90 kgf·cm , 44—78 in·lbf }

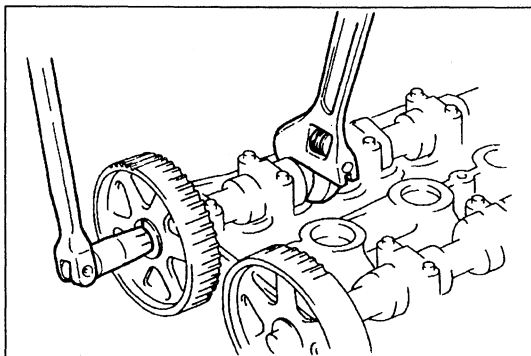
**CYLINDER HEAD (I)**

1. Disassemble in the order shown in the figure, referring to **Disassembly Note**.
2. Assemble in the reverse order of disassembly, referring to **Assembly Note**.



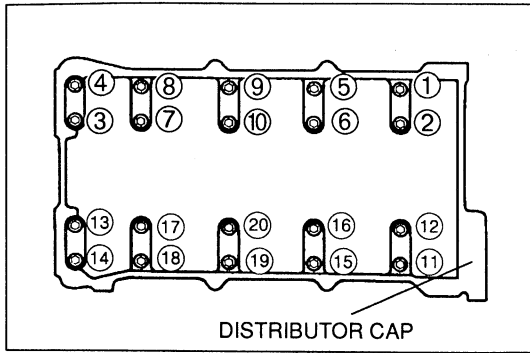
N·m { kgf·m , ft·lbf }

- |                                      |                         |                                      |
|--------------------------------------|-------------------------|--------------------------------------|
| 1. Engine hanger                     | 5. Camshaft             | Disassembly Note . . . . . page B-12 |
| 2. Camshaft pulley                   | 6. HLA                  | Disassembly Note . . . . . page B-12 |
| Disassembly Note . . . . . below     | 7. Cylinder head        | Disassembly Note . . . . . page B-12 |
| Assembly Note . . . . . page B-13    | 8. Cylinder head gasket | Assembly Note . . . . . page B-12    |
| 3. Seal plate                        |                         |                                      |
| 4. Camshaft cap                      |                         |                                      |
| Disassembly Note . . . . . page B-12 |                         |                                      |
| Assembly Note . . . . . page B-12    |                         |                                      |



**Disassembly Note**  
**Camshaft pulley**

1. Hold the camshaft by using a wrench on the cast hexagon as shown, and loosen the camshaft pulley lock bolt.
2. Remove the camshaft pulley.



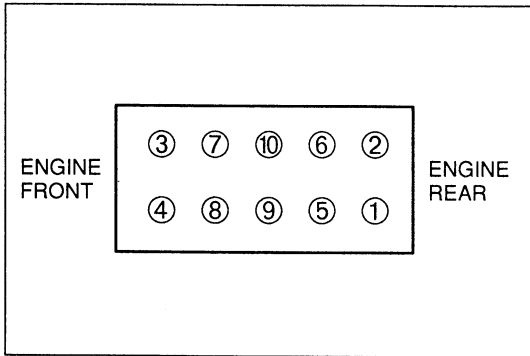
### Camshaft cap

1. Loosen the camshaft cap bolts in five or six steps in the order shown.
2. Remove the camshaft cap bolts and camshaft caps.

### Camshaft

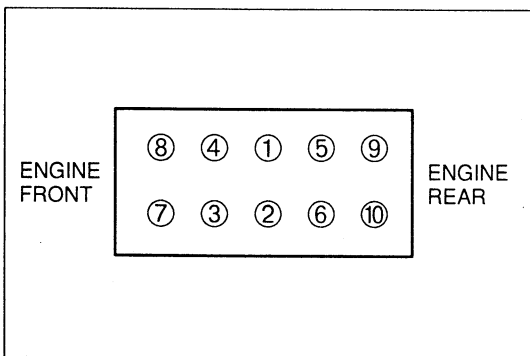
Before removing the camshaft, inspect the following.

- (1) Camshaft end play (Refer to page B-30.)
- (2) Camshaft journal oil clearance (Refer to page B-30.)



### Cylinder head

1. Loosen the cylinder head bolts in two or three steps in the order shown.
2. Remove the cylinder head.



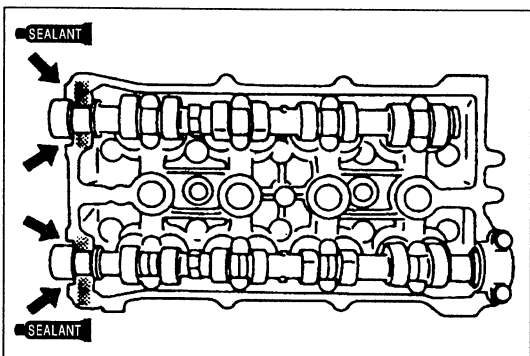
### Assembly Note

#### Cylinder head

Install the bolts and tighten them in two or three steps in the order shown.

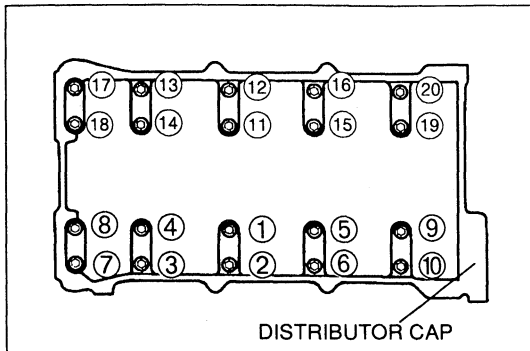
#### Tightening torque:

76—81 N·m { 7.7—8.3 kgf·m , 56—60 ft·lbf }



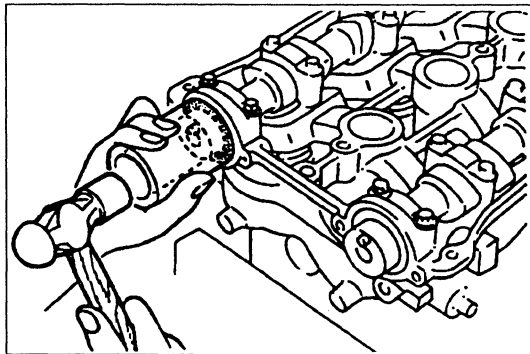
### Camshaft cap

1. Apply silicone sealant to the shaded areas shown in the figure.



2. Install the camshaft caps to the positions from which they were removed.
3. Tighten the camshaft cap bolts in five or six steps in the order shown.

**Tightening torque: 11.3—14.2 N·m**  
 { 115—145 kgf·cm , 99.9—125 in·lbf }

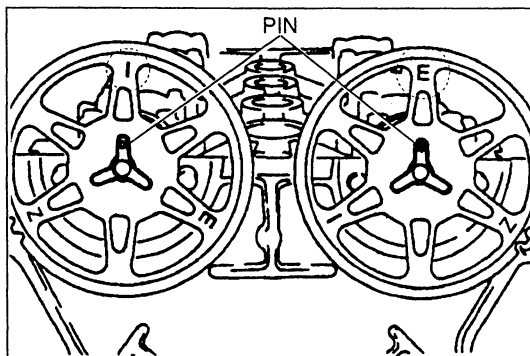


4. Apply clean engine oil to the lip of the new camshaft oil seal.
5. Push the oil seal slightly in by hand.
6. Tap the camshaft oil seal in evenly by using a pipe.

**Protrusion: 0—0.4 mm { 0—0.01 in }**

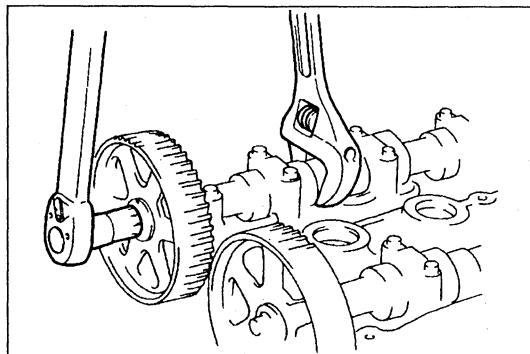
#### Note

- Oil seal outer diameter: 48.0 mm { 1.89 in }
- Oil seal inner diameter: 34.2 mm { 1.35 in }



#### Camshaft pulley

1. Install the camshaft pulleys with the "I" mark (intake side) or the "E" mark (exhaust side) straight up.

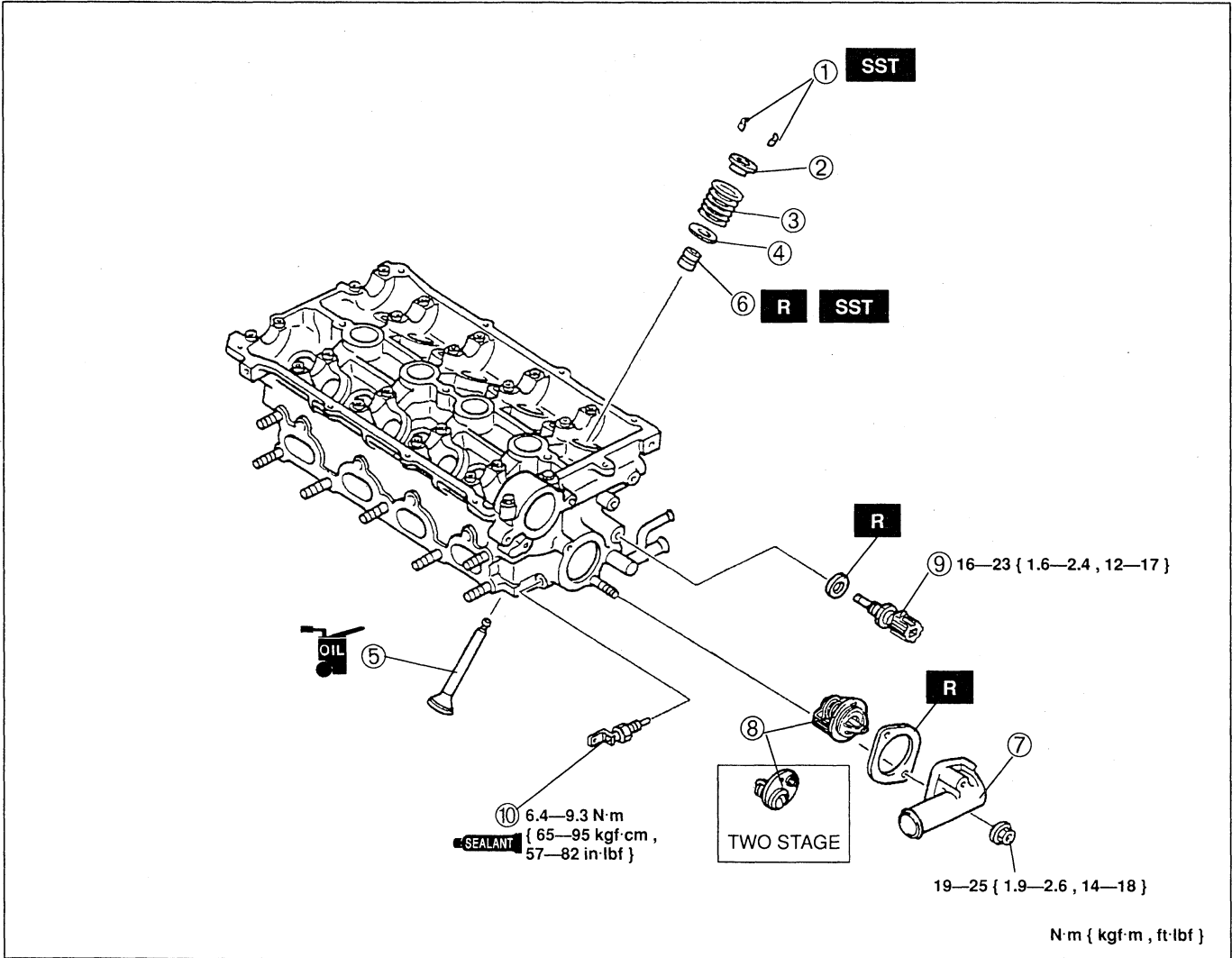


2. Hold the camshaft by using a wrench on the cast hexagon, and tighten the camshaft pulley lock bolt.

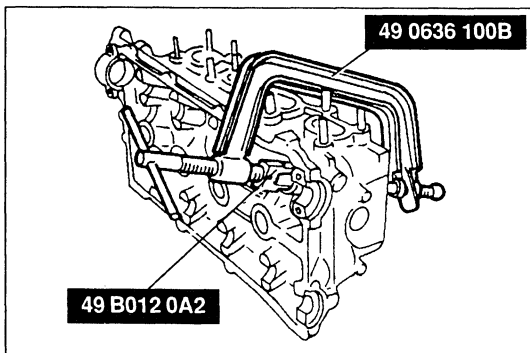
**Tightening torque:**  
 50—60 N·m { 5.0—6.2 kgf·m , 37—44 ft·lbf }

**CYLINDER HEAD (II)**

1. Disassemble in the order shown in the figure, referring to **Disassembly Note**.
2. Assemble in the reverse order of disassembly, referring to **Assembly Note**.

