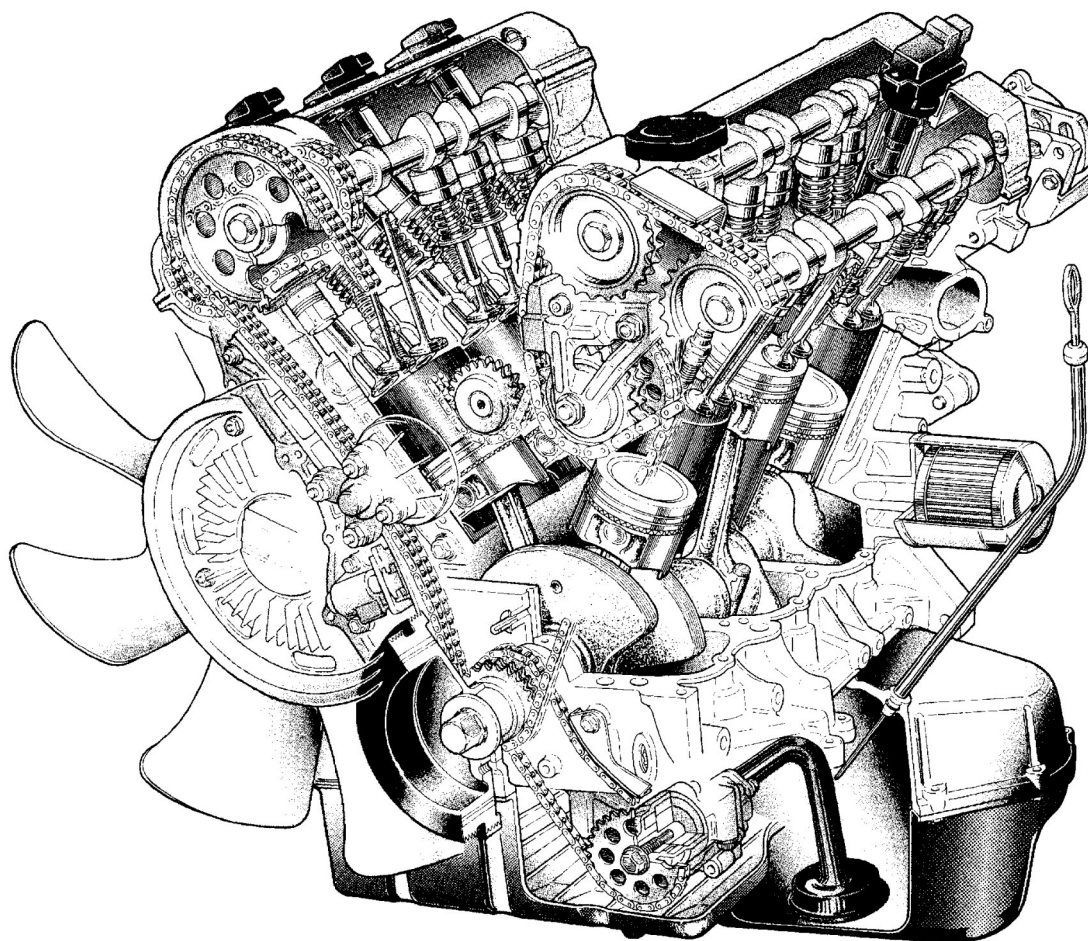


2004 ENGINES**2.5L V6****GENERAL DESCRIPTION****ENGINE GENERAL INFORMATION**

The engine is a water-cooled, 60° V6 cylinders, 4 stroke cycle gasoline unit with its DOHC (Double overhead camshaft) valve mechanism arranged for "V" type valve configuration. The double overhead camshaft is mounted over the cylinder head; it is driven from crankshaft through timing chains, and no push rods are provided in the valve train system.



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Fig. 1: Cutaway View Of Engine
Courtesy of SUZUKI OF AMERICA CORP.

AIR CLEANER ELEMENT INTRODUCTION

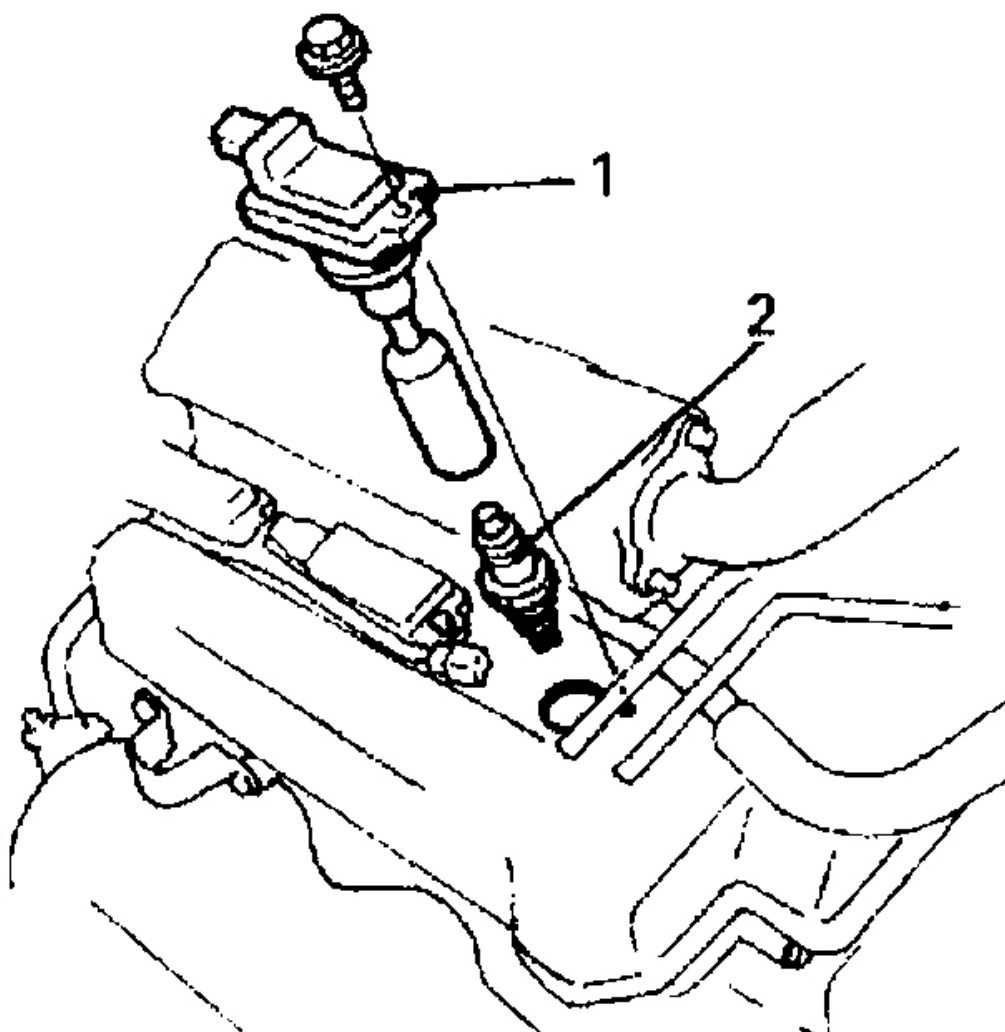
This air cleaner element is of dry type. Note that if it needs cleaning, refer to **AIR CLEANER ELEMENT INSPECTION & CLEANING** .

DIAGNOSTIC INFORMATION & PROCEDURES

COMPRESSION CHECK

Check compression pressure on all 6 cylinders as follows:

1. Warm up engine.
2. Stop engine after warming up.
3. Remove ignition coil covers and disconnect ignition coil harness couplers.
4. Remove all ignition coils (1) and spark plugs (2) referring to **SPARK PLUG REMOVAL & INSTALLATION** .



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Fig. 2: Removing All Ignition Coils & Spark Plugs
Courtesy of SUZUKI OF AMERICA CORP.

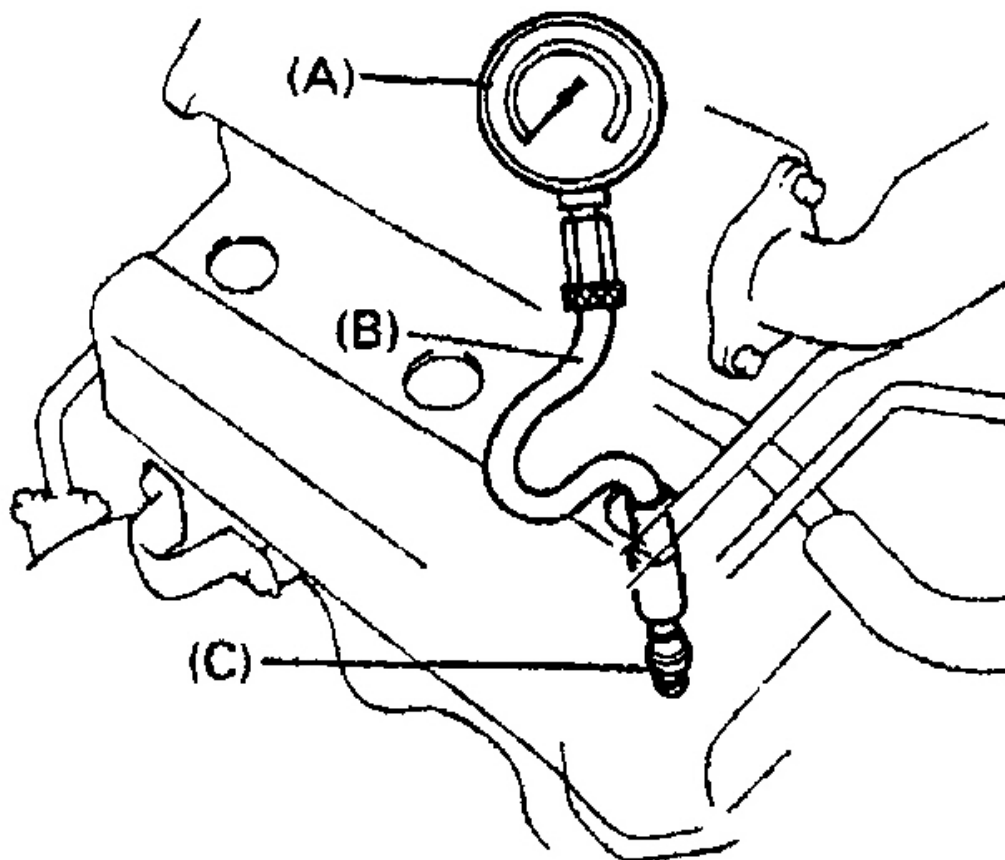
5. Remove surge tank cover.
6. Disconnect fuel injector wire harness at connector.
7. Install special tool (Compression gauge) into spark plug hole.

Special tool

(A): 09915-64510

(B): 09915-64530

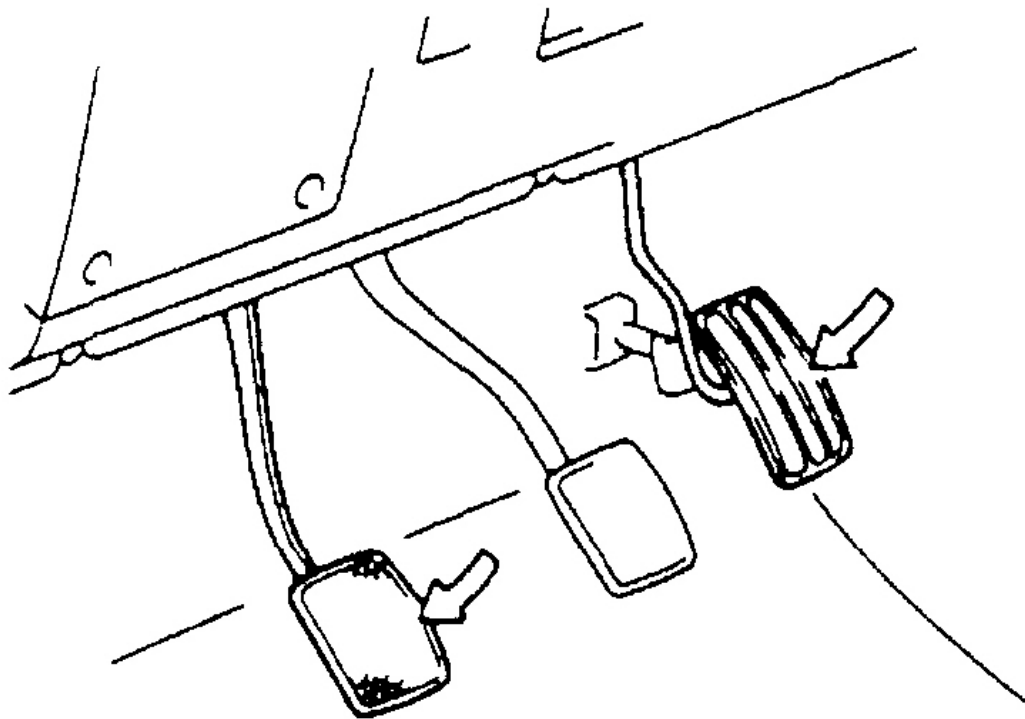
(C): 09915-67010



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Fig. 3: Installing Compression Gauge Into Spark Plug Hole
Courtesy of SUZUKI OF AMERICA CORP.