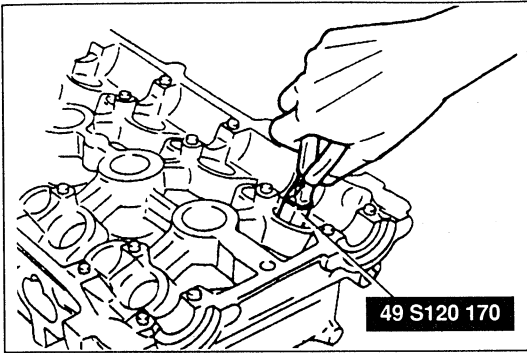


- |   |   |
|---|---|
| <ol style="list-style-type: none"> <li>1. Valve keeper<br/>Disassembly Note ..... below<br/>Assembly Note ..... page B-16</li> <li>2. Valve spring seat, upper</li> <li>3. Valve spring<br/>Assembly Note ..... page B-16</li> <li>4. Valve spring seat, lower</li> <li>5. Valve</li> </ol> | <ol style="list-style-type: none"> <li>6. Valve seal<br/>Disassembly Note ..... page B-15<br/>Assembly Note ..... page B-15</li> <li>7. Thermostat cover</li> <li>8. Thermostat<br/>Assembly Note ..... page B-15</li> <li>9. Engine coolant temperature sensor</li> <li>10. Water temperature sender unit<br/>Assembly Note ..... page B-15</li> </ol> |
|---|---|



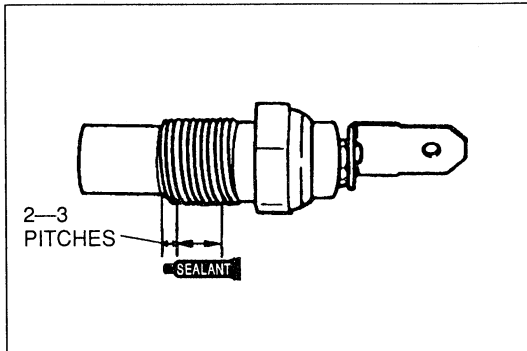
**Disassembly Note**  
**Valve keeper**

1. Set the **SST** against the upper valve spring seat as shown.
2. Remove the valve keepers.



**Valve seal**

Remove the valve seal by using the **SST**.



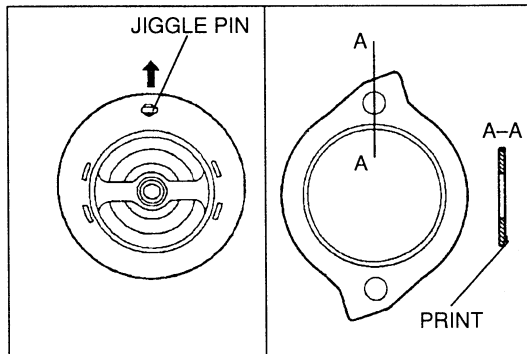
**Assembly Note**

**Water temperature sender unit**

1. Apply silicone sealant to the thread of the water temperature sender unit as shown.
2. Install the water temperature sender unit.

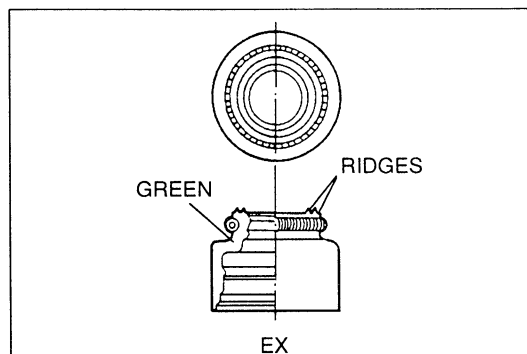
**Tightening torque:**

6.4—9.3 N·m { 65—95 kgf·cm , 57—82 in·lbf }



**Thermostat**

1. Install the thermostat with the jiggle pin facing upward.
2. Install the new gasket with the printed side facing the cylinder head.

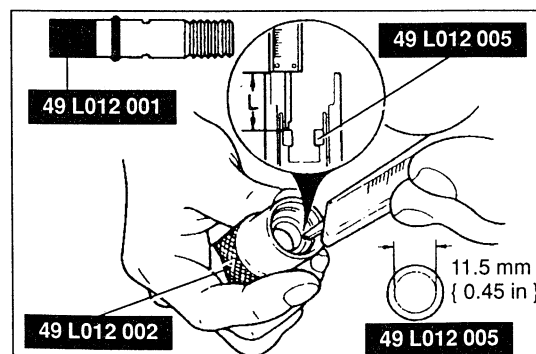


**Valve seal**

**Note**

- The intake and exhaust valve seals are different as shown.

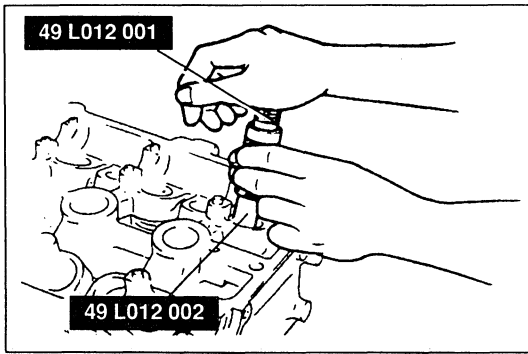
	Ridge	Color
Intake	One	Gray
Exhaust	Two	Green



1. Assemble the **SST** so that depth L is as specified.

**Depth L:** 18.4 mm { 0.724 in } (B6)

19.9 mm { 0.783 in } (BP)

**Caution**

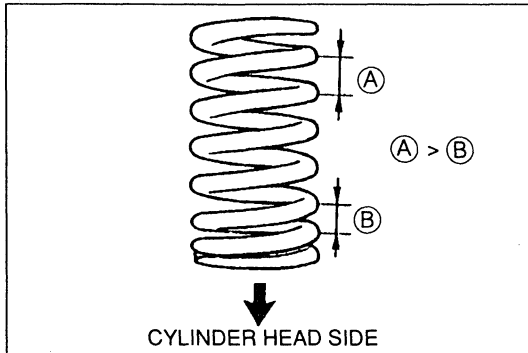
- Using a hammer will damage the valve seal.

2. Using the SST, press the valve seal on by hand.
3. Measure the valve seal setting height.

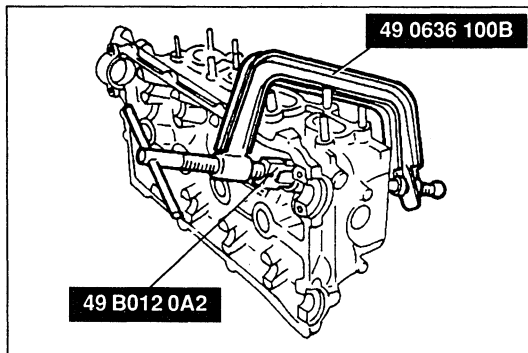
**Valve seal setting height:**

18.4 mm { 0.724 in } (B6)

19.9 mm { 0.783 in } (BP)

**Valve spring**

Install the valve spring with the closer pitch toward the cylinder head.

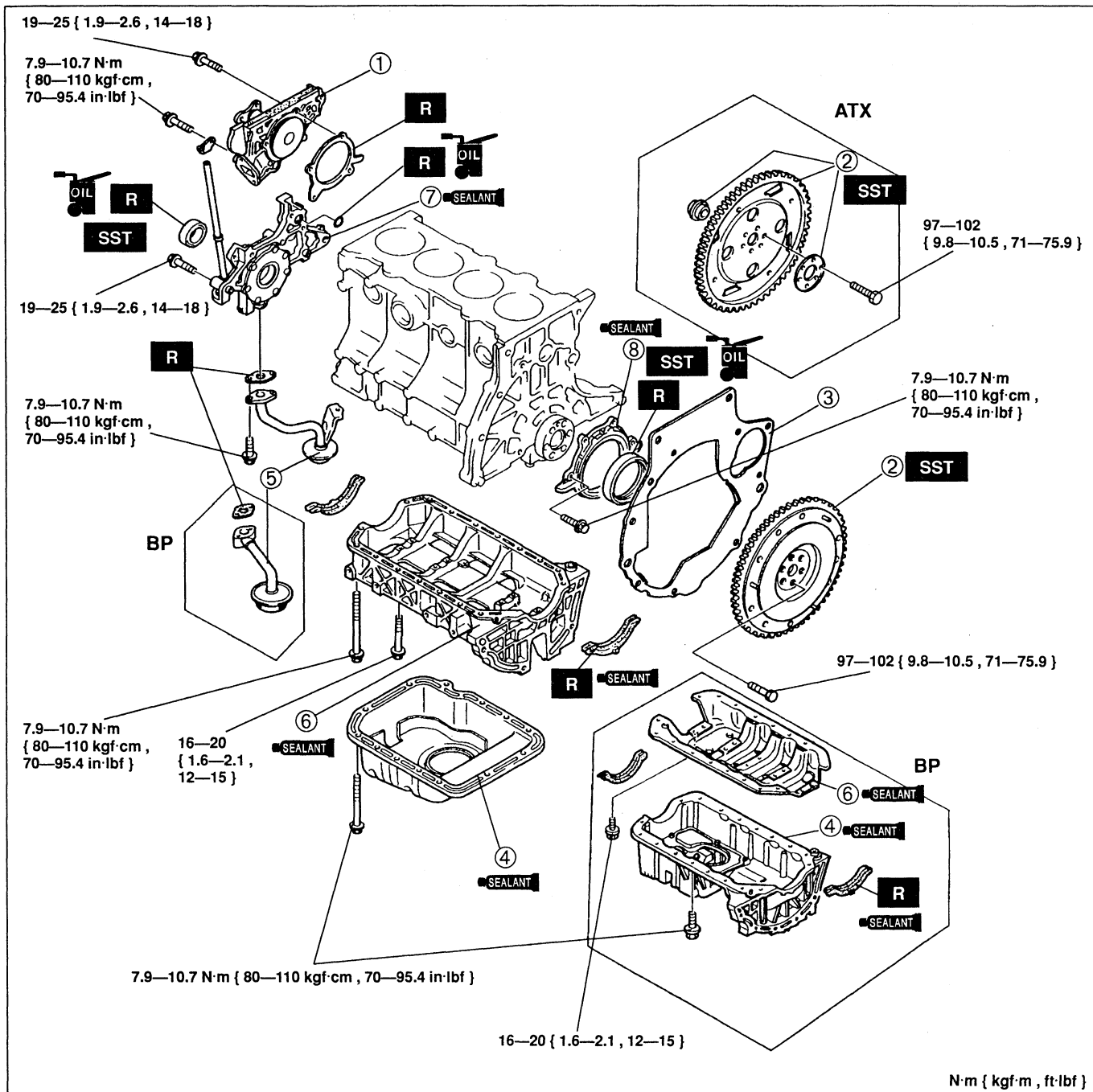
**Valve keeper**

Compress the valve spring by using the SST, and install the valve keepers.

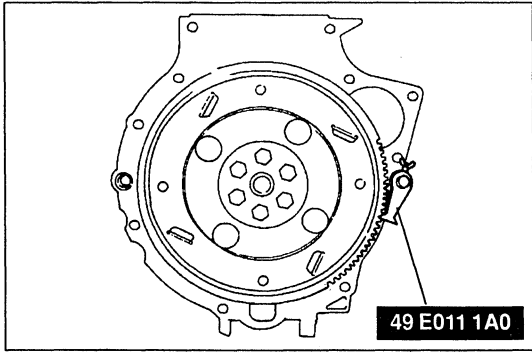


**CYLINDER BLOCK (EXTERNAL PARTS)**

1. Disassemble in the order shown in the figure, referring to **Disassembly Note**.
2. Assemble in the reverse order of disassembly, referring to **Assembly Note**.



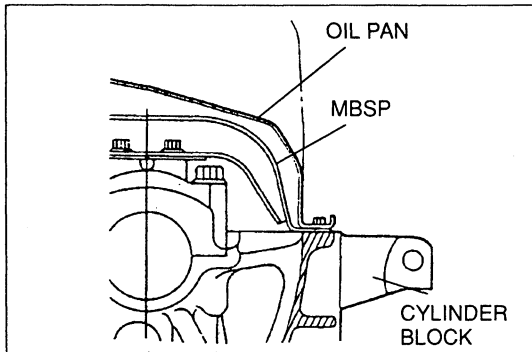
- |  |   |
|--|---|
| <ol style="list-style-type: none"> <li>1. Water pump<br/>Assembly Note ..... page B-21</li> <li>2. Backing plate, drive plate, adapter (ATX),<br/>flywheel (MTX)<br/>Disassembly Note ..... page B-18<br/>Assembly Note ..... page B-21</li> <li>3. End plate</li> <li>4. Oil pan<br/>Disassembly Note ..... page B-18<br/>Assembly Note ..... page B-21</li> <li>5. Oil strainer</li> </ol> | <ol style="list-style-type: none"> <li>6. VRAS (B6)<br/>MBSP (BP)<br/>Disassembly Note ..... page B-18<br/>Assembly Note ..... page B-20</li> <li>7. Oil pump<br/>Disassembly Note ..... page B-18<br/>Assembly Note ..... page B-19<br/>Disassembly / Inspection /<br/>Assembly ..... section D</li> <li>8. Rear cover<br/>Disassembly Note ..... page B-19<br/>Assembly Note ..... page B-19</li> </ol> |
|--|---|



### Disassembly Note

#### Backing plate, drive plate, adapter (ATX), flywheel (MTX)

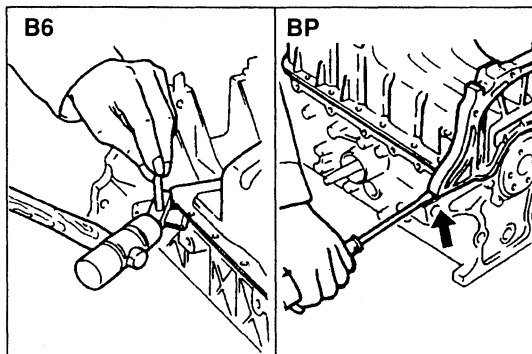
1. Hold the drive plate (ATX) or flywheel (MTX) by using the SST.
2. Remove the drive plate lock bolts and remove the backing plate and adapter. (ATX)
3. Remove the flywheel lock bolts and remove the flywheel. (MTX)



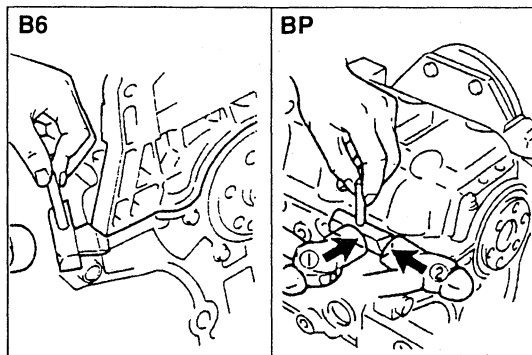
### Oil pan

#### Caution

- Do not insert the prying tool between the MBSP and cylinder block (BP).

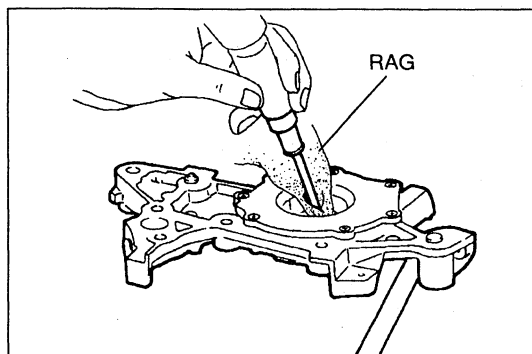


Remove the oil pan by using a scraper or a separator tool.



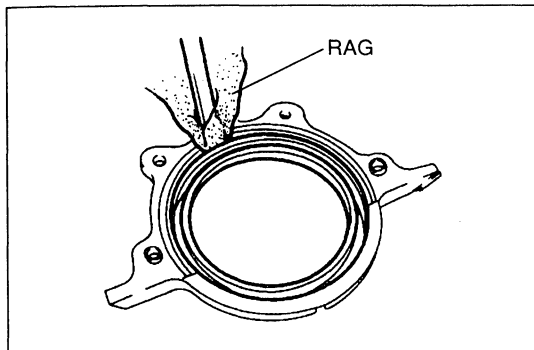
### VRAS (B6), MBSP (BP)

Separate the VRAS or MBSP from the cylinder block by using a scraper or a separator tool.

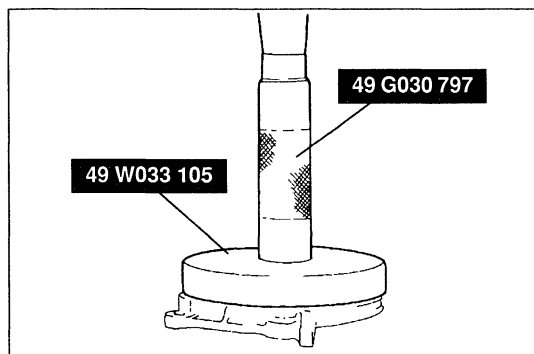


### Oil pump

Remove the oil seal by using a screwdriver protected with a rag.

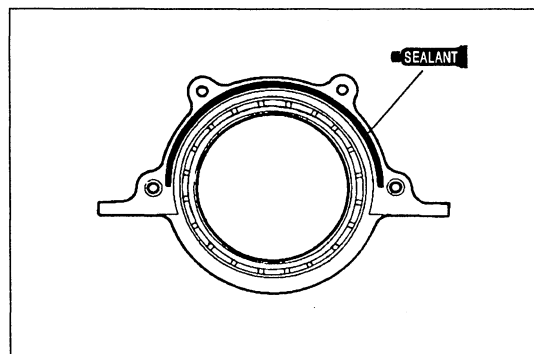
**Rear cover**

Remove the oil seal by using a screwdriver protected with a rag.

**Assembly Note****Rear cover**

1. Apply clean engine oil to the new oil seal.
2. Push the oil seal slightly in by hand.
3. Press the oil seal in evenly by using the SST.

**Protrusion: 0—0.5 mm { 0—0.019 in }**



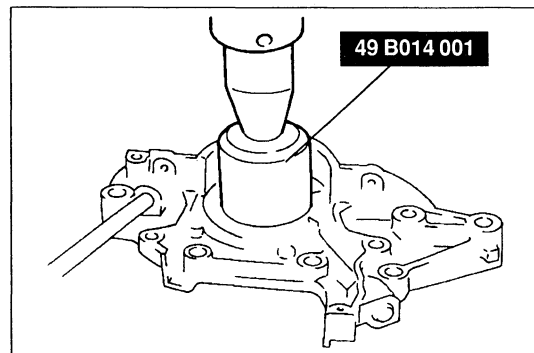
4. Apply silicone sealant to the rear cover as shown.

**Thickness:  $\phi$  2 mm { 0.079 in }**

5. Install the rear cover.

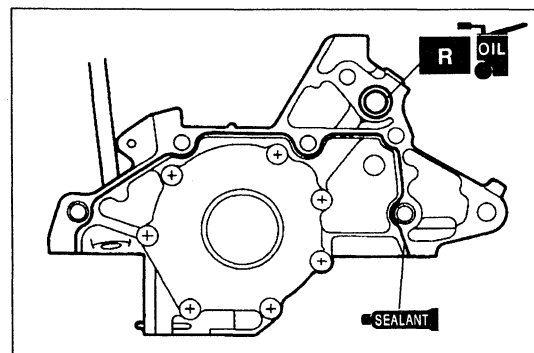
**Tightening torque:**

**7.9—10.7 N·m { 80—110 kgf·cm , 70—95.4 in·lbf }**

**Oil pump**

1. Apply clean engine oil to the new oil seal.
2. Push the oil seal slightly in by hand.
3. Press the oil seal in evenly by using the SST.

**Protrusion: 0.5—1.0 mm { 0.020—0.039 in }**



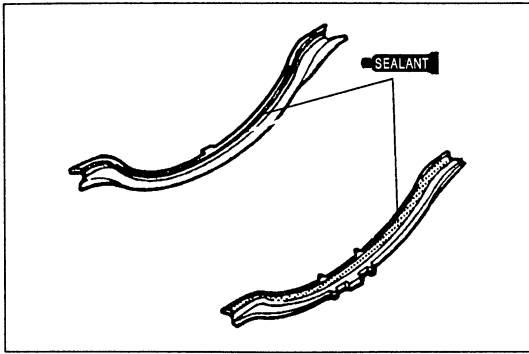
4. Install the new O-ring.
5. Apply silicone sealant to the oil pump body as shown.

**Thickness:  $\phi$  1—2 mm { 0.040—0.078 in }**

6. Install the oil pump.

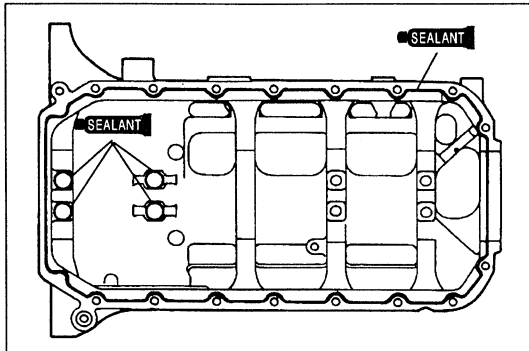
**Tightening torque:**

**19—25 N·m { 1.9—2.6 kgf·m , 14—18 ft·lbf }**



### VRAS (B6)

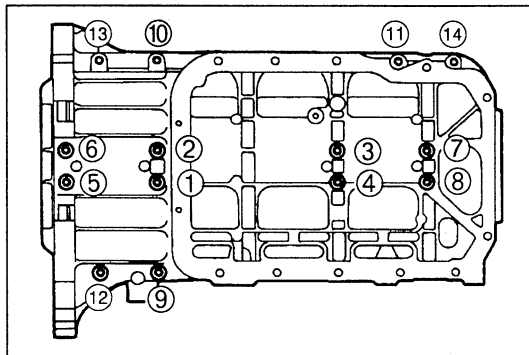
1. Apply silicone sealant to the oil pump and rear cover mounting surfaces of the new oil pan gaskets, and install them.



2. Apply silicone sealant to the VRAS as shown.

**Thickness:  $\phi$  2—3 mm { 0.079—0.118 in }**

3. Install the VRAS.



4. Tighten the bolts in the order shown.

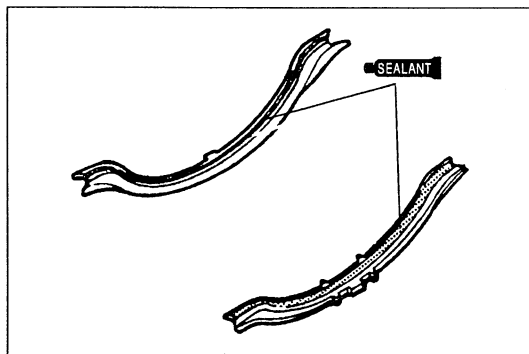
### Tightening torque

①—⑧:

**16—20 N·m { 1.6—2.1 kgf·m , 12—15 ft·lbf }**

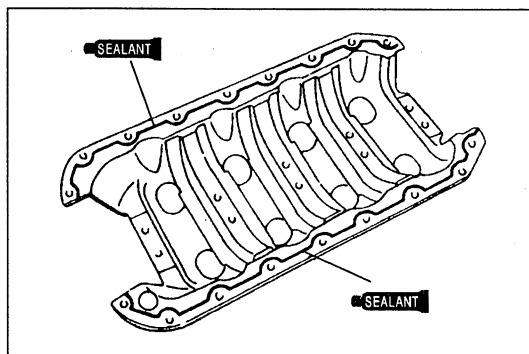
⑨—⑭:

**7.9—10.7 N·m { 80—110 kgf·cm , 70—95.4 in·lbf }**



### MBSP (BP)

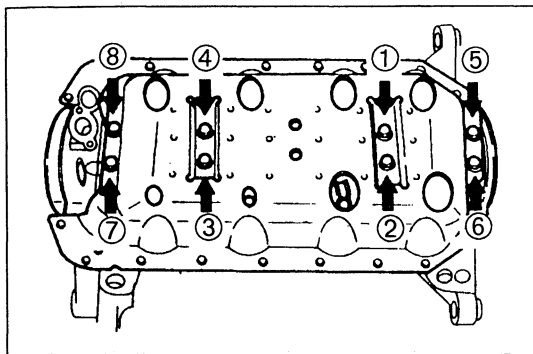
1. Apply silicone sealant to the oil pump and rear cover mounting surfaces of the new oil pan gaskets, and install them.



2. Apply silicone sealant to the MBSP as shown.

**Thickness:  $\phi$  2.5—3.5 mm { 0.099—0.137 in }**

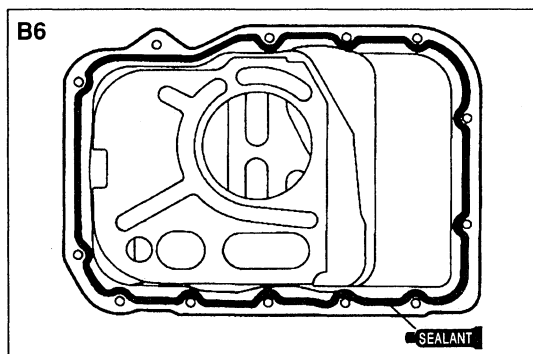
3. Install the MBSP.



- Tighten the bolts in the order shown in the figure.

**Tightening torque:**

16—20 N·m { 1.6—2.1 kgf·m , 12—15 ft·lbf }

**Oil pan**

- Apply silicone sealant to the oil pan as shown.

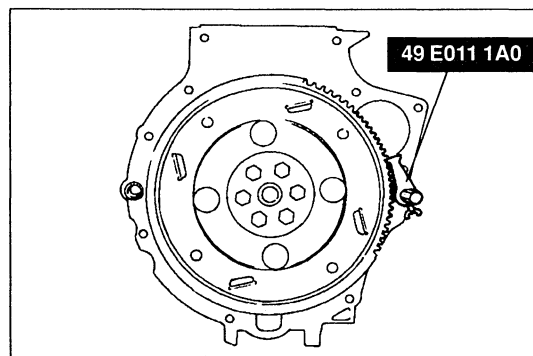
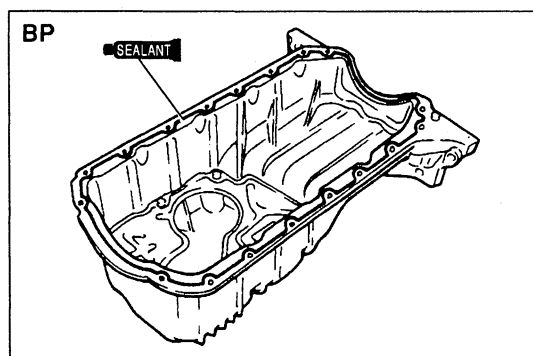
**Thickness:**  $\phi$  2—3 mm { 0.079—0.118 in } (B6)

$\phi$  2.5—3.5 mm { 0.099—0.137 in } (BP)

- Install the oil pan.