8. Disengage clutch (to lighten starting load on engine) for M/T vehicle, and depress accelerator pedal all the way to make throttle fully open.



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Fig. 4: Disengaging Clutch (M/T Vehicle) & Depressing Accelerator Pedal
Courtesy of SUZUKI OF AMERICA CORP.

9. Crank engine with fully charged battery, and read the highest pressure on compression gauge.

NOTE: For measuring compression pressure, crank engine at least 250 rpm by using fully charged battery.

Compression pressure

Standard: 1400 - 1600 kPa (14.0 - 16.0 kg/cm² , 199.0 - 227.5 psi)

Limit: 1300 kPa (13.0 kg/cm² , 185.0 psi)

Max. difference between any two cylinders: 100 kPa (1.0 kg/cm² , 14.2 psi)

10. Carry out steps 7 , 8 and 9 on each cylinder to obtain 6 readings.

ENGINE VACUUM CHECK

The engine vacuum that develops in the intake line is a good indicator of the condition of the engine. The vacuum checking procedure is as follows:

1. Warm up engine to normal operating temperature and make sure that engine idle speed is within specification.
2. Stop engine and disconnect vacuum hoses from fuel pressure regulator valve (1).
3. Connect special tools (Vacuum gauge and hose joint) and 3-way joint between vacuum hose and valve.

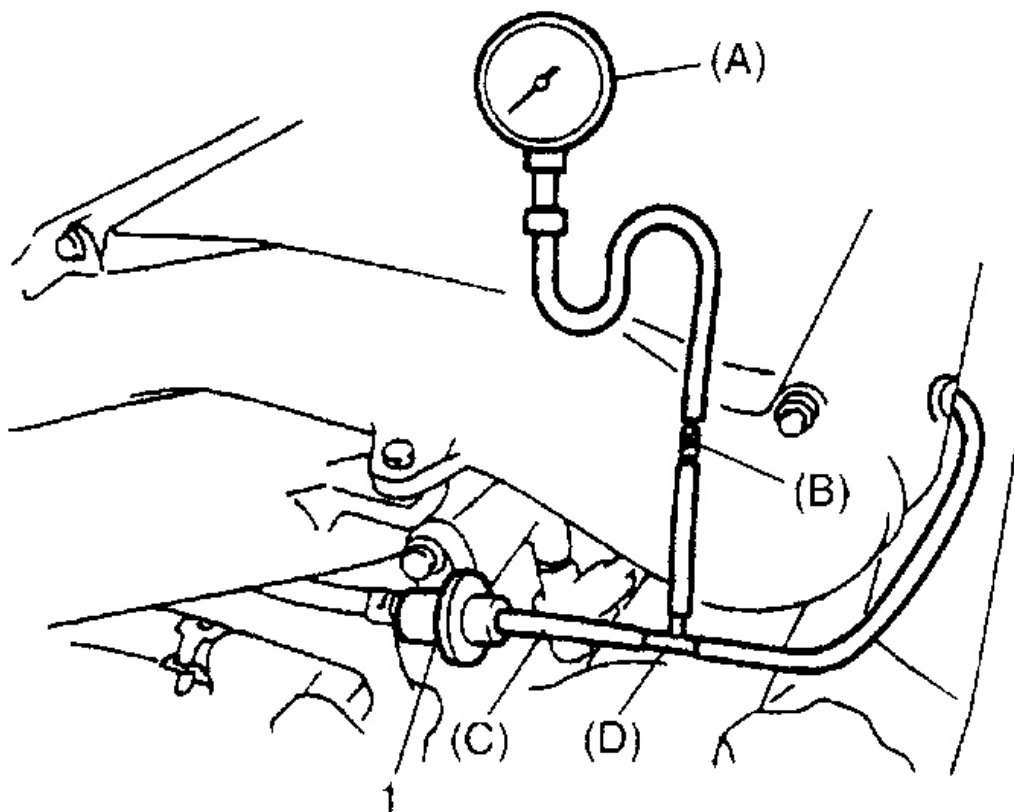
Special tool

(A): 09915-67311

(B): 09918-08210

(C): 09355-35754-600 (Hose, SUZUKI genuine parts)

(D): 09367-04002 (3-way joint, SUZUKI genuine parts)



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Fig. 5: Connecting Special Tools

Courtesy of SUZUKI OF AMERICA CORP.

4. Start engine and run engine at specified idle speed, and read vacuum gauge. Vacuum should be within specification.

Vacuum specifications (sea level): 59 - 79 kPa (450 - 600 mmHg, 17.7 - 23.7 in.Hg) at specified idle speed

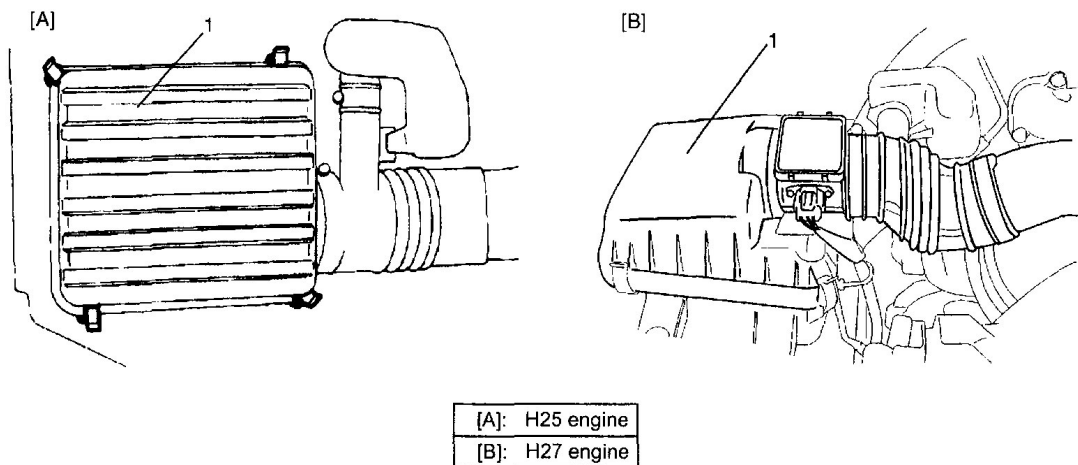
5. After checking, remove, all special tools.
6. Connect vacuum hoses to fuel pressure regulator valve.

REPAIR INSTRUCTIONS

AIR CLEANER ELEMENT REMOVAL & INSTALLATION

Removal

1. Remove air cleaner upper case (1).



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Fig. 6: Removing Air Cleaner Upper Case
Courtesy of SUZUKI OF AMERICA CORP.

2. Remove air cleaner element.

Installation

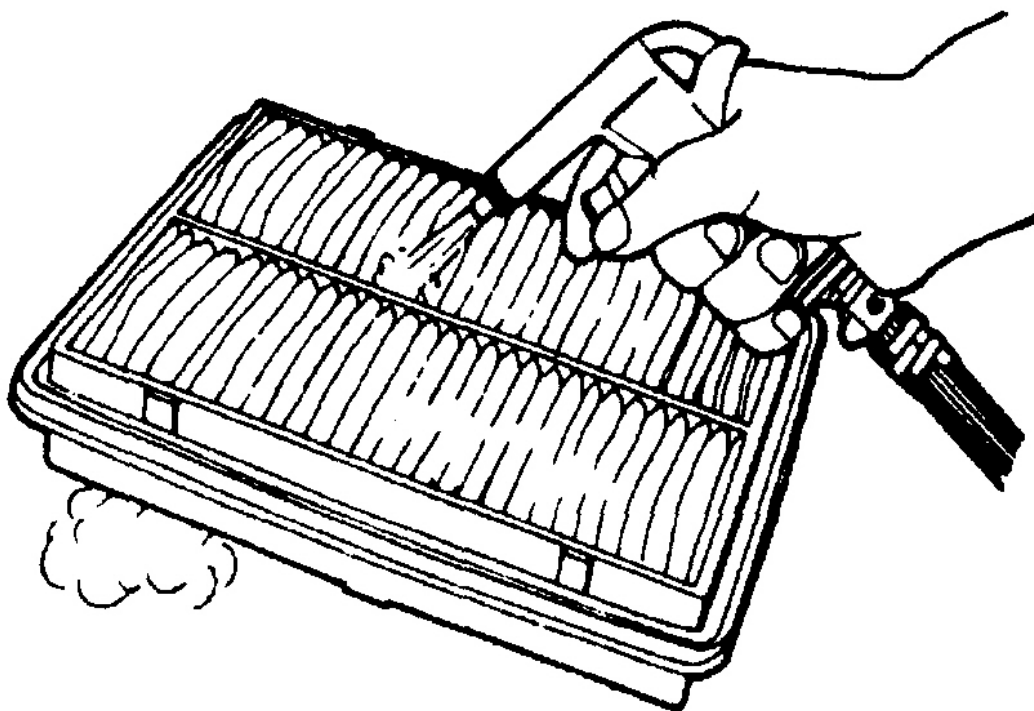
1. Install element to air cleaner box.
2. Install air cleaner upper case.

AIR CLEANER ELEMENT INSPECTION & CLEANING**Inspection**

Check element for dirt. Replace if element is excessively dirty.

Cleaning

When cleaning element, blow off dust by blowing compressed air from air outlet side of element (i.e., the side facing up when installed in air cleaner case).



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Fig. 7: Blowing Off Dust Using Compressed Air
Courtesy of SUZUKI OF AMERICA CORP.

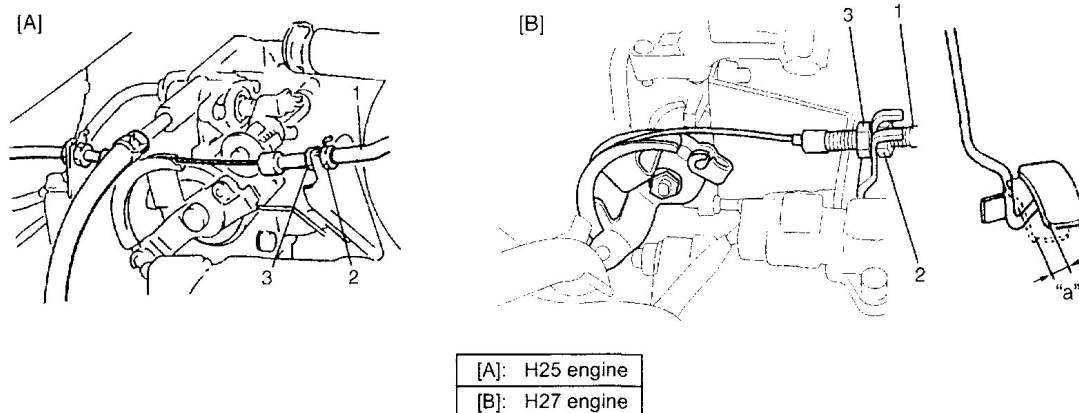
ACCELERATOR CABLE ADJUSTMENT

1. Warm up engine to normal operating temperature.
2. Check to make sure that fast idle control cam is off cam follower lever. If not, check fast idle control system referring to **THROTTLE BODY REMOVAL & INSTALLATION (H25 ENGINE)** .
3. With throttle valve closed, check accelerator pedal play "a" which should be within the following specification.

If measured value is out of specification, adjust accelerator cable (1) so as pedal play to be within specification with cable adjusting nut (2). Then tighten lock nut (3).

Accelerator pedal play

"a": 2 - 5 mm (0.08 - 0.20 in.)



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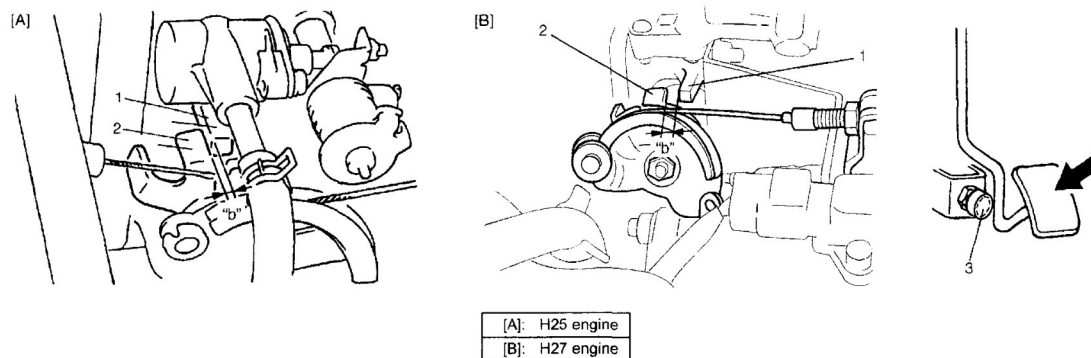
Fig. 8: Adjusting Accelerator Cable
Courtesy of SUZUKI OF AMERICA CORP.