**Tightening torque:**

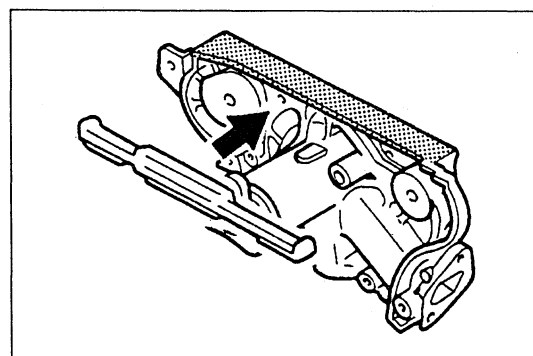
7.9—10.7 N·m { 80—110 kgf·cm , 70—95.4 in·lbf }

**Backing plate, drive plate, adapter (ATX), flywheel (MTX)**

- Hold the drive plate (ATX) or flywheel (MTX) by using the SST.
- Install the drive plate. (ATX)
- Install the flywheel. (MTX)

**Tightening torque:**

97—102 N·m { 9.8—10.5 kgf·m , 71—75.9 ft·lbf }

**Water pump**

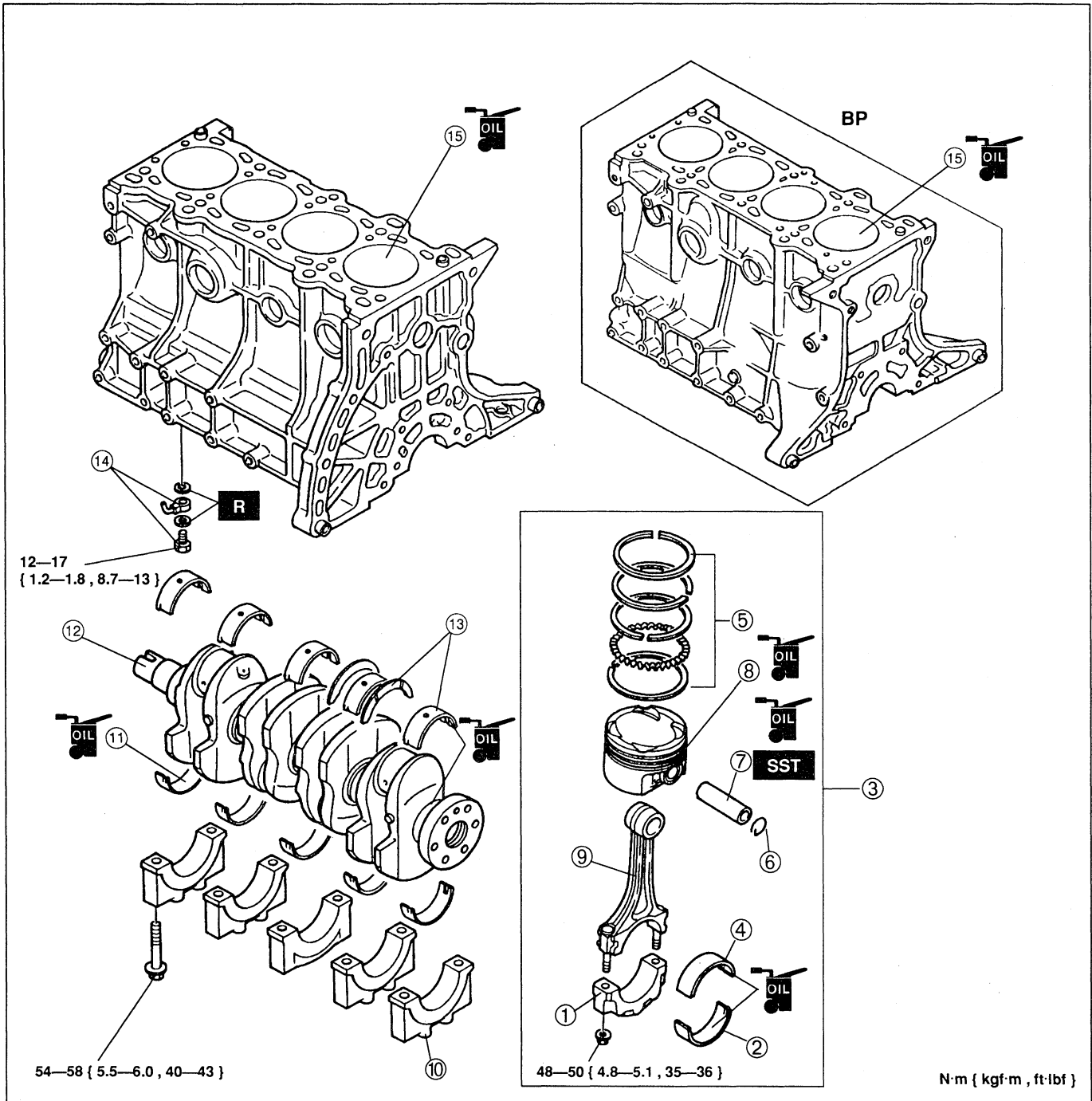
- Verify that the rubber seal is securely fixed onto the water pump.
- If not, remove the rubber seal and reinstall it with the bonding agent.
- Install the water pump.

**Tightening torque:**

19—25 N·m { 1.9—2.6 kgf·m , 14—18 ft·lbf }

**CYLINDER BLOCK (INTERNAL PARTS)**

1. Disassemble in the order shown in the figure, referring to **Disassembly Note**.
2. Assemble in the reverse order of disassembly, referring to **Assembly Note**.



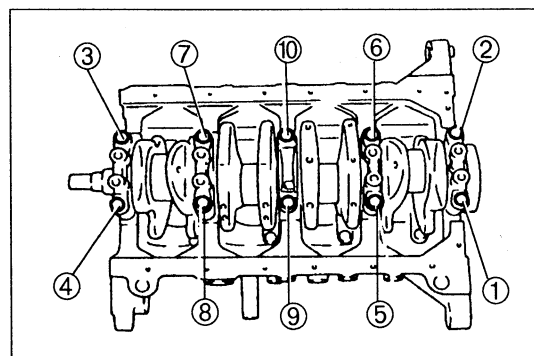
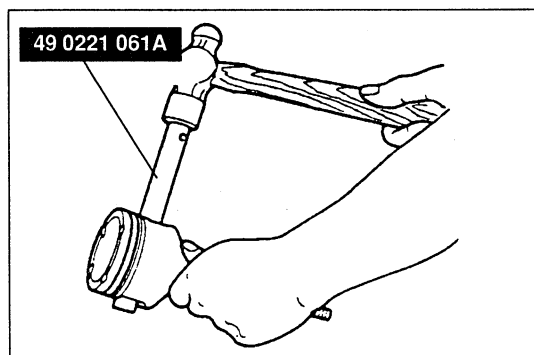
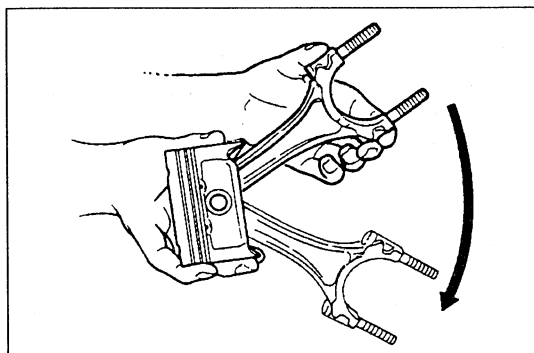
- |                                       |  |
|---------------------------------------|--|
| 1. Connecting rod cap                 | 8. Piston                                  |
| 2. Connecting rod bearing, lower      | 9. Connecting rod                          |
| 3. Piston and connecting rod assembly | 10. Main bearing cap                       |
| Disassembly Note ..... page B-23      | Disassembly Note ..... page B-23           |
| Assembly Note ..... page B-24         | Assembly Note ..... page B-24              |
| 4. Connecting rod bearing, upper      | 11. Main bearing, lower                    |
| 5. Piston ring                        | 12. Crankshaft                             |
| 6. Piston pin clip                    | Disassembly Note ..... page B-23           |
| 7. Piston pin                         | 13. Main bearing, upper and thrust bearing |
| Disassembly Note ..... page B-23      | 14. Oil jet valve and nozzle               |
| Assembly Note ..... page B-24         | 15. Cylinder block                         |

N·m { kgf·m , ft·lbf }

**Disassembly Note****Piston and connecting rod assembly**

Before removing the piston and connecting rod assembly, inspect the following.

- (1) Connecting rod large end side clearance  
(Refer to page B-33.)
- (2) Connecting rod bearing oil clearance  
(Refer to page B-33.)

**Piston pin****Caution**

- The connecting rods must be reinstalled in the same positions from which they were removed. If they are not, it can cause premature and uneven wear.

**Note**

- Mark the connecting rods to show their original positions.

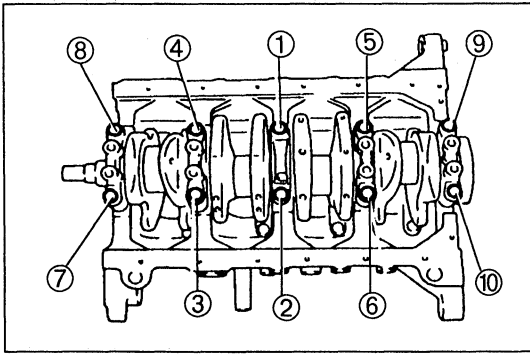
1. Before disassembling the piston and connecting rod, check the oscillation torque as shown. If the large end does not drop by its own weight, replace the piston or the piston pin.
2. Remove the piston pin by using the **SST**.

**Main bearing cap**

1. Before removing the main bearing caps, measure the crankshaft end play. (Refer to page B-35.)
2. Loosen the main bearing cap bolts in two or three steps in the order shown.
3. Remove the main bearing caps.

**Crankshaft**

Before removing the crankshaft, measure the main bearing oil clearances. (Refer to page B-36.)



### Assembly Note Main bearing cap

Tighten the main bearing cap bolts in two or three steps in the order shown.

#### Tightening torque:

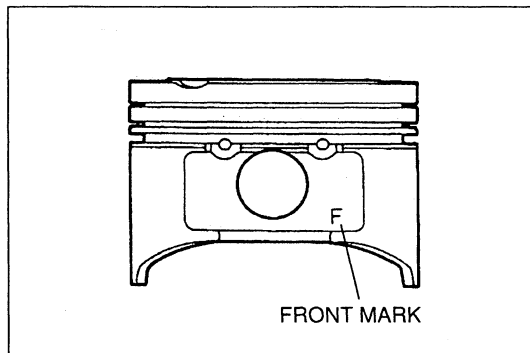
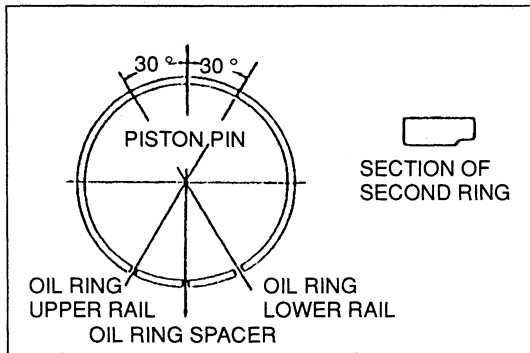
54—58 N·m { 5.5—6.0 kgf·m , 40—43 ft·lbf }

### Piston pin

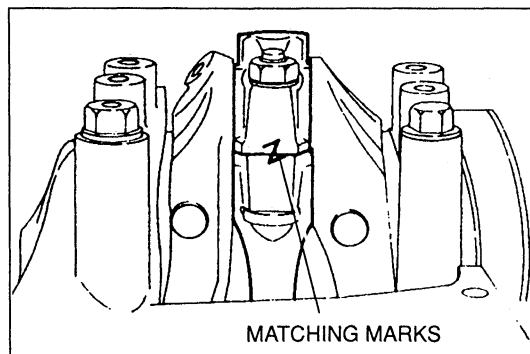
1. Install the piston pin clip into the clip groove in the piston.
2. Assemble the piston and the connecting rod in the direction from which they were disassembled.
3. Apply clean engine oil to the piston pin.
4. Install the piston pin from the side opposite the clip.
5. Install the piston pin until the pin contacts the clip. If the pin cannot be installed easily, heat the piston.
6. Install the second clip into the clip groove in the piston.
7. Check the oscillation torque of the connecting rod. (Refer to page B-23.)

### Piston and connecting rod assembly

1. Verify that the second ring is installed with the scraper face downward.
2. Verify that the top ring is installed with R mark (tapered side) face upward. When the ring has no mark (taper), it can be installed with either side facing upward.
3. Position the end gap of each ring as shown.