- With accelerator pedal depressed fully, check clearance between throttle lever (2) and lever stopper (1) (throttle body) which should be within the following specification.

If measured value is out of specification, adjust it to specification by changing height of pedal stopper bolt (3).

Clearance between throttle lever and lever stopper (throttle body) (with accelerator pedal depressed fully)

"b": 0.5 - 2.0 mm (0.02 - 0.08 in.)



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Fig. 9: Checking Clearance Between Throttle Lever & Lever Stopper
Courtesy of SUZUKI OF AMERICA CORP.

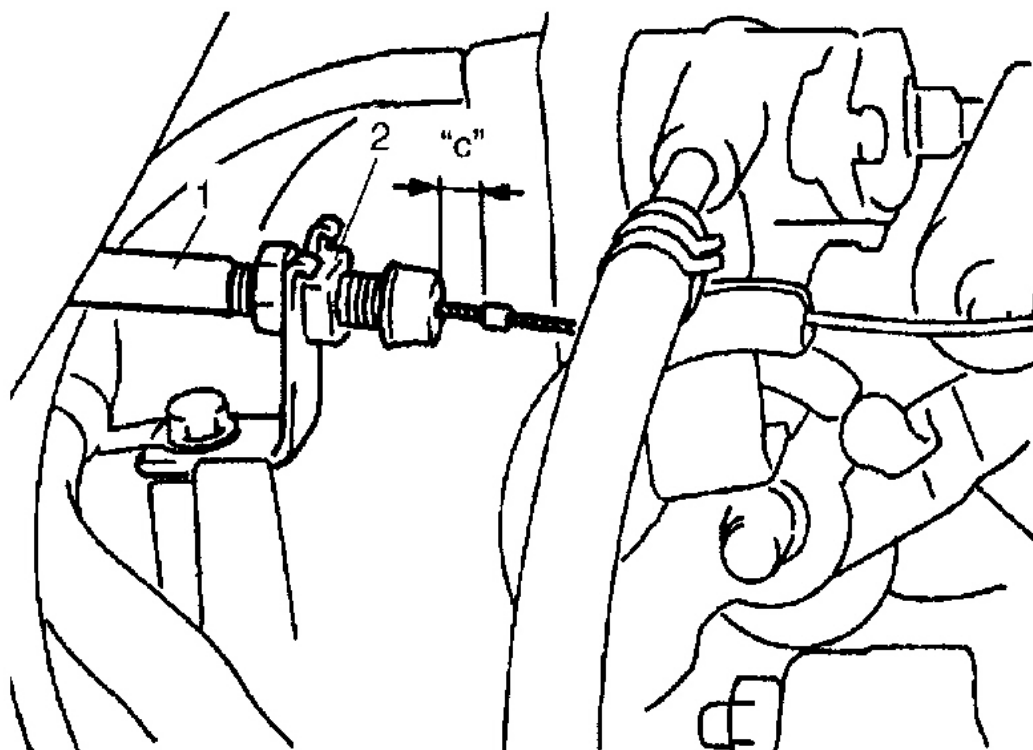
A/T THROTTLE CABLE ADJUSTMENT (H25 ENGINE WITH A/T ONLY)

1. Make sure that accelerator cable is adjusted as specified.
2. With throttle valve closed, check clearance "c" which should be within the following specification.

If it is out of specification, adjust A/T throttle cable (1) by turning cable adjusting nut (2).

A/T throttle cable adjustment clearance

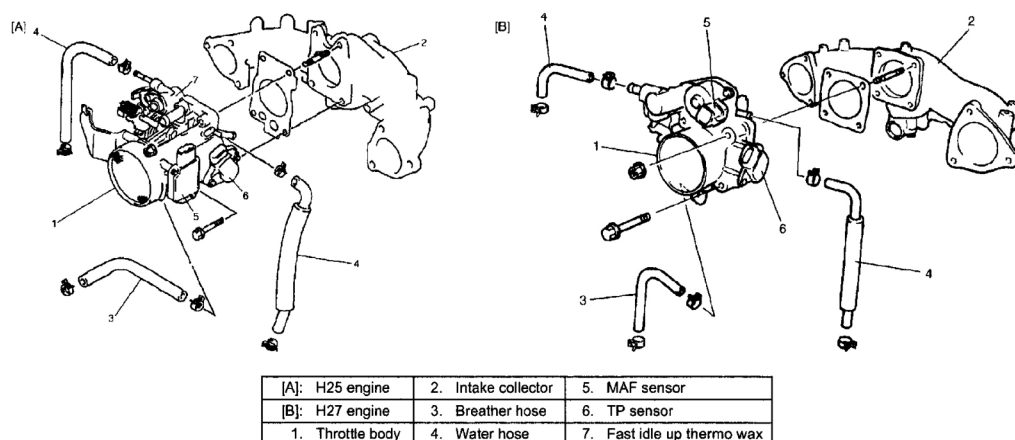
"c": 0.8 - 1.5 mm (0.03 - 0.06 in.)



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Fig. 10: Adjusting A/T Throttle Cable
Courtesy of SUZUKI OF AMERICA CORP.

THROTTLE BODY COMPONENTS



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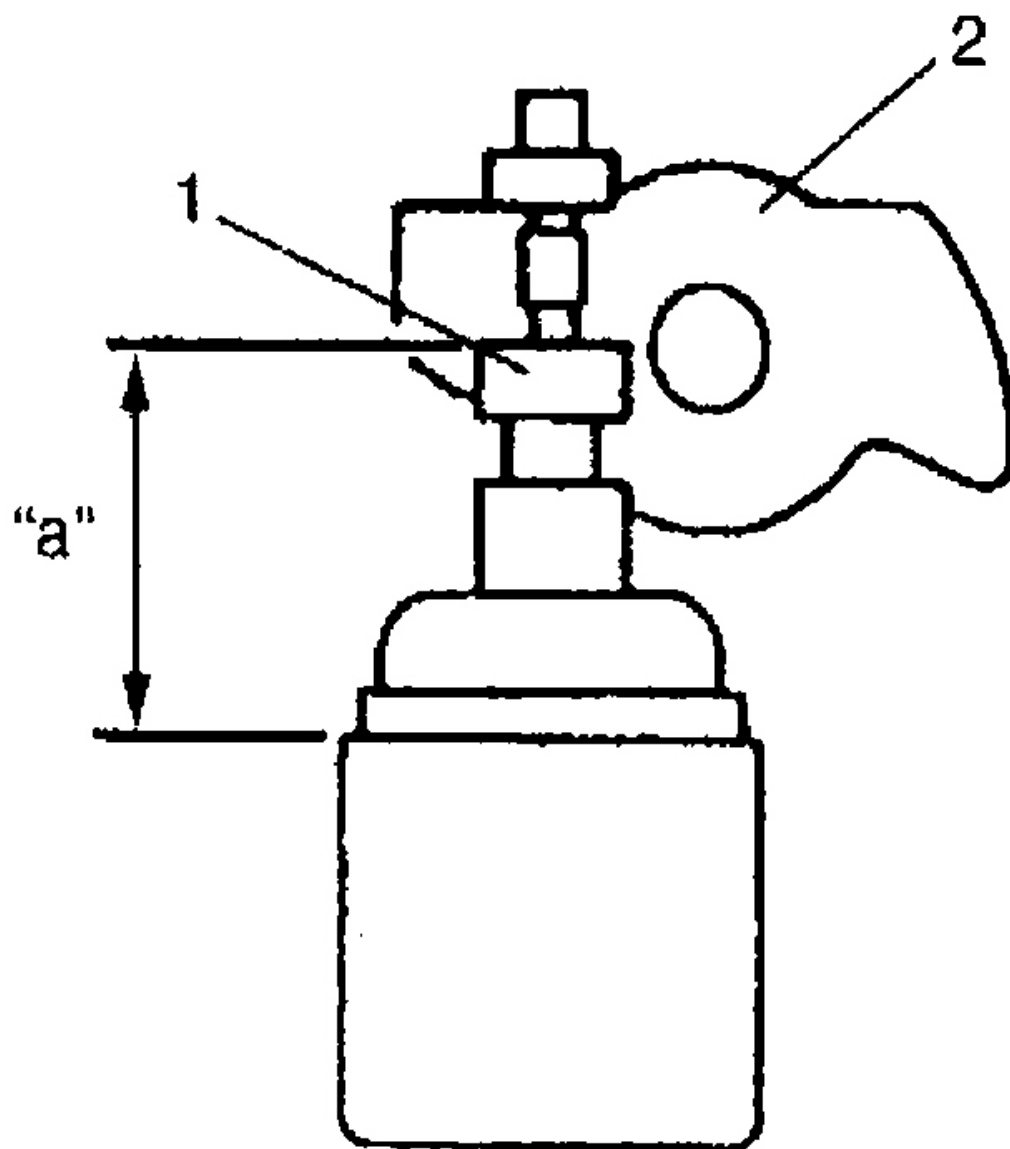
Fig. 11: Exploded View Of Throttle Body Components
Courtesy of SUZUKI OF AMERICA CORP.

Throttle Body On-Vehicle Inspection

1. Check that throttle valve lever moves smoothly.
2. Perform the following checks.
 - A. Measure plunger (1) protrusion "a" of fast idle control arm (2) at engine coolant temperature is 25°C (77°F).

Plunger protrusion

"a": 26.6 - 27.4 mm (1.047 - 1.079 in.)



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Fig. 12: Measuring Plunger Protrusion
Courtesy of SUZUKI OF AMERICA CORP.

- B. Warm up engine and check to make sure that fast control cam is off cam follower lever (1) at engine coolant temp. is 52 - 68°C (126 - 154°F).

If check result in Step [A](#) or B is out of specification, replace throttle body assembly referring to

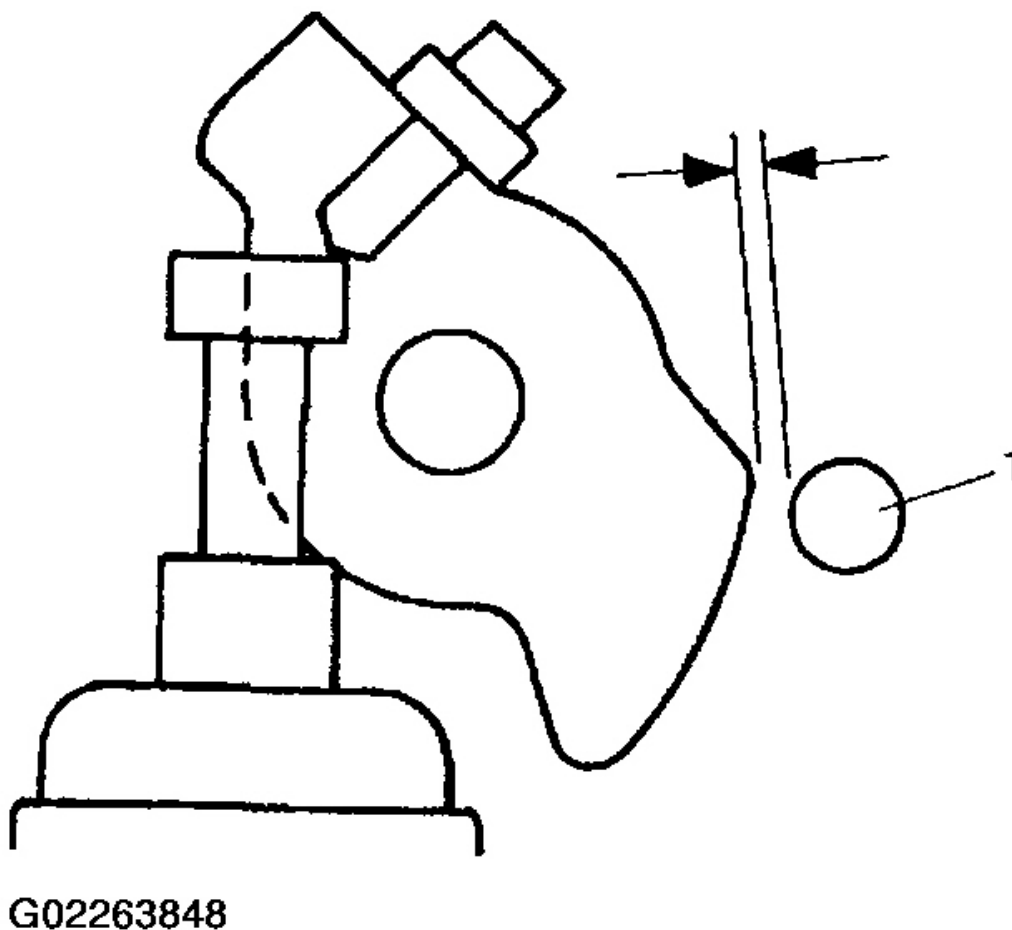
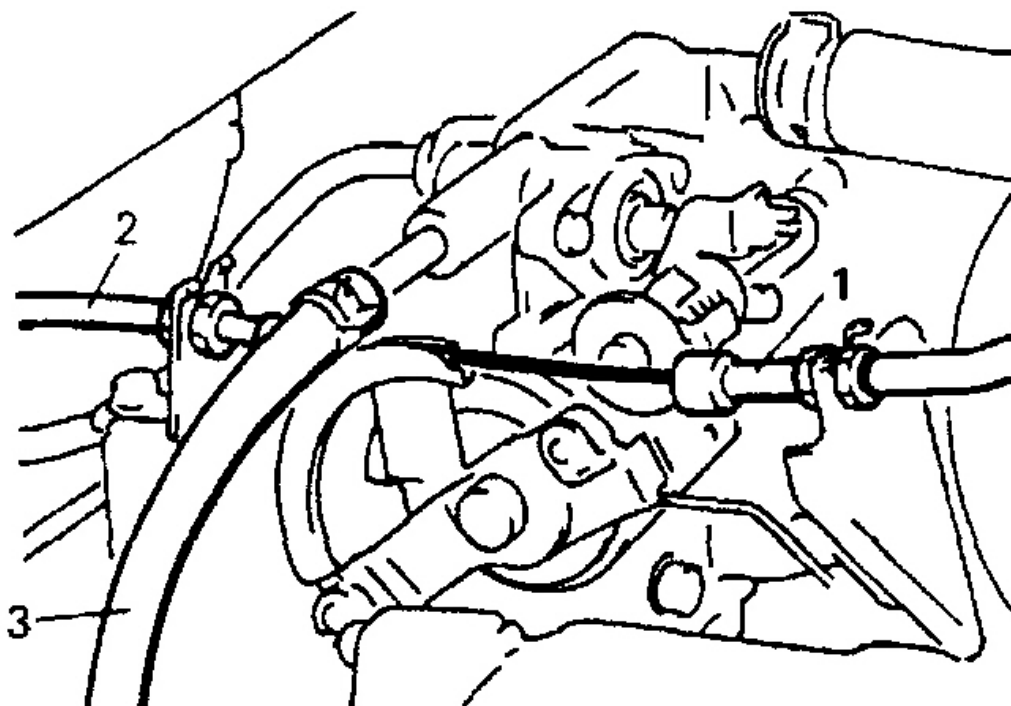
THROTTLE BODY REMOVAL & INSTALLATION (H25 ENGINE) .

Fig. 13: Checking To Make Sure That Fast Control Cam Is Off Cam Follower Lever
Courtesy of SUZUKI OF AMERICA CORP.

THROTTLE BODY REMOVAL & INSTALLATION (H25 ENGINE)**Removal**

1. Disconnect negative cable (-) at battery.
2. Drain engine coolant referring to **COOLANT DRAINING** .
3. Detach fuse/relay box.
4. Remove strut tower bar.
5. Disconnect accelerator cable (1) and A/T throttle cable (2) (for A/T model) from throttle body.

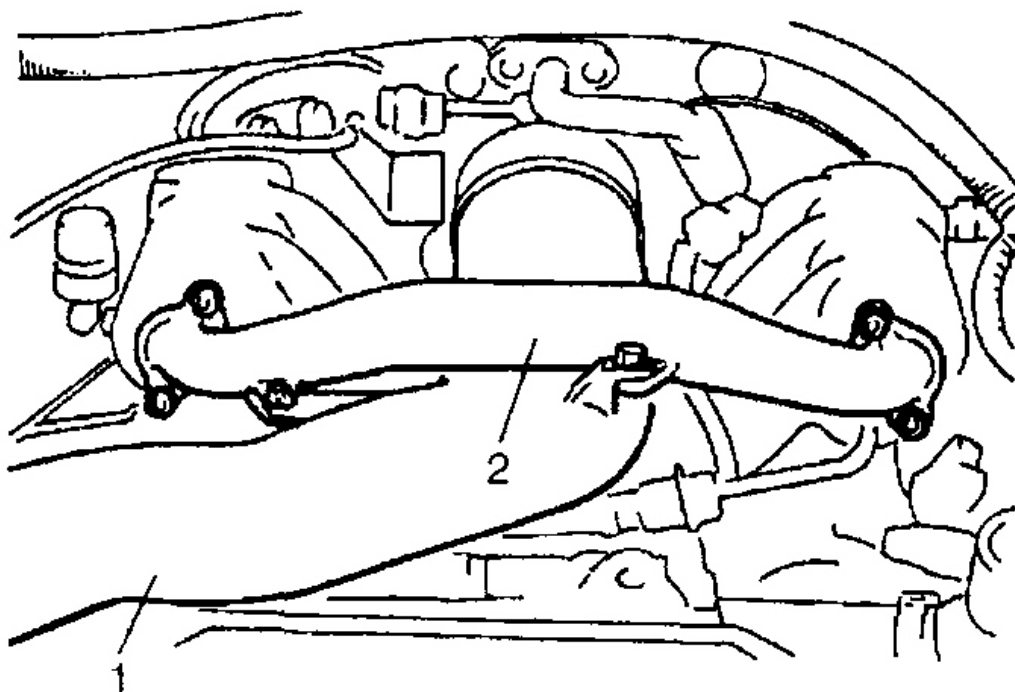
6. Disconnect water hose (3) from throttle body.



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Fig. 14: Identifying Accelerator Cable, A/T Throttle Cable & Water Hose
Courtesy of SUZUKI OF AMERICA CORP.

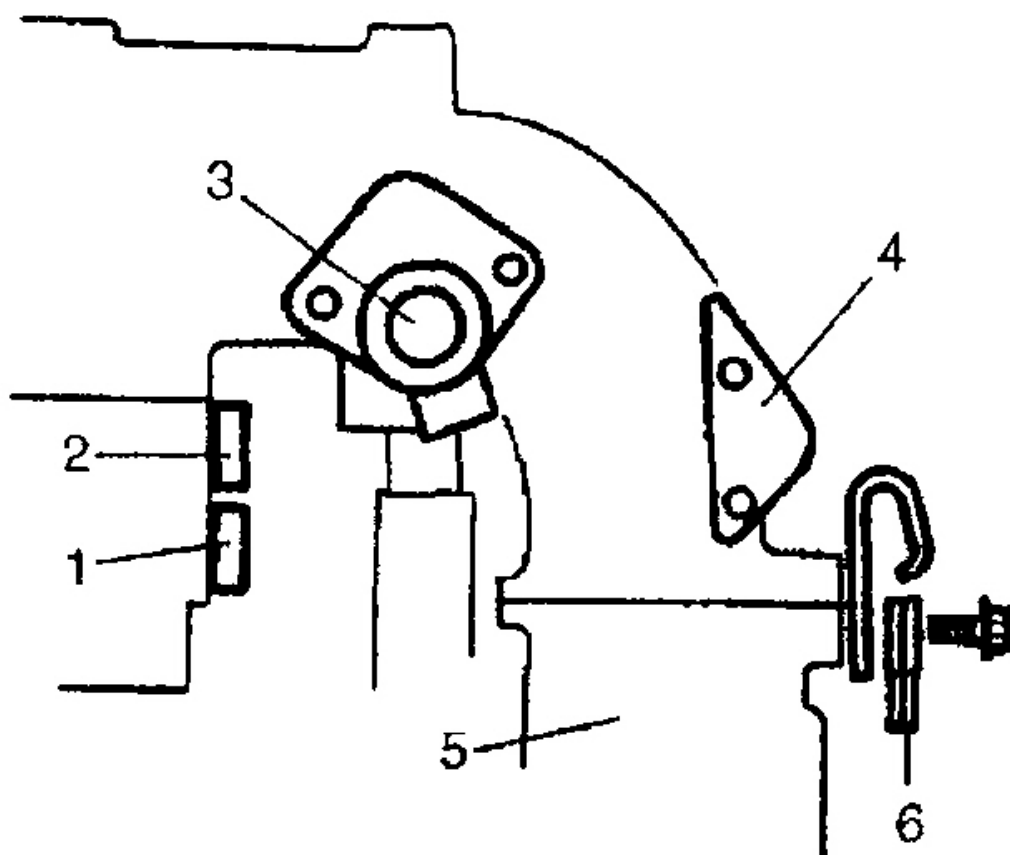
7. Remove surge tank cover.
8. Remove intake air pipe (1) and surge tank pipe (2).



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Fig. 15: Removing Intake Air Pipe & Surge Tank Pipe
Courtesy of SUZUKI OF AMERICA CORP.

9. Disconnect connector of injector wire.
10. Disconnect connectors of TP sensor (2), MAF sensor (1) and IAC valve (3).
11. Disconnect ground terminal (6) from intake manifold (5).
12. Remove clamp bracket (4) from intake collector.

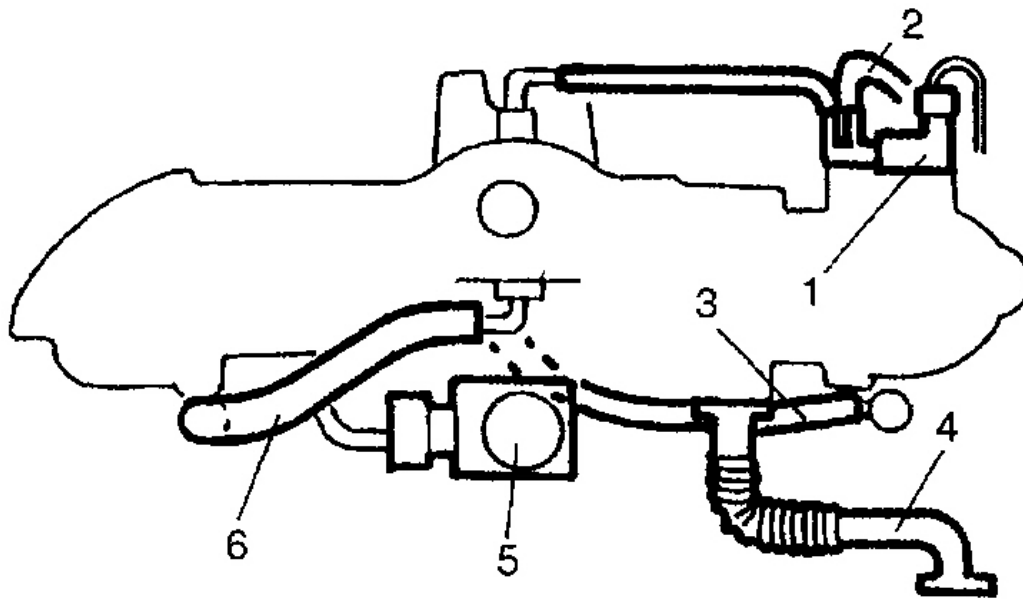


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Fig. 16: Disconnecting Connectors Of TP Sensor, MAF Sensor & IAC Valve Ground Terminal , & Removing Clamp Bracket

Courtesy of SUZUKI OF AMERICA CORP.

13. Disconnect connectors of EVAP canister purge valve (1) and EGR valve (5).
14. Disconnect PCV hose (6), breather hose (3) and EVAP canister purge valve hose (2).
15. Remove EGR pipe (4) from exhaust manifold.