4. Insert the piston and connecting rod assembly into the cylinder with the F mark facing the front of the engine.



5. Align the matching marks on the connecting rod and the connecting rod cap, install the connecting rod cap.

#### Tightening torque:


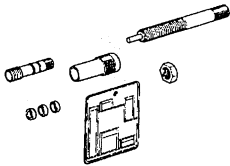
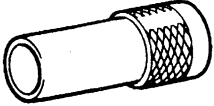
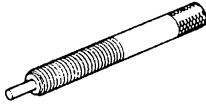

48—50 N·m { 4.8—5.1 kgf·m , 35—36 ft·lbf }

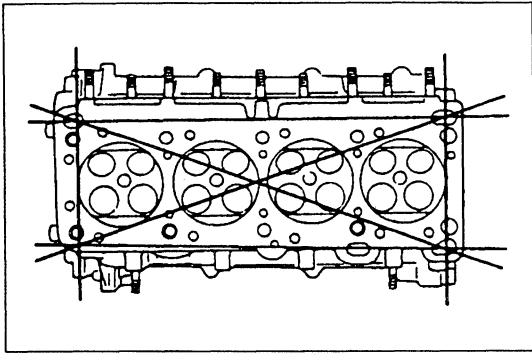


## INSPECTION / REPAIR

## PREPARATION

## SST

<p>49 B012 005</p> <p>Replacer valve guide</p> 	<p>For removal of valve guides</p>	<p>49 L012 0A0</p> <p>Installer set, valve seal &amp; valve guide</p> 	<p>For installation of valve guides</p>
<p>49 L012 002</p> <p>Body (Part of 49 L012 0A0)</p> 	<p>For installation of valve guides</p>	<p>49 L012 003</p> <p>Installer (Part of 49 L012 0A0)</p> 	<p>For installation of valve guides</p>
<p>49 L012 004</p> <p>Nut (Part of 49 L012 0A0)</p> 	<p>For installation of valve guides</p>	<p>—</p>	<p>—</p>



### CYLINDER HEAD

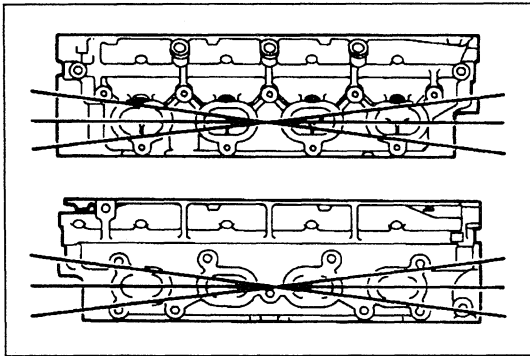
1. Carry out coloring flaw detection on the cylinder head surface. Replace the cylinder head if necessary.
2. Measure the cylinder head for distortion in the six directions as shown.

**Distortion: 0.15 mm { 0.006 in } max. (B6)**  
**0.10 mm { 0.004 in } max. (BP)**

3. Inspect for the following and repair or replace as necessary.
  - (1) Sunken valve seats
  - (2) Damaged intake and exhaust manifold contact surfaces
  - (3) Excessive camshaft oil clearance and end play
4. If the cylinder head distortion exceeds the maximum, repair by grinding or replace the cylinder head. If the cylinder head height is not within the specification, replace it.

**Grinding: 0.20 mm { 0.008 in } max. (B6)**  
**0.10 mm { 0.004 in } max. (BP)**

**Height: 133.8—140.0 mm { 5.268—5.511 in }**

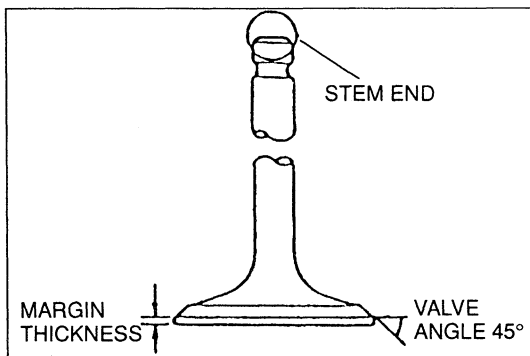


5. Measure the intake manifold and exhaust manifold contact surfaces for distortion in the six directions as shown.

**Distortion: 0.15 mm { 0.006 in } max.**

6. If the distortion exceeds the specification, grind the surface or replace the cylinder head.

**Grinding: 0.20 mm { 0.008 in } max.**

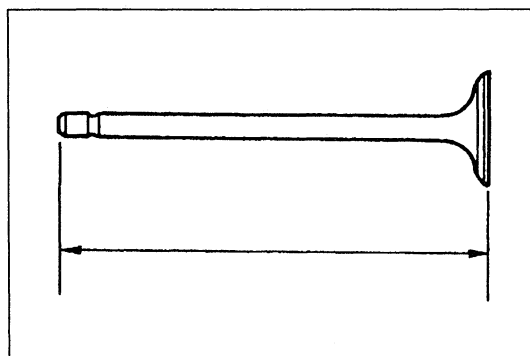


### VALVE, VALVE GUIDE

1. Measure the valve head margin thickness. Replace the valve if necessary

#### Margin thickness

**IN: 1.0 mm { 0.039 in } min. (B6)**  
**1.350 mm { 0.053 in } min. (BP)**  
**EX: 1.0 mm { 0.039 in } min. (B6)**  
**1.475 mm { 0.058 in } min. (BP)**

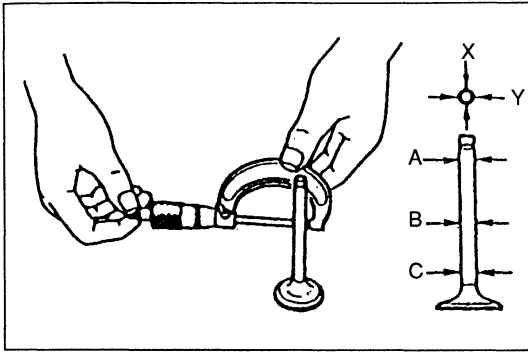


2. Measure the valve length. Replace the valve if necessary.

#### Length

mm { in }

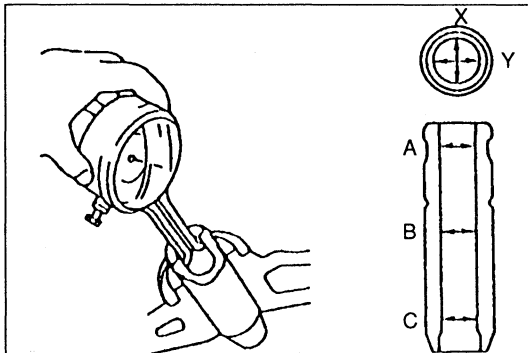
		B6	BP
IN	Standard	104.89—105.69 { 4.1296—4.1610 }	100.94—101.74 { 3.9741—4.0055 }
	Minimum	104.79 { 4.1256 }	100.84 { 3.9701 }
EX	Standard	104.96—105.79 { 4.1323—4.1649 }	101.04—101.84 { 3.9780—4.0094 }
	Minimum	104.89 { 4.1295 }	100.74 { 3.9661 }



3. Measure the valve stem diameter of each valve in X and Y directions at the three points (A, B, and C) shown. Replace the valve if necessary.

**Diameter**

**IN Standard: 5.970—5.985 mm { 0.2351—0.2356 in }**  
**Minimum: 5.920 mm { 0.2331 in }**  
**EX Standard: 5.965—5.980 mm { 0.2349—0.2354 in }**  
**Minimum: 5.915 mm { 0.2329 in }**



4. Measure the inner diameter of each valve guide in X and Y directions at the three points (A, B, and C) shown. Replace the valve guide if necessary.

**Inner diameter:**

**6.01—6.03 mm { 0.2367—0.2374 in }**  
**6.02—6.04 mm { 0.2371—0.2377 in }**

**(Service parts)**

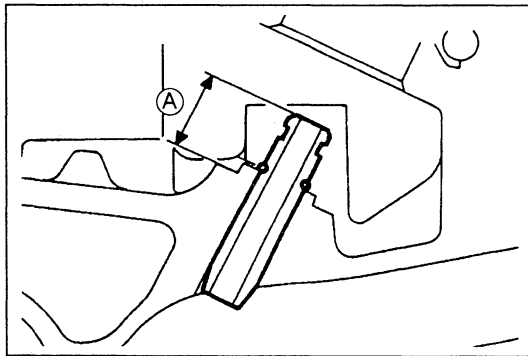
5. Calculate the valve stem-to-valve guide clearance. Subtract the outer diameter of the valve stem from the inner diameter of the corresponding valve guide.

**Clearance**

**IN: 0.025—0.060 mm { 0.0010—0.0023 in }**  
**0.035—0.070 mm { 0.0014—0.0027 in }**

**(Service parts)**

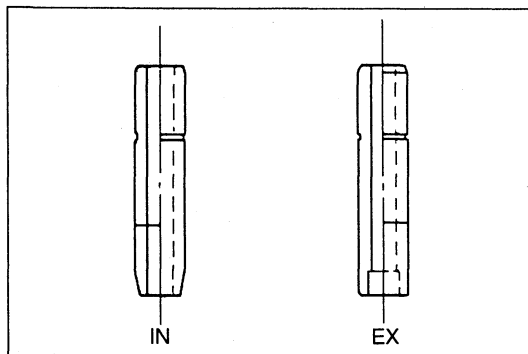
**EX: 0.030—0.065 mm { 0.0012—0.0025 in }**  
**0.040—0.075 mm { 0.0016—0.0029 in }**

**(Service parts)****Maximum: 0.20 mm { 0.008 in }**

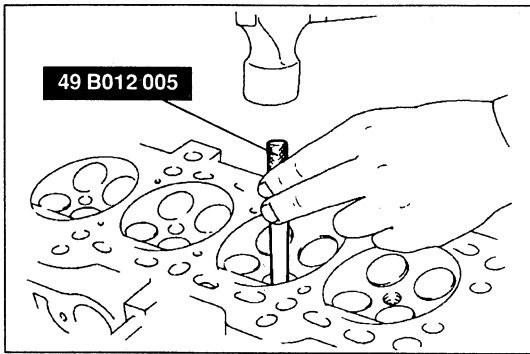
6. If the clearance exceeds the specification, replace the valve and/or valve guide.

7. Measure the protrusion height (dimension Ⓐ) of each valve guide without valve spring seat, low. Replace the valve guide if necessary.

**Height: 16.8—17.4 mm { 0.662—0.685 in } (B6)**  
**18.3—18.9 mm { 0.721—0.744 in } (BP)**

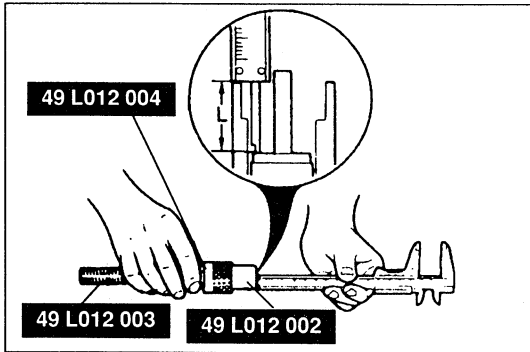
**Replacement of valve guide****Note**

- Although the shapes of the intake and exhaust valve guides are different, use the exhaust valve guide on both sides as a replacement.



### Removal

Using the **SST**, remove the valve guide from the combustion chamber side.

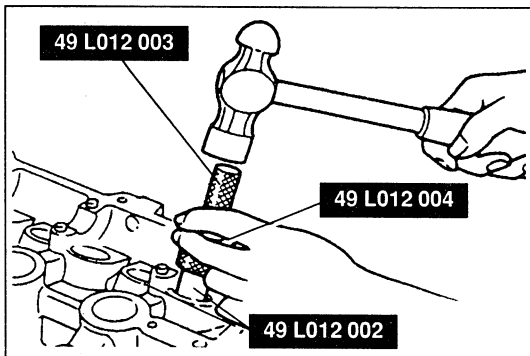


### Installation

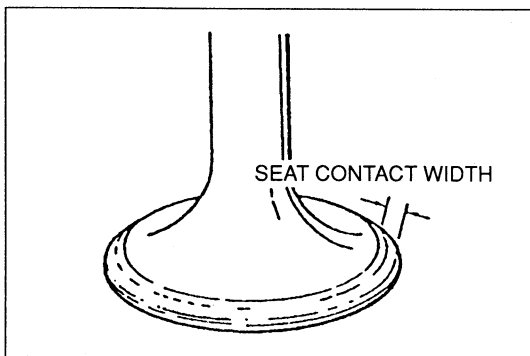
1. Assemble the **SSTs** so that depth L is as specified.

**Depth L:** 16.8—17.4 mm { 0.662—0.685 in } (B6)  
18.3—18.9 mm { 0.721—0.744 in } (BP)

2. Tighten the nut.
3. Fit the clip onto the valve guide.



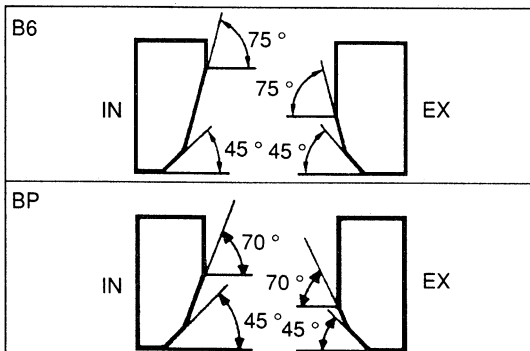
4. Using the **SST**, tap the valve guide in from the side opposite the combustion chamber until the **SST** contacts the cylinder head.
5. Verify that the valve guide protrusion height is within the specification. (Refer to page B-27.)



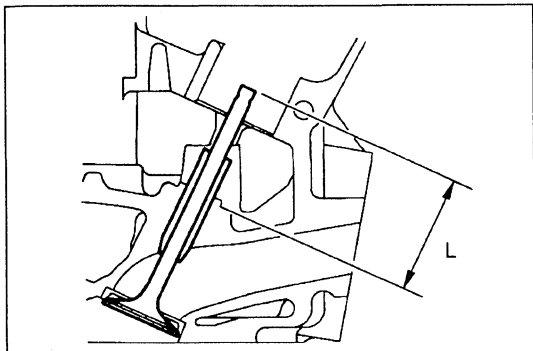
### VALVE SEAT

1. If necessary, resurface the valve seat by using a **45°** valve seat cutter and/or resurface the valve face.
2. Apply a thin coat of prussian blue to the valve face.
3. Check the valve seating by pressing the valve against the seat.  
If blue does not appear 360° around the valve seat, resurface the seat.
4. Measure the seat contact width.

**Width:** 0.8—1.4 mm { 0.032—0.055 in }



5. Verify that the valve seating position is at the center of the valve face.
  - (1) If the seating position is too high, correct the valve seat using a **75°** (B6) or **70°** (BP) cutter, and a **45°** cutter.
  - (2) If the seating position is too low, correct the valve seat using a **0°** cutter, and a **45°** cutter.
6. Seat the valve to the valve seat using lapping compound.
7. Check the sinking of the valve seat.
  - (1) Measure the protruding length (dimension L) of the valve stem.



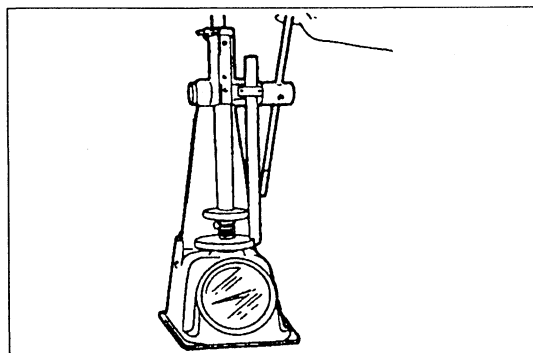
**Dimension L: 43.5 mm { 1.713 in } (B6)  
45.0 mm { 1.772 in } (BP)**

(2) If L is as below, it can be used as it is.

**43.5—44.0 mm { 1.713—1.732 in } (B6)  
45.0—45.5 mm { 1.772—1.791 in } (BP)**

(3) If L is more than below, replace the cylinder head.

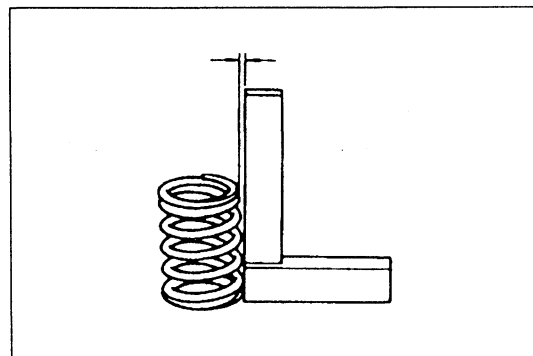
**44.1 mm { 1.736 in } (B6)  
45.6 mm { 1.795 in } (BP)**



**VALVE SPRING**

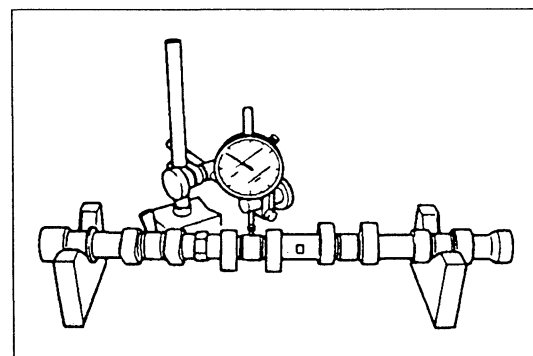
1. Apply pressing force to the valve spring and check the spring height.

		B6	BP
Pressing force N { kgf , lbf }	IN	217.1—245.6 { 22.13—25.05 , 48.69—55.11 }	224—253 { 22.8—25.8 , 50.2—56.7 }
	EX	173.3—196.1 { 17.67—20.00 , 38.88—44.00 }	
Height mm { in }	IN	40.0 { 1.57 }	39.5 { 1.56 }
	EX		



2. Replace the valve spring if necessary.  
3. Measure the out-of-square of the valve spring. Replace the valve spring if necessary.

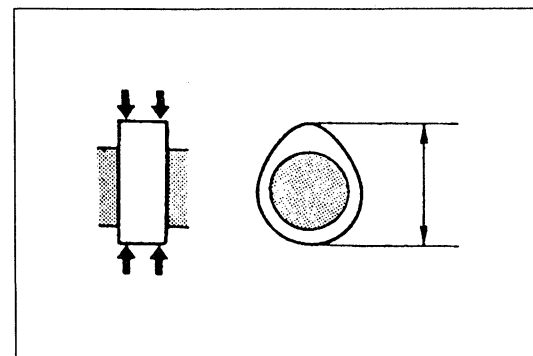
**Out-of-square: 1.69 mm { 0.067 in } max. (B6)  
1.62 mm { 0.064 in } max. (BP)**



**CAMSHAFT**

1. Set the No.1 and No.5 journals on V-blocks.  
2. Measure the camshaft runout. Replace the camshaft if necessary.

**Runout: 0.03 mm { 0.0012 in } max.**

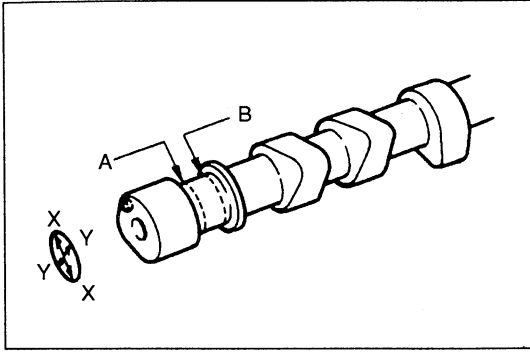


3. Measure the cam lobe heights at the two points as shown.

**Height**

mm { in }

		B6	BP
IN	Standard	40.487 { 1.5940 }	44.094 { 1.7360 }
	Minimum	40.287 { 1.5861 }	43.894 { 1.7281 }
EX	Standard	40.881 { 1.6095 }	44.600 { 1.7560 }
	Minimum	40.681 { 1.6016 }	44.400 { 1.7480 }



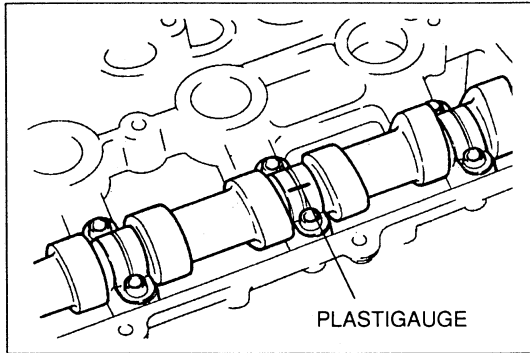
4. Measure the journal diameters in X and Y directions at the two points (A and B) shown. Replace the camshaft if necessary.

**Diameter**

**Standard:**

25.940—25.965 mm { 1.0213—1.0222 in }

**Minimum:** 25.910 mm { 1.0201 in }



5. With the HLA removed, measure the camshaft journal oil clearances as follows.

- (1) Position plastigauge atop the journals in the axial direction.

- (2) Do not rotate the camshaft when measuring the oil clearances.
- (3) Install the camshaft caps and tighten the camshaft cap bolts. (Refer to page B-13.)
- (4) Loosen the camshaft cap bolts and remove the bolts. (Refer to page B-12.)
- (5) Remove the camshaft caps.

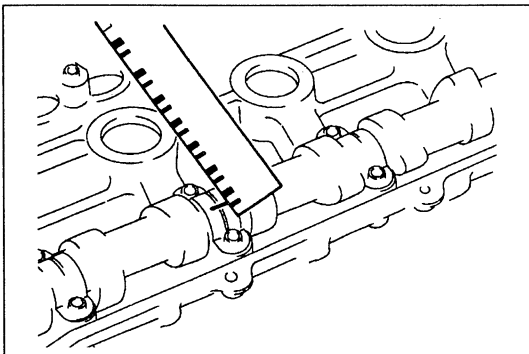
- (6) Measure the oil clearance.

**Oil clearance:**

0.035—0.081 mm { 0.0014—0.0031 in }

**Maximum:** 0.15 mm { 0.0059 in }

- (7) If the oil clearance exceeds the specification, replace the camshaft or the cylinder head.



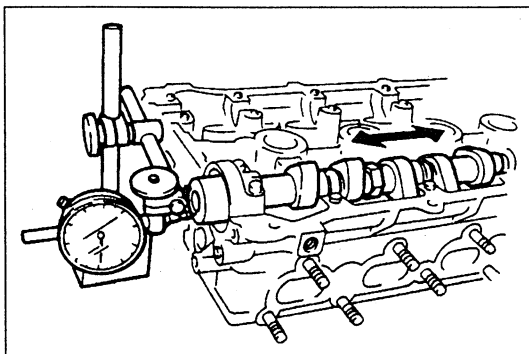
6. Install the front camshaft cap.
7. Measure the camshaft end play. If it exceeds the maximum, replace the cylinder head or camshaft.

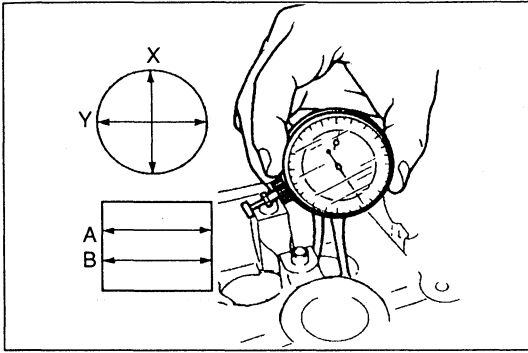
**End play**

**Standard:**

0.057—0.127 mm { 0.0023—0.0049 in }

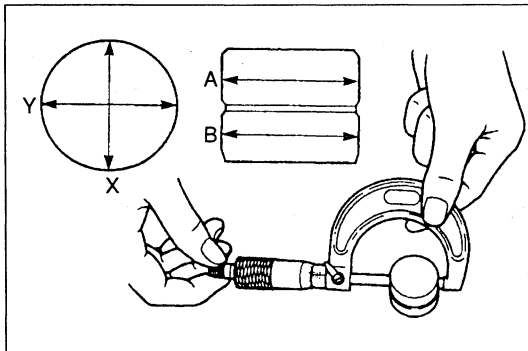
**Maximum:** 0.20 mm { 0.0079 in }



**HLA**

1. Measure the HLA hole inner diameter in X and Y directions at the two points (A and B) shown.

**Diameter: 30.000—30.025 mm { 1.1811—1.1820 in }**



2. Measure the HLA body outer diameters in X and Y directions at the two points (A and B) shown.

**Outer diameter:**

**29.959—29.975 mm { 1.1795—1.1801 in }**

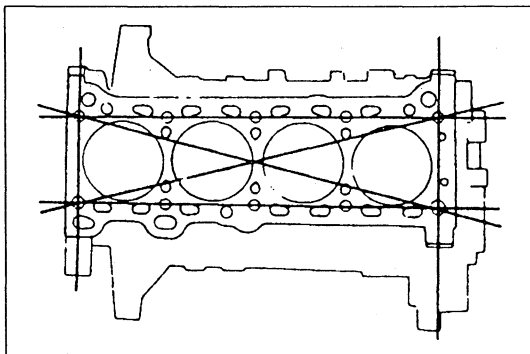
3. Subtract the HLA body outer diameter from the HLA hole inner diameter.

**Clearance**

**Standard: 0.025—0.066 mm { 0.0010—0.025 in }**

**Maximum: 0.180 mm { 0.0071 in }**

4. If the clearance exceeds the maximum, replace the HLA or cylinder head.

**CYLINDER BLOCK**

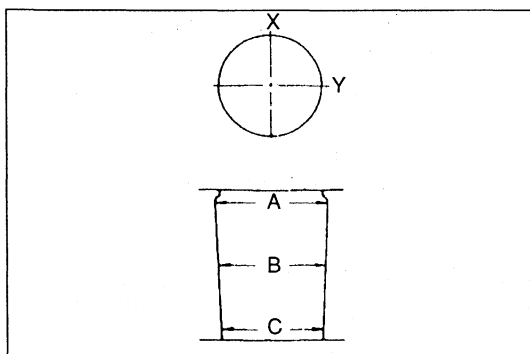
1. Measure the distortion of the cylinder block top surface in the six directions as shown in the figure.

**Distortion: 0.15 mm { 0.006 in } max.**

2. If the distortion exceeds the maximum, repair by grinding or replace the cylinder block. If the cylinder block height is not within the specification, replace it.

**Grinding: 0.20 mm { 0.008 in } max.**

**Height: 221.5 mm { 8.720 in }**



3. Measure the cylinder bores in X and Y directions at the three points (A, B, and C) in each cylinder as shown. If the difference between measurements A and C or measurements X and Y exceeds the wear limit, replace the cylinder block or rebore the cylinder to oversize.

**Note**

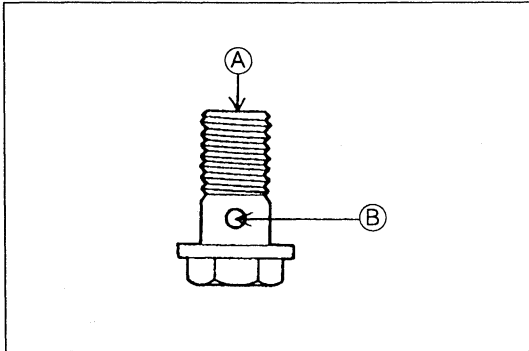
- The boring size should be based on the same size as an oversize piston and the same for all cylinders.