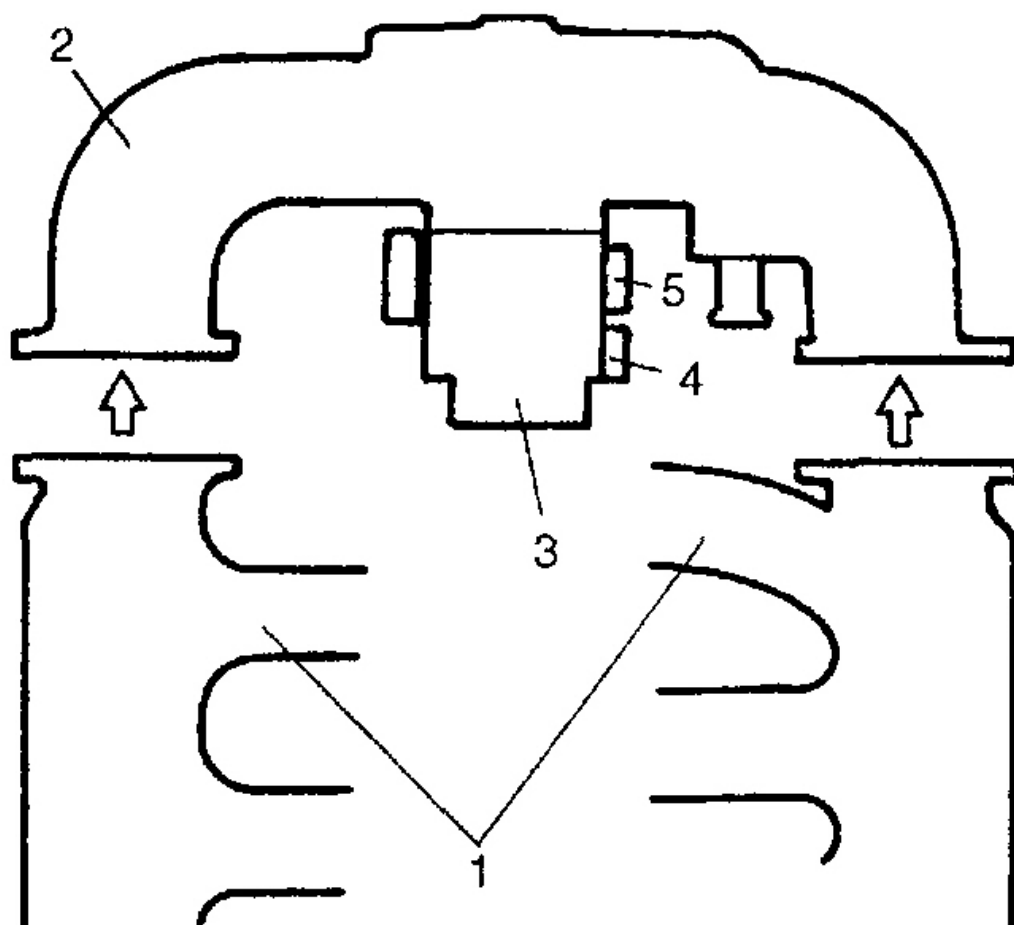
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Fig. 17: Disconnecting Connectors Of EVAP Canister Purge Valve, EGR Valve & Disconnecting PCV Hose, Breather Hose & EVAP Canister Purge Valve Hose, & Removing EGR Pipe
Courtesy of SUZUKI OF AMERICA CORP.

16. Remove throttle body (3) and intake collector (2) from intake manifold (1).
17. Disconnect hoses of IAC valve and PCV from throttle body.
18. Remove throttle body from intake collector.

NOTE:

- MAF sensor (4), TP sensor (5), or other components containing rubber must not be placed in a solvent or cleaner bath. A chemical reaction will cause these parts to swell, harden or get distorted.
- Don't put drills or wires into passages for cleaning. It causes damages in passages.

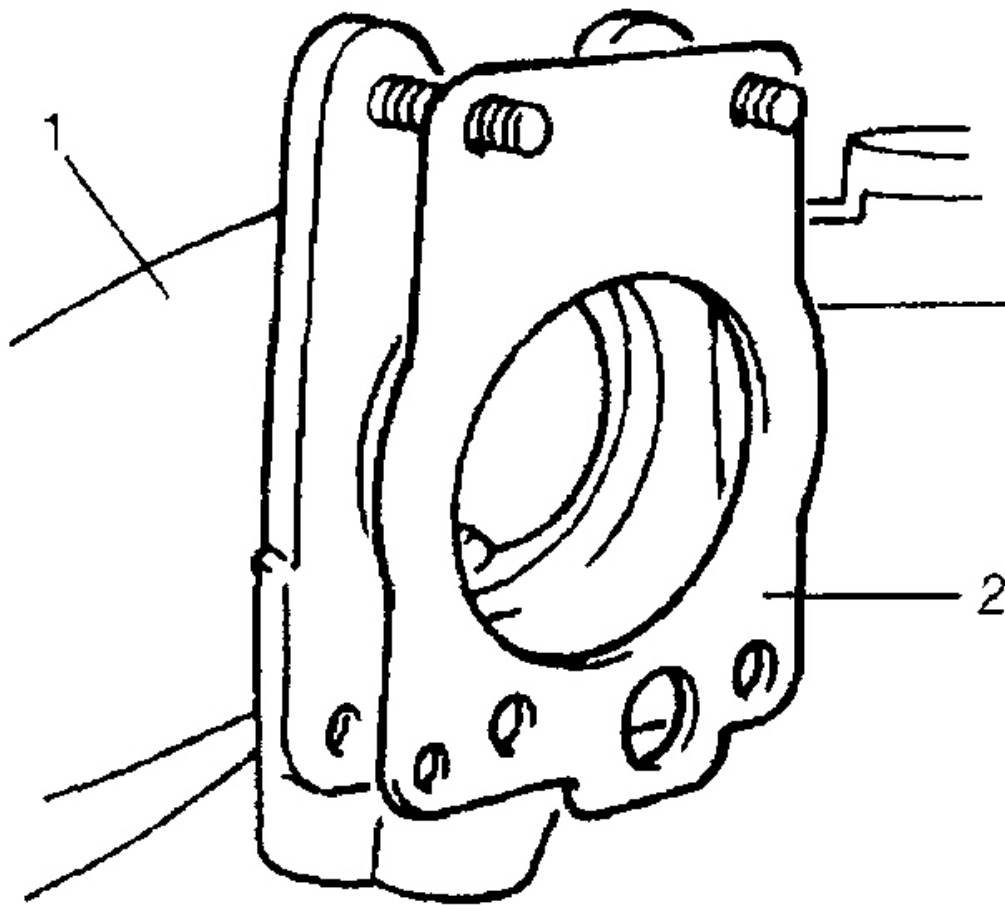


G02263853

Fig. 18: Removing Throttle Body & Intake Collector From Intake Manifold
Courtesy of SUZUKI OF AMERICA CORP.

Installation

1. Clean mating surfaces and install new throttle body gasket (2) to intake collector (1).



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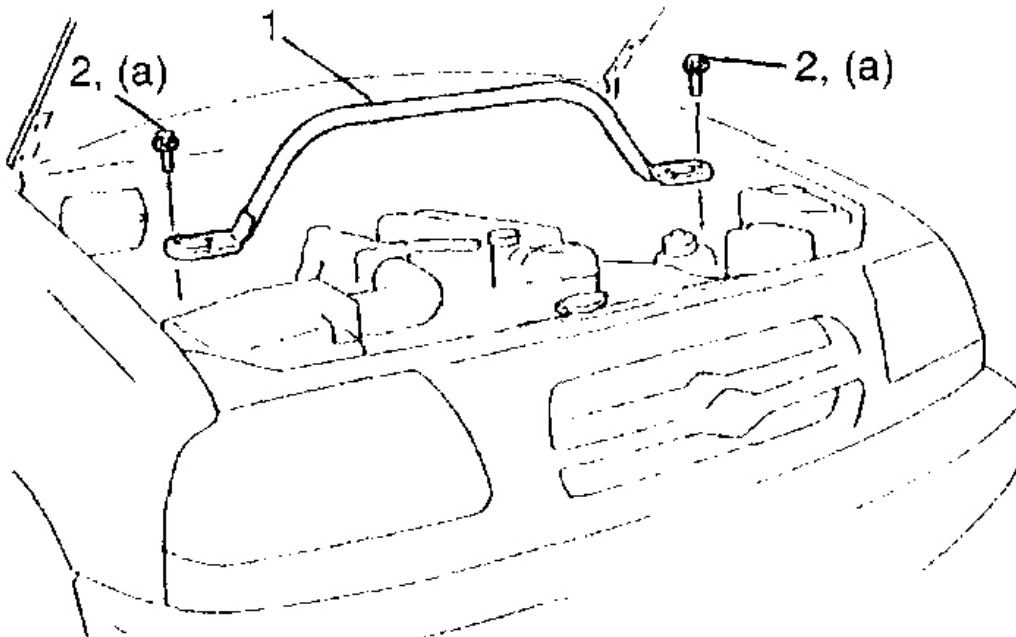
Fig. 19: Installing Throttle Body Gasket To Intake Collector
Courtesy of SUZUKI OF AMERICA CORP.

2. Install throttle body to intake collector and tighten bolts and nuts.
3. Connect IAC valve hose and PCV hose.
4. Install throttle body and intake collector to intake manifold with new intake collector gaskets.
5. Install EGR pipe with new gaskets.
6. Connect PCV hose, breather hose and EVAP canister purge valve hose.
7. Connect connectors of EVAP canister purge valve and EGR valve. Fix wire harness with clamps.
8. Install clamp bracket to intake collector.
9. Connect ground terminal to intake manifold.

10. Connect connectors of TP sensor, MAF sensor and IAC valve.
11. Connect connector of injector wire.
12. Install surge tank pipe to intake manifold with new gaskets and intake air pipe to throttle body.
13. Install surge tank cover.
14. Connect water hoses to throttle body.
15. Connect accelerator cable and A/T throttle cable (for A/T model).
16. Install strut tower bar (1) and tighten strut tower bar mounting bolts (2) to specified torque.

Tightening torque

Strut tower bar mounting bolts (a): 50 N.m (5.0 kg-m, 36.5 lb-ft)



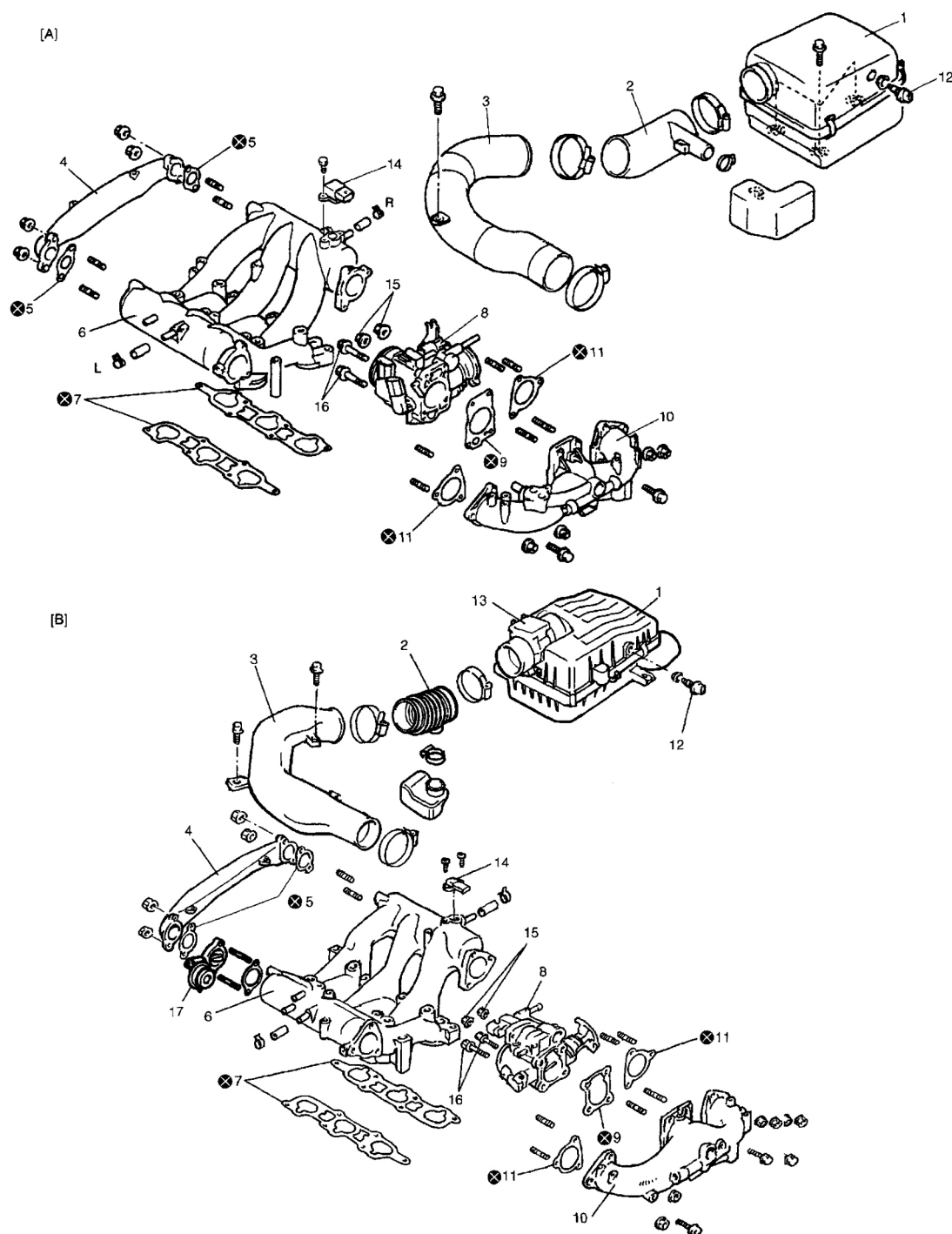
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Fig. 20: Installing Strut Tower Bar
Courtesy of SUZUKI OF AMERICA CORP.