### Cylinder bore

mm { in }

	B6	BP
Standard	78.000—78.019 { 3.0709—3.0716 }	83.000—83.019 { 3.2678—3.2684 }
0.25 { 0.01 } oversize	78.250—78.269 { 3.0808—3.0814 }	83.250—83.269 { 3.2776—3.2783 }
0.50 { 0.02 } oversize	78.500—78.519 { 3.0906—3.0912 }	83.500—83.519 { 3.2874—3.2881 }

**Wear limit: 0.15 mm { 0.006 in }**



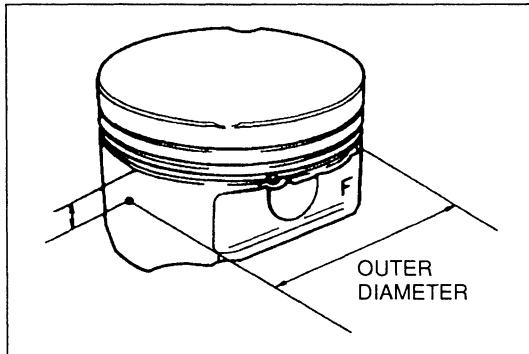
### OIL JET

1. Apply compressed air to oil jet valve (A) and verify that air passes through oil jet valve (B). If not, replace the oil jet valve.

### Air pressure:

**167—225 kPa { 1.7—2.3 kg/cm<sup>2</sup> , 25—32 psi }**

2. Check the oil jet nozzle for clogs. Replace the nozzle if necessary.



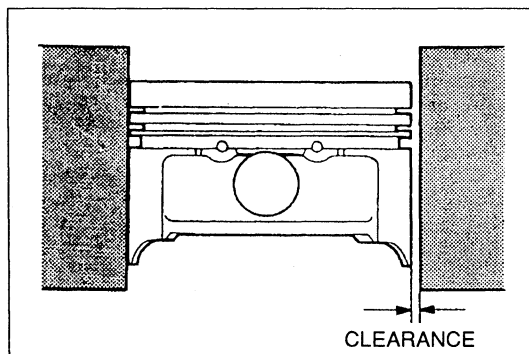
### PISTON, PISTON RING, AND PISTON PIN

1. Measure the outer diameter of each piston at a right angle (90 °) to the piston pin, **17.6 mm { 0.69 in } (B6)**, **16.5 mm { 0.65 in } (BP)** below the oil ring land lower edge.

### Piston diameter

mm { in }

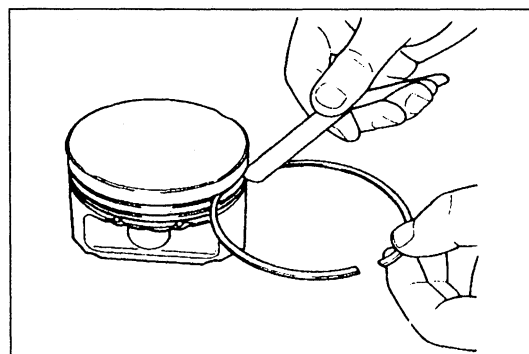
	B6	BP
Standard	77.954—77.974 { 3.0691—3.0698 }	82.954—82.974 { 3.2659—3.2666 }
0.25 { 0.01 } oversize	78.204—78.224 { 3.0789—3.0796 }	82.204—83.224 { 3.2758—3.2765 }
0.50 { 0.02 } oversize	78.454—78.474 { 3.0888—3.0895 }	83.454—83.474 { 3.2856—3.2863 }



2. Calculate the piston-to-cylinder clearance. Subtract the piston diameter from the cylinder bore of the corresponding cylinder.

**Clearance: 0.024—0.037 mm { 0.0010—0.0014 in }**

**Maximum: 0.15 mm { 0.006 in }**



3. If the clearance exceeds the maximum, replace the piston or rebores the cylinders to fit oversize pistons.
4. If the piston is replaced, the piston rings must also be replaced.
5. Measure the piston ring-to-ring land clearance around the entire circumference using a new piston ring.

### Clearance

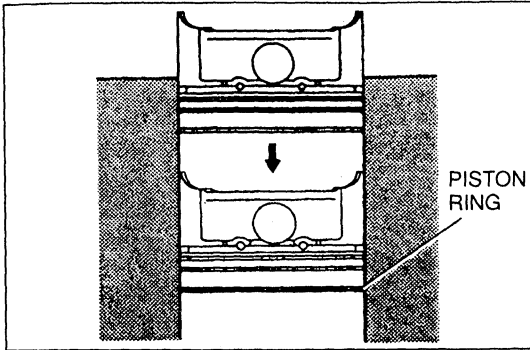
**Top: 0.030—0.065 mm { 0.0012—0.0026 in }**

**Second: 0.030—0.070 mm { 0.0012—0.0027 in }**

**Oil: 0.07—0.16 mm { 0.003—0.006 in }**

**Maximum: 0.15 mm { 0.006 in }**





6. If the clearance exceeds the maximum, replace the piston and piston ring.
7. Insert the piston ring into the cylinder by hand and use the piston to push it to the bottom of the ring travel.
8. Measure each piston ring end gap with a feeler gauge. Replace the piston ring if necessary.

**End gap**

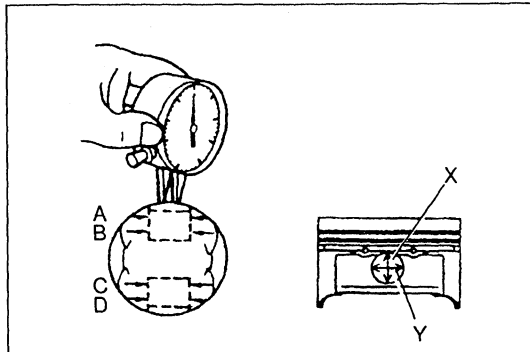
**Top:** 0.15—0.30 mm { 0.006—0.011 in }

**Second:** 0.30—0.45 mm { 0.012—0.017 in } (B6)

0.15—0.30 mm { 0.006—0.011 in } (BP)

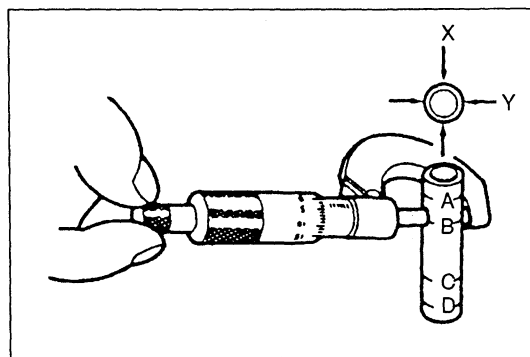
**Oil rail:** 0.20—0.70 mm { 0.008—0.027 in }

**Maximum:** 1.0 mm { 0.039 in }



9. Measure each piston pin hole diameter in X and Y direction at the four points (A, B, C, and D) as shown.

**Diameter:** 19.988—20.000 mm { 0.7870—0.7874 in }



10. Measure each piston pin diameter in X and Y directions at the four points (A, B, C, and D) as shown.

**Diameter:** 19.987—19.993 mm { 0.7869—0.7871 in }

11. Calculate the piston pin-to-piston pin bore clearance.

**Clearance:**

—0.005—0.013 mm { —0.0001—0.0005 in }

12. If the clearance exceeds the specification, replace the piston and/or piston pin.

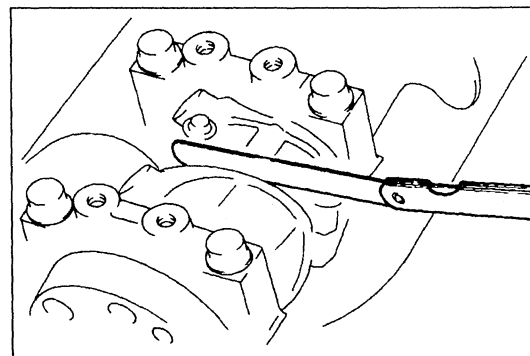
**CONNECTING ROD**

1. Measure the connecting rod large end side clearance.

**Clearance:** 0.110—0.262 mm { 0.0044—0.0103 in }

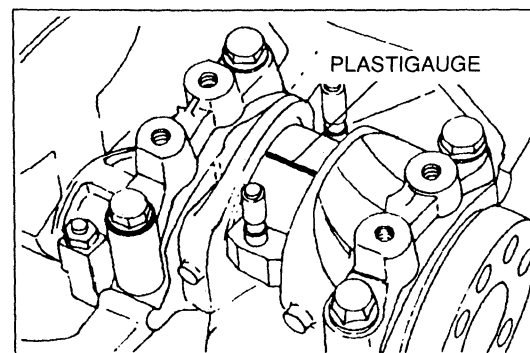
**Maximum:** 0.3 mm { 0.0118 in }

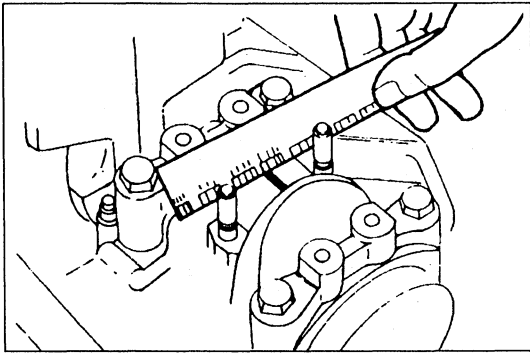
2. If the clearance exceeds the maximum, replace the connecting rod and cap assembly.



3. Measure the connecting rod large end oil clearances as follows.

- (1) Position plastigauge atop the crankshaft in the axial direction.
- (2) Install the connecting rod caps and tighten the connecting rod cap nuts. (Refer to page B-24.)
- (3) Remove the connecting rod cap nuts and connecting rod cap.
- (4) Measure the plastigauge at each crank pin.





**Oil clearance:**

**0.028—0.048 mm { 0.0012—0.0018 in } (B6)**

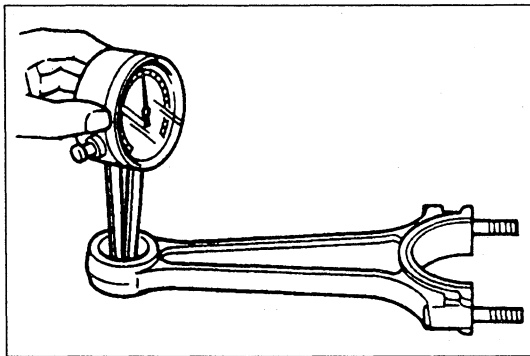
**0.020—0.044 mm { 0.0008—0.0017 in } (BP)**

**Maximum: 0.10 mm { 0.0039 in }**

- (5) If the oil clearance exceeds the maximum, replace the connecting rod bearing or grind the crank pin and use undersize bearings.

mm { in }

Bearing	Crank pin
Standard	44.940—44.956 { 1.7693—1.7699 }
0.25 { 0.01 } undersize	44.690—44.706 { 1.7595—1.7600 }
0.50 { 0.02 } undersize	44.440—44.456 { 1.7497—1.7502 }
0.75 { 0.03 } undersize	44.190—44.206 { 1.7398—1.7403 }

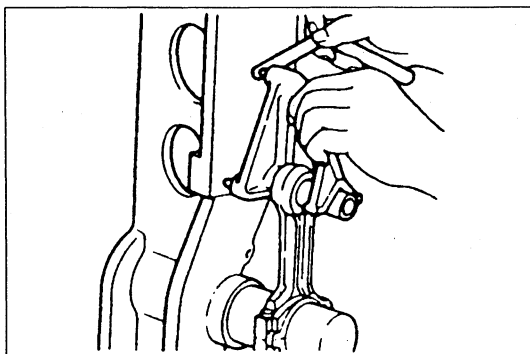


4. Measure each connecting rod bushing inner diameter.

**Diameter: 20.003—20.014 mm { 0.7876—0.7879 in }**

5. Calculate the connecting rod bushing-to-piston pin clearance. If the clearance is not as specified, replace the connecting rod or piston pin.

**Clearance: 0.010—0.027 mm { 0.0004—0.0010 in }**



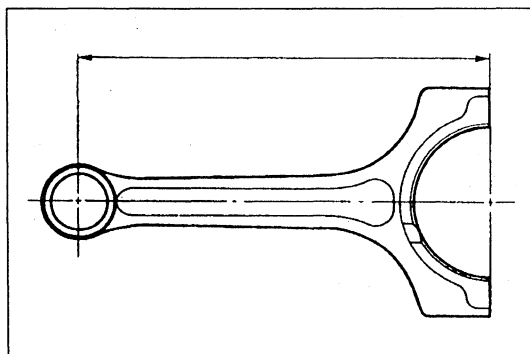
6. Measure each connecting rod for bending. Repair or replace the connecting rod if necessary.

**Bending:**

**0.075 mm { 0.0030 in } max./50 mm { 1.97 in }**

**Distortion:**

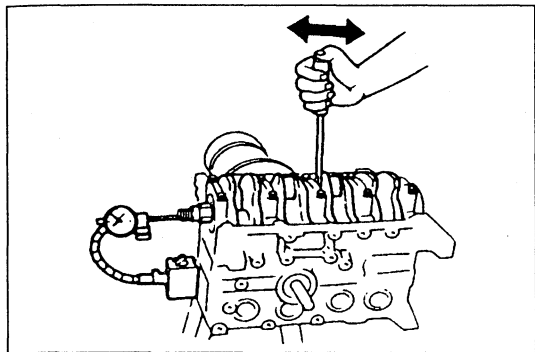
**0.180 mm { 0.0071 in } max./50 mm { 1.97 in }**



**Center-to-center distance:**

**132.85—132.95 mm { 5.2304—5.2342 in }**

7. If the connecting rod is replaced, the connecting rod cap must also be replaced because they are machined together.

**CRANKSHAFT**

1. Measure the crankshaft end play.

**End play: 0.080—0.282 mm { 0.0032—0.0111 in }**

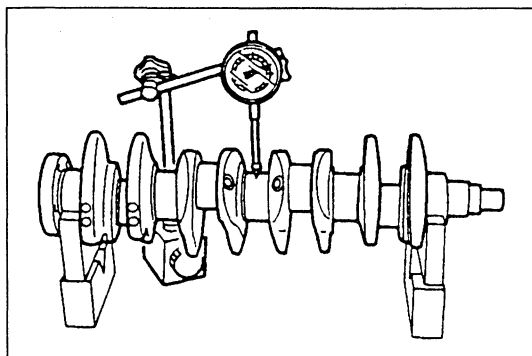
**Maximum: 0.3 mm { 0.01 in }**

2. If the end play exceeds the maximum, replace the thrust bearing or grind the crankshaft and install an oversize thrust bearing.