17. Install fuse/relay box.
18. Refill cooling system referring to **COOLING SYSTEM FLUSH & REFILL** .
19. Connect negative (-) cable at battery.
20. Adjust accelerator cable and A/T throttle cable (for A/T model) referring to **ACCELERATOR CABLE**

ADJUSTMENT and A/T THROTTLE CABLE ADJUSTMENT (H25 ENGINE WITH A/T ONLY) .

THROTTLE BODY & INTAKE MANIFOLD COMPONENTS



[A]: For H25 engine	3. Intake air pipe	7. Intake manifold gasket	11. Gasket	15. Throttle body nut
[B]: For H27 engine	4. Surge tank pipe	8. Throttle body assembly	12. IAT sensor	16. Throttle body bolt
1. Air cleaner box	5. Gasket	9. Throttle body gasket	13. MAF sensor	17. Intake control valve
2. Intake air hose	6. Intake manifold	10. Intake collector	14. MAP sensor	⊗: Do not reuse.

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Fig. 21: Exploded View Of Throttle Body & Intake Manifold Components

Courtesy of SUZUKI OF AMERICA CORP.

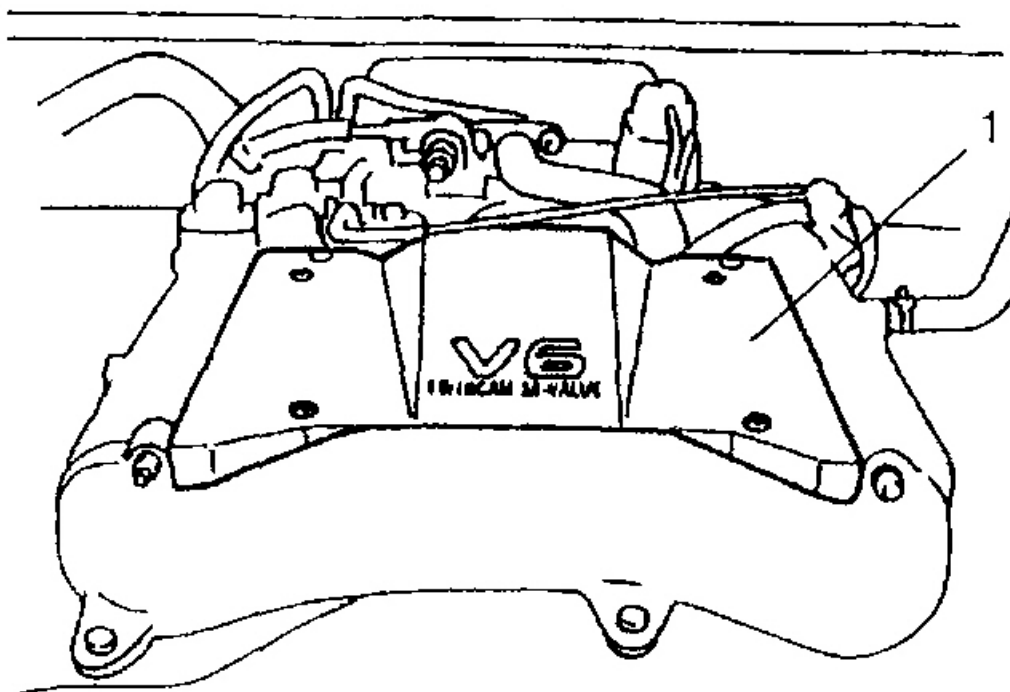
THROTTLE BODY & INTAKE MANIFOLD REMOVAL & INSTALLATION (H25 ENGINE)

Removal

1. Release fuel pressure in fuel feed line by referring to FUEL PRESSURE RELIEF PROCEDURE .

CAUTION: This work must not be done when engine is hot. If done so, it may cause adverse effect to catalyst.

2. Disconnect negative (-) cable at battery.
3. Drain coolant referring to COOLANT DRAINING .
4. Detach fuse/relay box and remove strut tower bar.
5. Disconnect coupler from IAT sensor.
6. Remove surge tank cover (1).

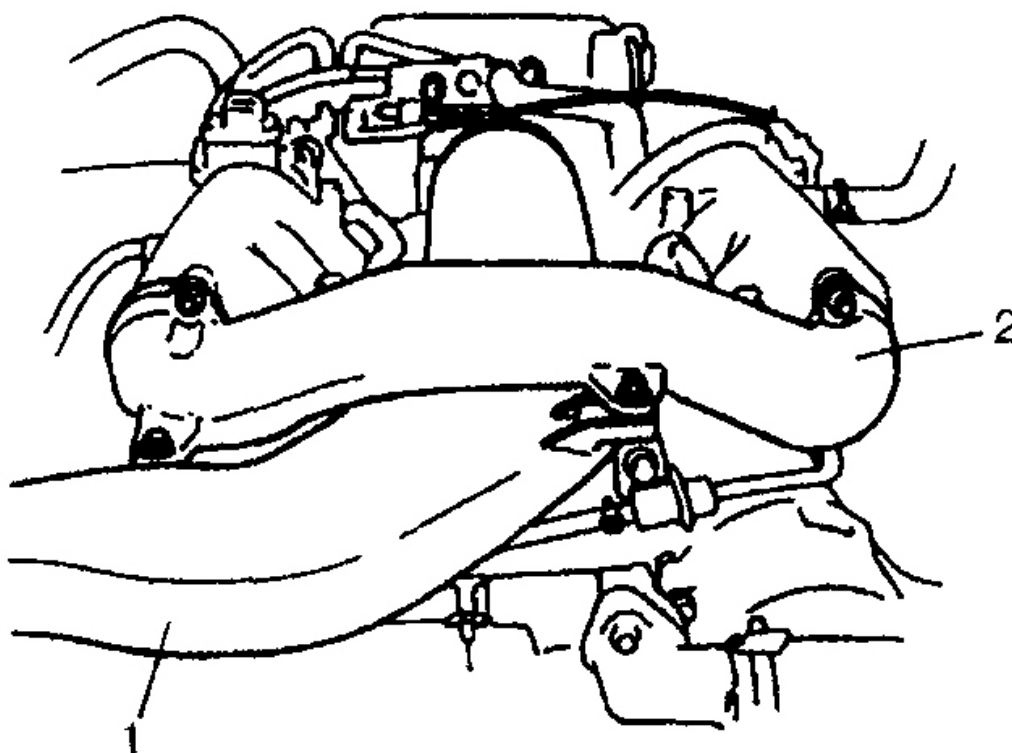


G02263867

Fig. 22: Removing Surge Tank Cover

Courtesy of SUZUKI OF AMERICA CORP.

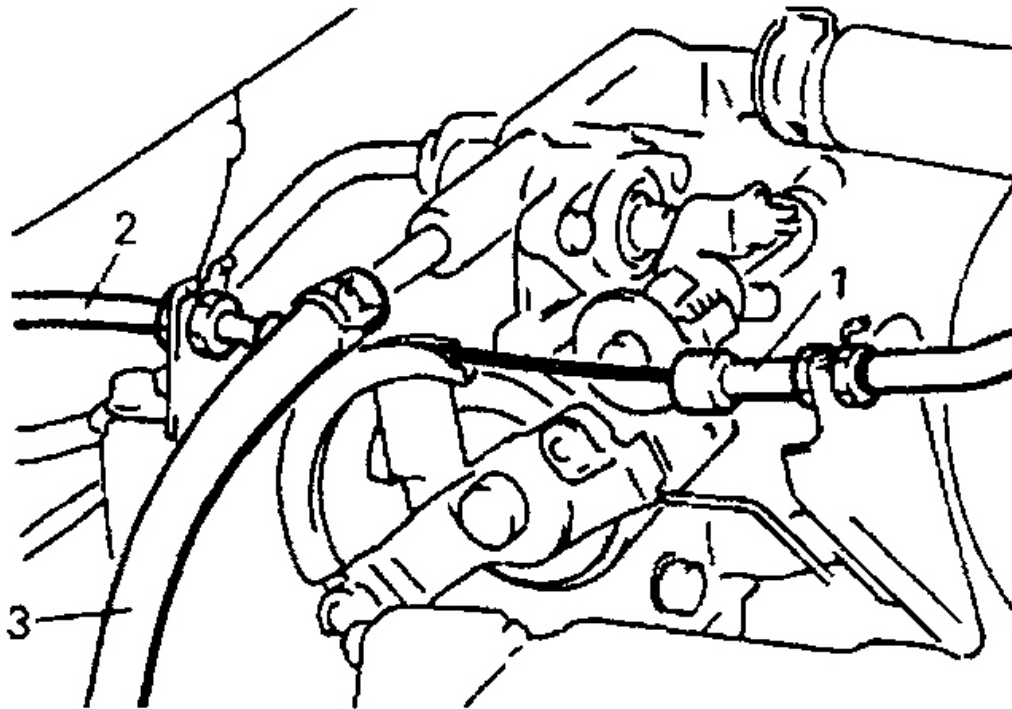
7. Remove air cleaner upper case, intake air hose, intake air pipe (1) and surge tank pipe (2) as one component. Do not disassemble them, when removing and reinstalling.



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Fig. 23: Removing Air Cleaner Upper Case, Intake Air Hose, Intake Air Pipe & Surge Tank Pipe
Courtesy of SUZUKI OF AMERICA CORP.

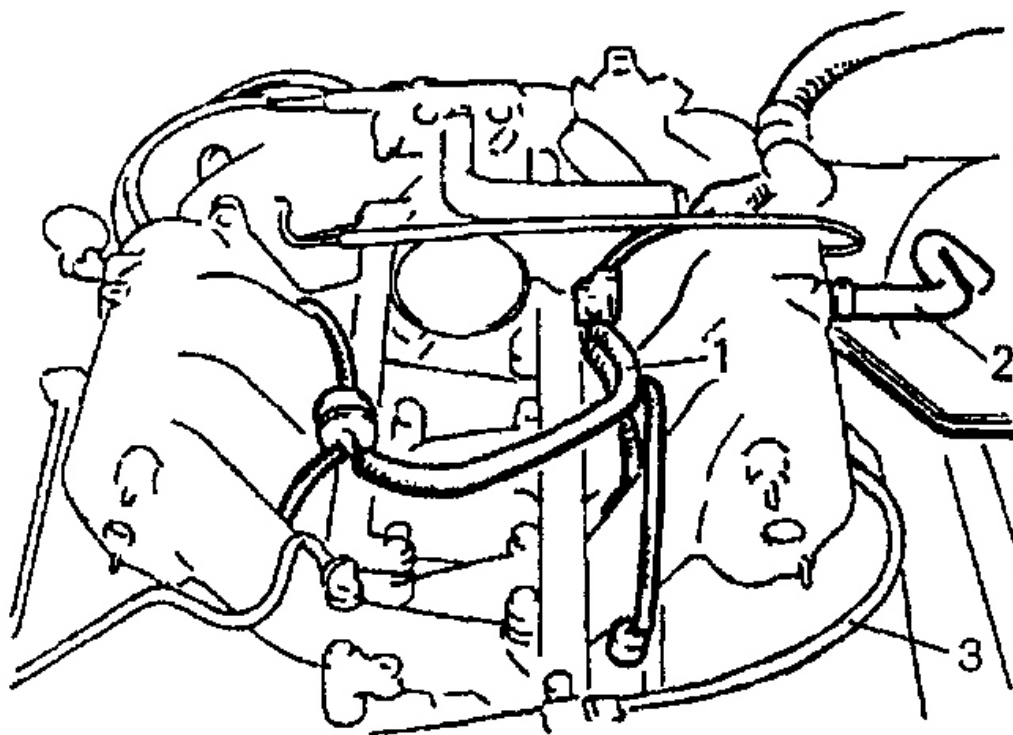
8. Disconnect accelerator cable (1) and A/T throttle cable (for A/T model) (2) from throttle body.
9. Disconnect water hose (3) from throttle body.



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Fig. 24: Disconnecting Water Hose From Throttle Body
Courtesy of SUZUKI OF AMERICA CORP.

10. Disconnect injector wire (1) coupler.
11. Disconnect brake booster hose (2) and fuel pressure regulator vacuum hose (3) from intake manifold.