**Journal width**

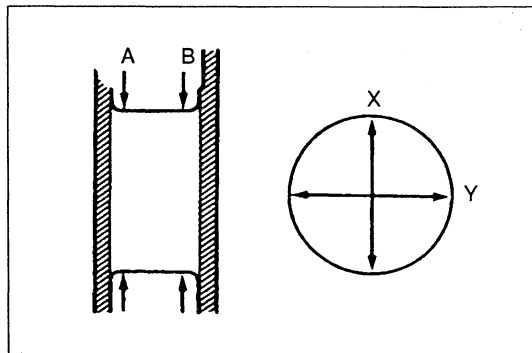
mm { in }

Bearing	No.4 journal width
Standard	24.07—24.12 { 0.948—0.949 }
0.25 { 0.01 } oversize	24.32—24.37 { 0.958—0.959 }
0.50 { 0.02 } oversize	24.57—24.62 { 0.968—0.969 }
0.75 { 0.03 } oversize	24.82—24.87 { 0.978—0.979 }



3. Set the crankshaft No.1 and No.5 main journals on V-blocks.
4. Measure the crankshaft runout at the No.3 main journals. Replace the crankshaft if necessary.

**Runout: 0.04 mm { 0.0016 in } max.**



5. Measure journal diameter in X and Y directions at two points (A and B) as shown.

**Main journal**

**Diameter:**

**49.938—49.956 mm { 1.9661—1.9667 in }**

**Minimum: 49.904 mm { 1.9647 in }**

**Out-of-round: 0.05 mm { 0.0020 in } max.**

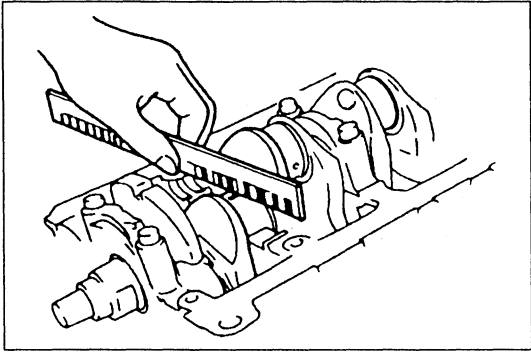
**Crank pin journal**

**Diameter:**

**44.940—44.956 mm { 1.7693—1.7699 in }**

**Minimum: 44.908 mm { 1.7680 in }**

**Out-of-round: 0.05 mm { 0.0020 in } max.**



6. If the diameter exceeds the maximum, grind the journal and install the undersize bearing.
7. Measure the main journal oil clearances as follows.
  - (1) Position plastigauge atop the crankshaft in the axial direction.
  - (2) Install the main bearing cap and tighten the main bearing cap bolts. (Refer to page B-24.)
  - (3) Remove the main bearing cap bolts and main bearing caps. (Refer to page B-23.)
  - (4) Measure the plastigauge at each journal.

**Oil clearance:**

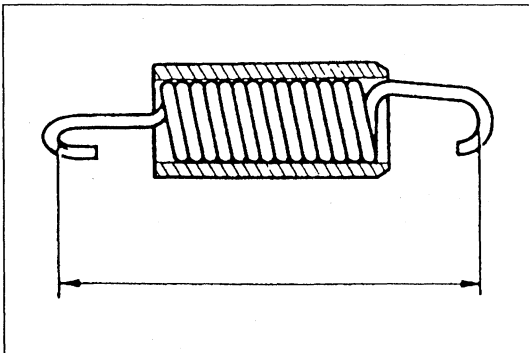
**0.018—0.036 mm { 0.0008—0.0014 in }**

**Maximum: 0.1 mm { 0.004 in }**

- (5) If the oil clearance exceeds the maximum, replace the connecting rod bearing or grind the main journal and use undersize bearings.

mm { in }

Bearing	Main journal
Standard	49.938—49.956 { 1.9661—1.9667 }
0.25 { 0.01 } undersize	49.688—49.706 { 1.9563—1.9569 }
0.50 { 0.02 } undersize	49.438—49.456 { 1.9464—1.9470 }
0.75 { 0.03 } undersize	49.188—49.206 { 1.9366—1.9372 }



**TENSIONER SPRING**

Measure the free length of the tensioner spring. Replace the tensioner spring if necessary.

**Free length: 59.2 mm { 2.33 in }**

# LUBRICATION SYSTEM

OIL PUMP ..... D-2  
DISASSEMBLY / INSPECTION / ASSEMBLY .... D-2

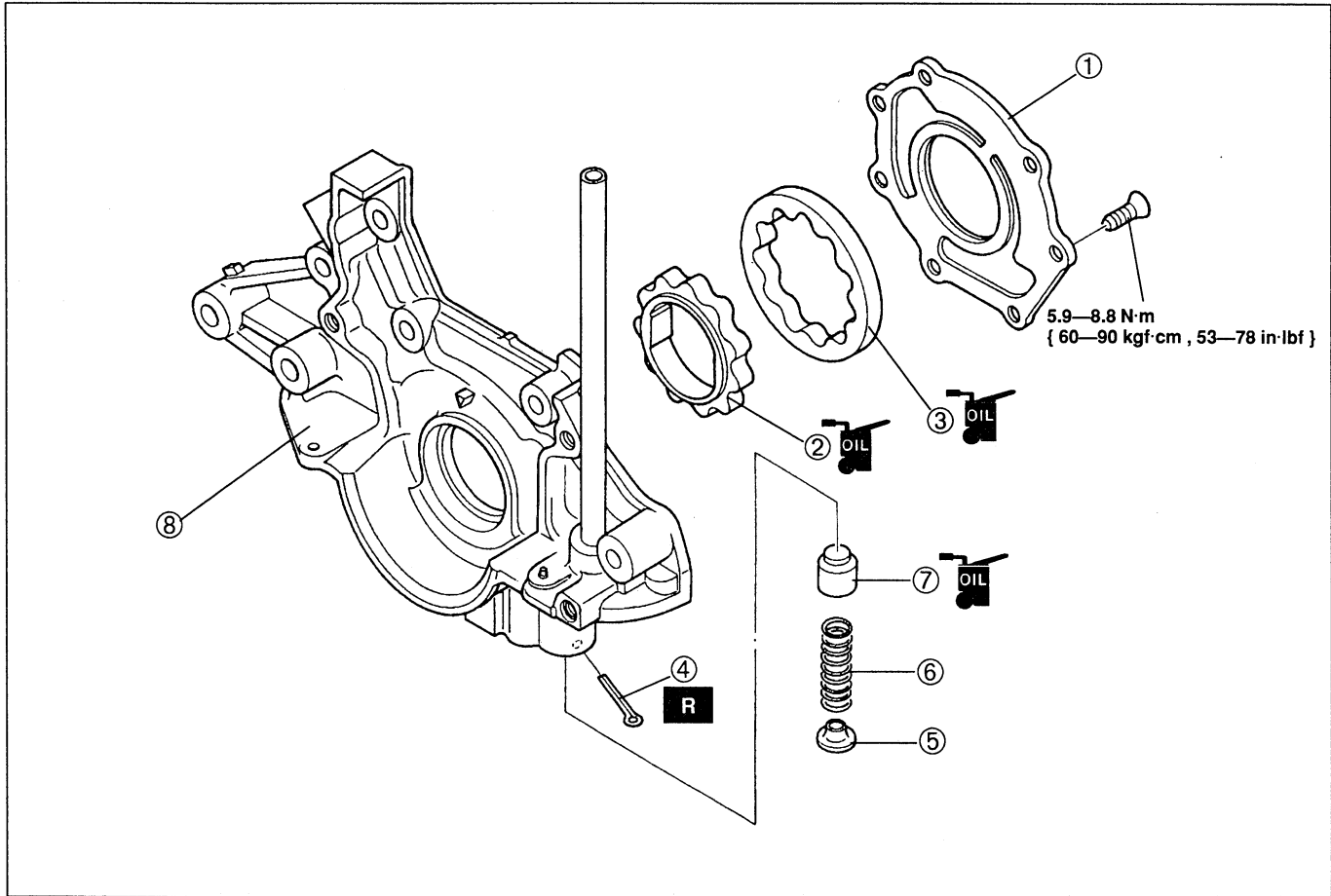
OIL PUMP

DISASSEMBLY / INSPECTION / ASSEMBLY

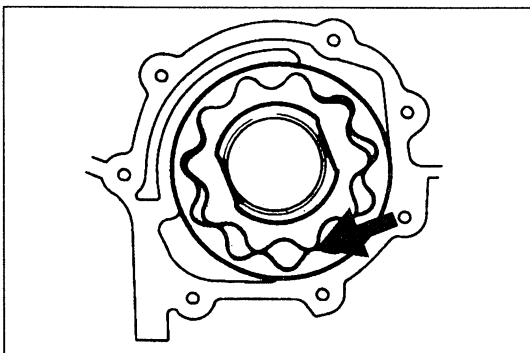
Warning

- Continuous exposure with USED engine oil has caused skin cancer in laboratory mice. Protect your skin by washing with soap and water immediately after this work.

1. Disassemble in the order shown in the figure.
2. Assemble in the reverse order of disassembly, referring to **Assembly Note**.



- |                              |                           |
|------------------------------|---------------------------|
| 1. Oil pump cover            | 5. Spring seat            |
| 2. Inner rotor               | 6. Pressure spring        |
| Inspection ..... below       | Inspection ..... page D-3 |
| 3. Outer rotor               | 7. Control plunger        |
| Inspection ..... below       | 8. Oil pump body          |
| 4. Cotter pin                | Inspection ..... below    |
| Assembly Note ..... page D-3 |                           |



**Inspection**

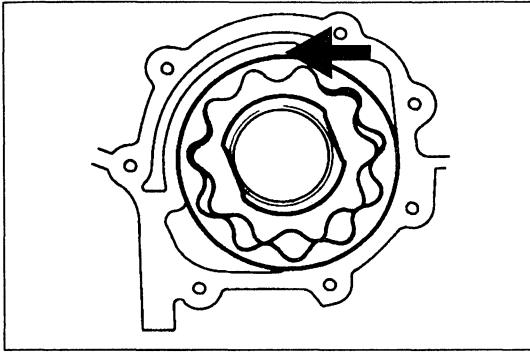
**Inner rotor, outer rotor, and oil pump body**

Measure the following clearances. Replace the rotor or oil pump body if necessary.

**Tooth tip clearance:**

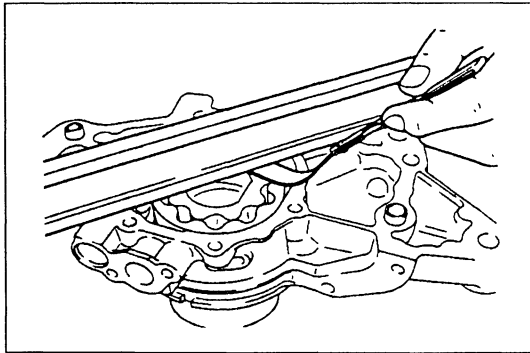
0.02—0.16 mm { 0.0008—0.0062 in }

**Maximum: 0.20 mm { 0.0079 in }**

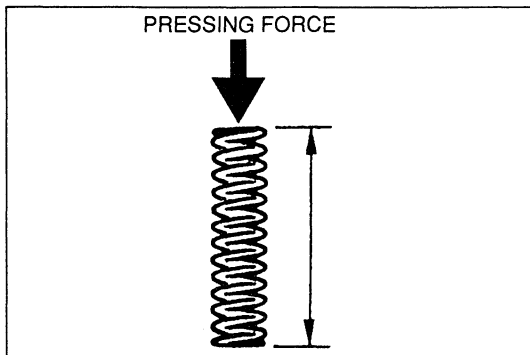


**Outer rotor-to-oil pump body clearance:**  
 0.090—0.180 mm { 0.0036—0.0070 in }  
 Maximum: 0.22 mm { 0.0087 in }

D



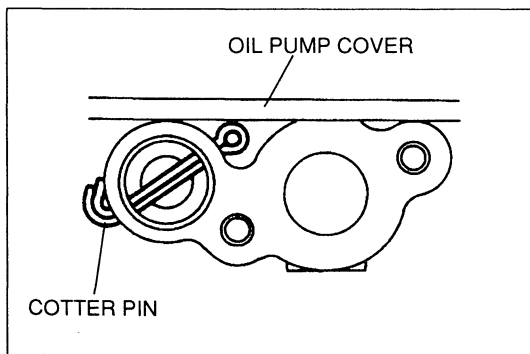
**Side clearance:** 0.03—0.11 mm { 0.0012—0.0043 in }  
 Maximum: 0.14 mm { 0.0055 in }



#### Pressure spring

Apply pressing force to the pressure spring and check the spring height.

**Pressing force:**  
 62.8—68.6 N { 6.4—7.0 kgf , 14.1—15.4 lbf }  
**Height:** 35.42 mm { 1.394 in }



#### Assembly Note

##### Cotter pin

Bend the cotter pin so that its tip does not project from the oil pump cover mounting surface.