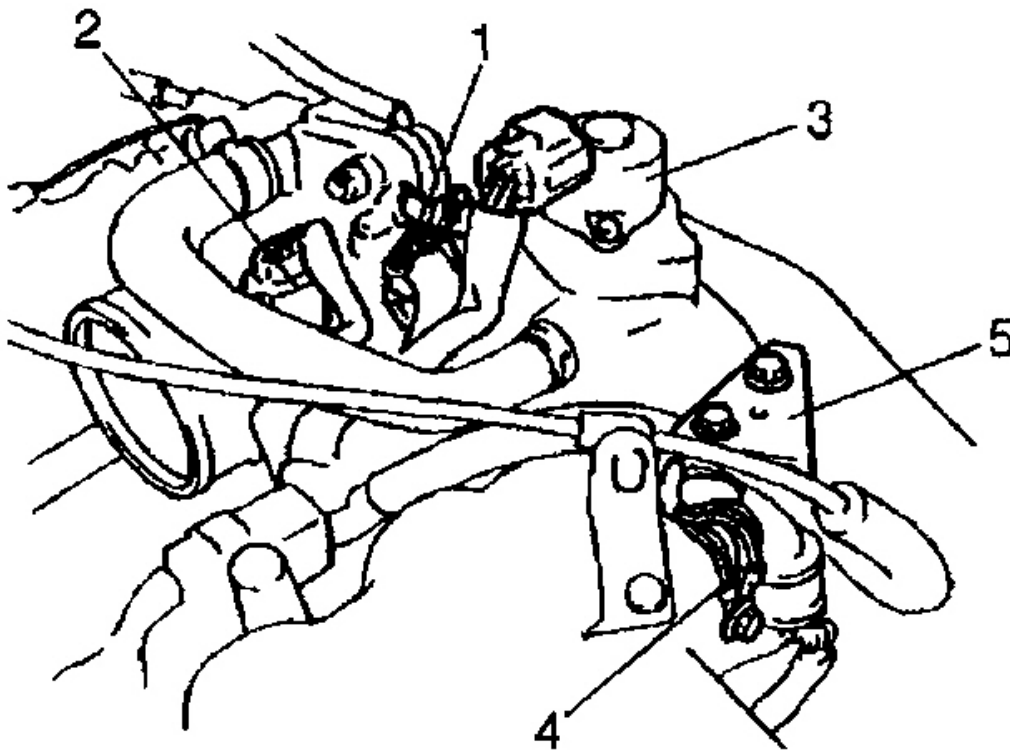


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Fig. 25: Disconnecting Brake Booster Hose & Fuel Pressure Regulator Vacuum Hose From Intake Manifold

Courtesy of SUZUKI OF AMERICA CORP.

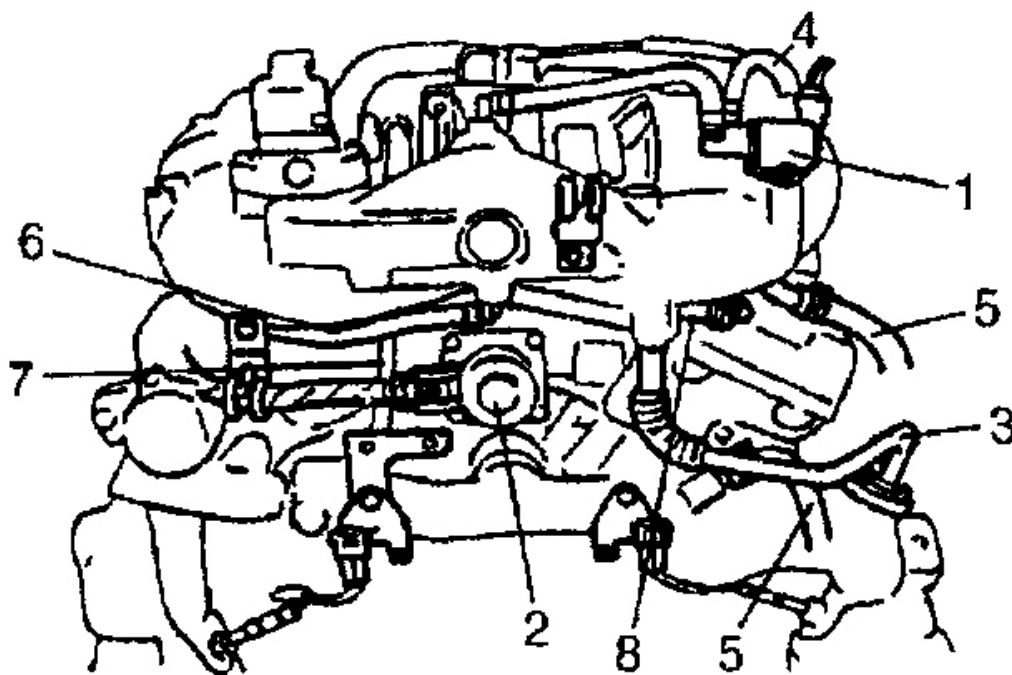
12. Disconnect couplers of TP sensor (1), MAF sensor (2) and IAC valve (3).
13. Disconnect earth terminal (4) from intake collector.
14. Remove clamp bracket (5) from intake collector.



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Fig. 26: Disconnect Couplers Of TP Sensor, MAF Sensor & IAC Valve, & Disconnecting Earth Terminal From Intake Collector, & Removing Clamp Bracket From Intake Collector
Courtesy of SUZUKI OF AMERICA CORP.

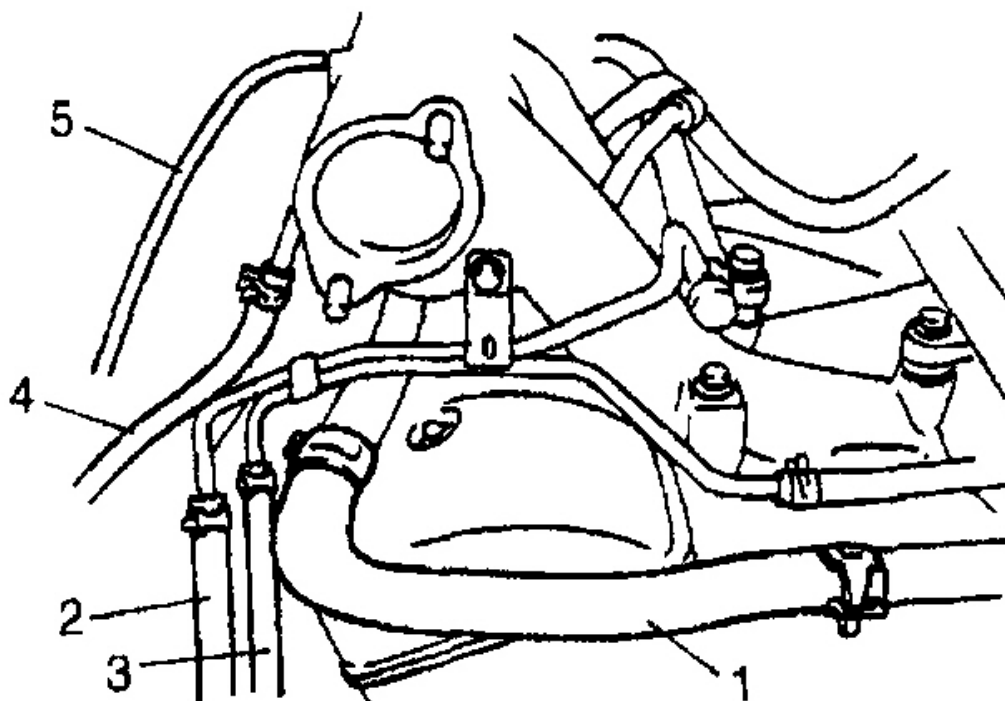
15. Disconnect couplers from MAP sensor, EVAP canister purge valve (1) and EGR valve (2).
16. Disconnect PCV hose (6) from cylinder head cover.
17. Disconnect breather hoses (8) from throttle body or cylinder head cover.
18. Disconnect EVAP canister purge valve hose (4), heater hose (5) and water hose (7).
19. Remove EGR pipe (3).



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Fig. 27: Disconnecting Couplers, EVAP Canister Purge Valve, EGR Valve, PCV Hose, Breather Hoses, EVAP Canister Purge Valve Hose, Heater Hose & Water Hose, & Removing EGR Pipe
Courtesy of SUZUKI OF AMERICA CORP.

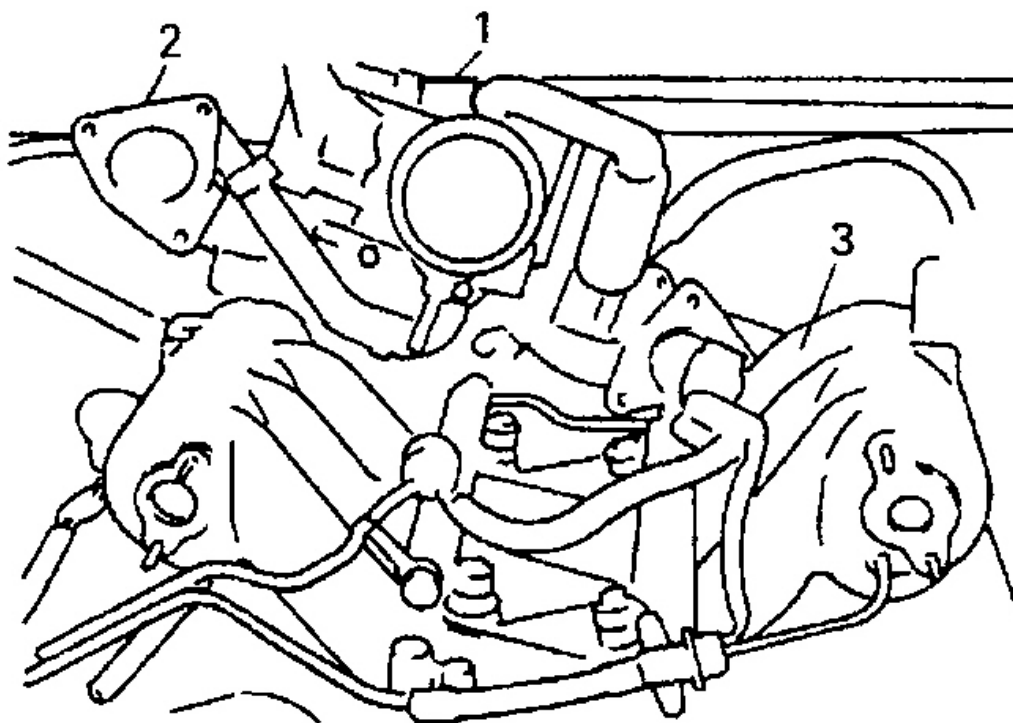
20. Disconnect heater hose (1), EVAP canister hose (4), tank pressure control solenoid valve hose (5), fuel feed hose (2) and fuel return hose (3).



G02263873

Fig. 28: Disconnecting Heater Hose, EVAP Canister Hose, Tank Pressure Control Solenoid Valve Hose, Fuel Feed Hose & Fuel Return Hose
Courtesy of SUZUKI OF AMERICA CORP.

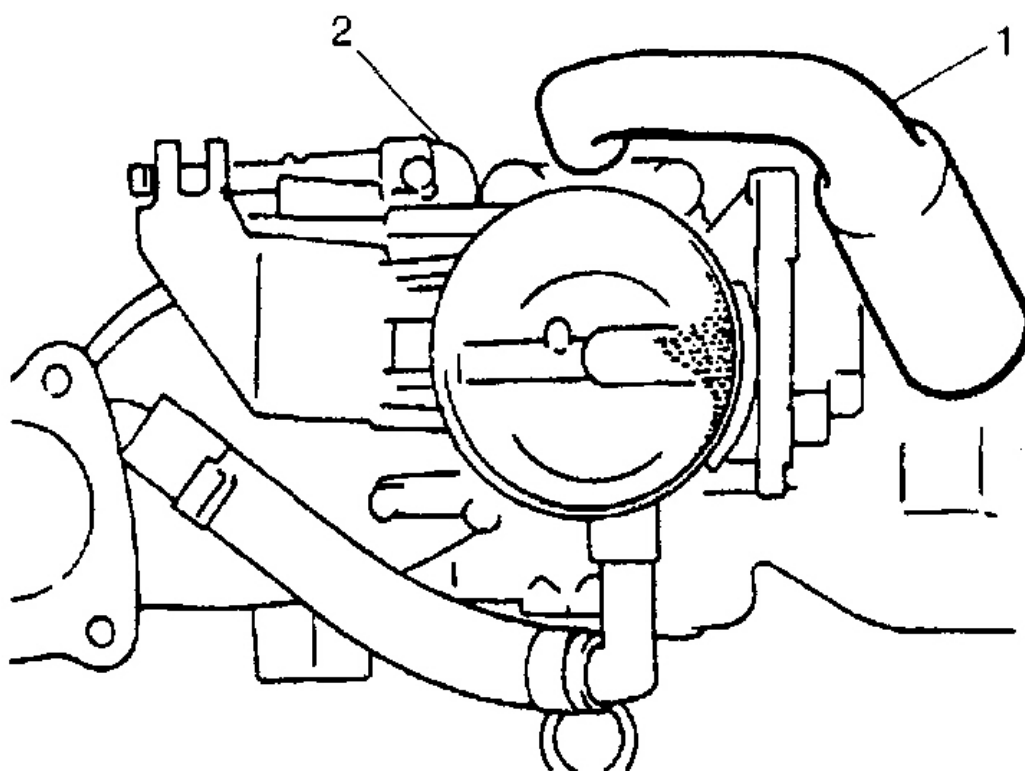
21. Remove throttle body (1) and intake collector (2) from intake manifold (3).



G02263874

Fig. 29: Removing Throttle Body & Intake Collector From Intake Manifold
Courtesy of SUZUKI OF AMERICA CORP.

22. Disconnect IAC valve hose (1) and EVAP canister purge valve hose from intake collector.
23. Remove throttle body (2) from intake collector.

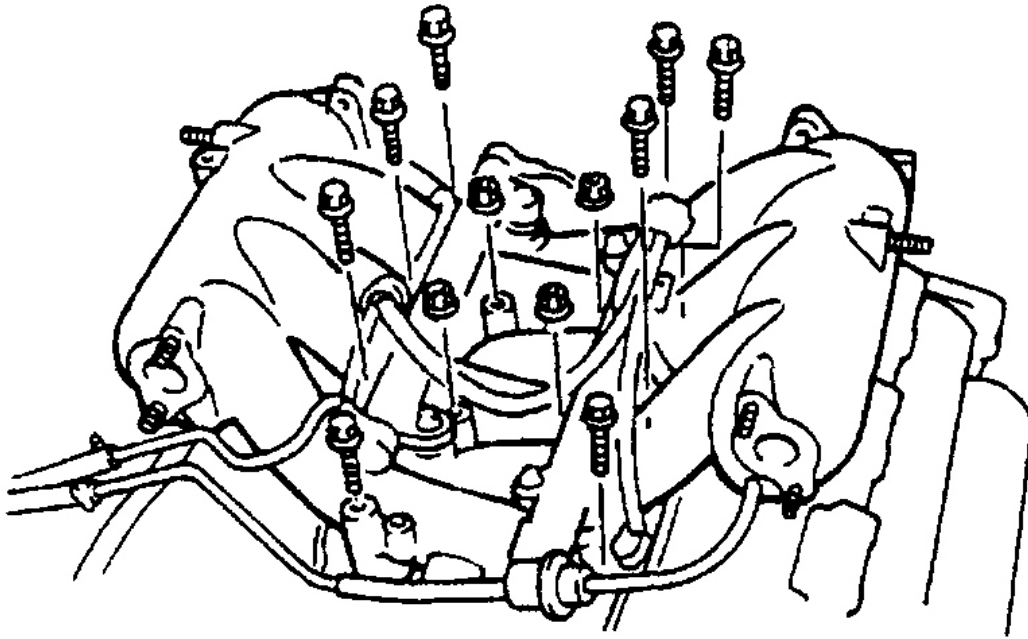


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Fig. 30: Disconnecting IAC Valve Hose & EVAP Canister Purge Valve Hose, & Removing Throttle Body

Courtesy of SUZUKI OF AMERICA CORP.

24. Remove IAC valve, EGR valve and EVAP canister purge valve from intake collector.
25. Remove intake manifold bolts (8 pc.) and nuts (4 pc.).
26. Remove intake manifold.

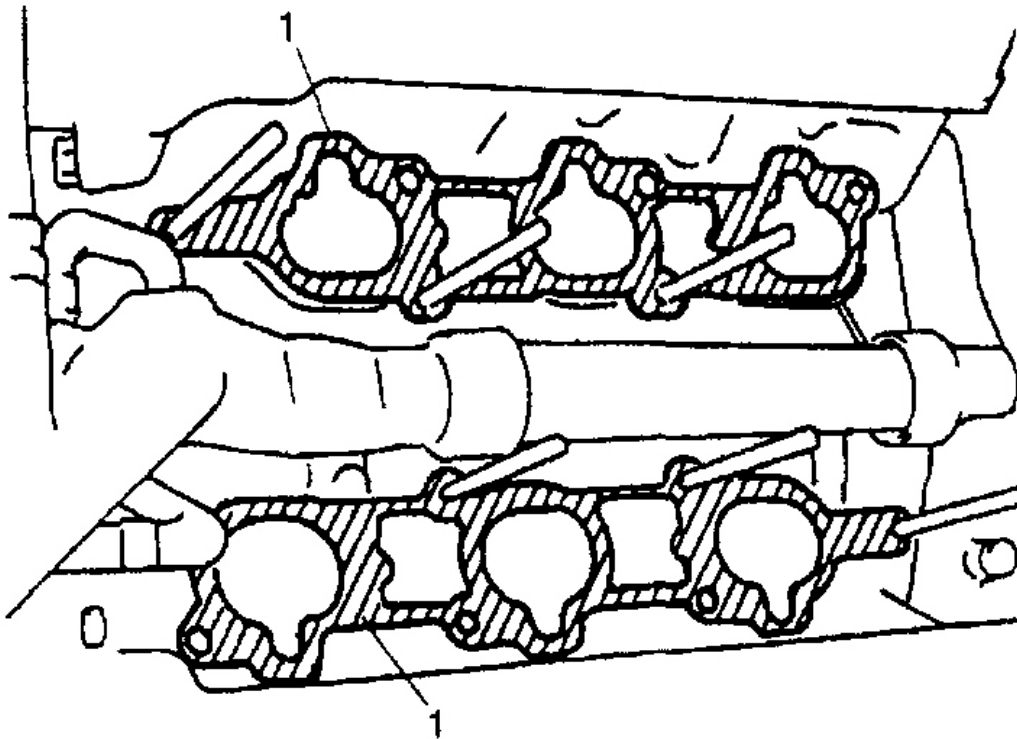


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Fig. 31: Removing Intake Manifold
Courtesy of SUZUKI OF AMERICA CORP.

Installation

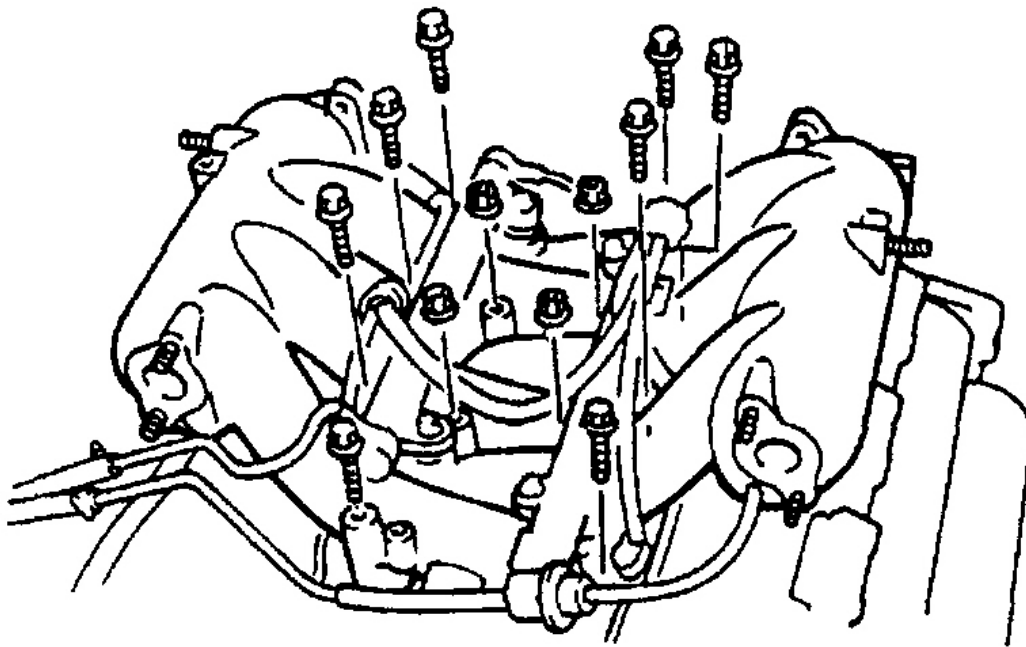
1. Install new intake manifold gaskets (1) to cylinder heads.



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Fig. 32: Installing Intake Manifold Gaskets
Courtesy of SUZUKI OF AMERICA CORP.

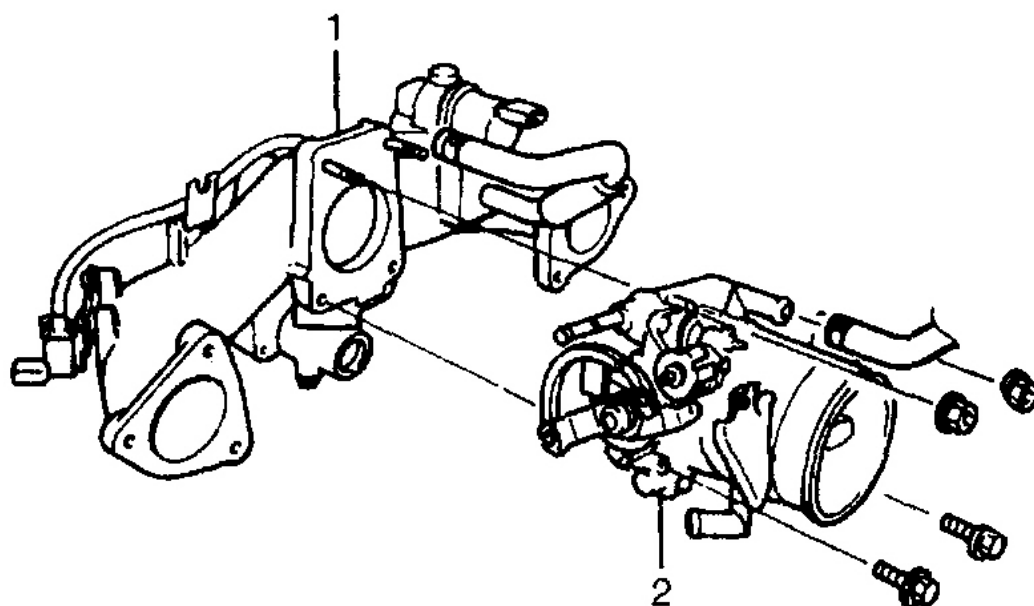
2. Install intake manifold and tighten bolts and nuts.



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Fig. 33: Installing Intake Manifold
Courtesy of SUZUKI OF AMERICA CORP.

3. Install throttle body (2) to intake collector (1) with new throttle body gasket.

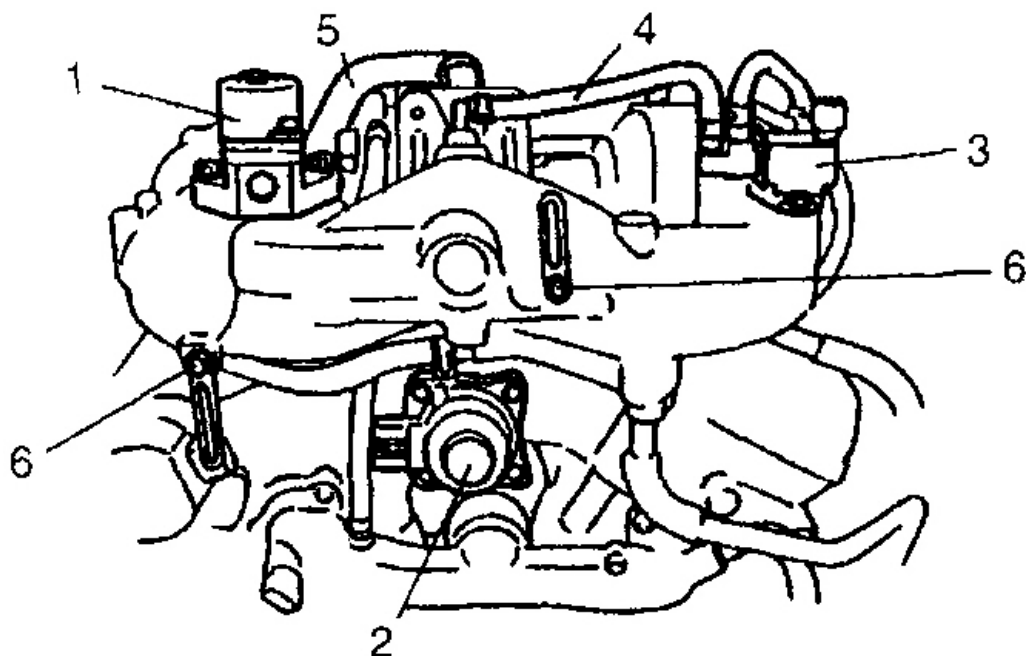


G02263879

Fig. 34: Installing Throttle Body To Intake Collector
Courtesy of SUZUKI OF AMERICA CORP.

4. Install IAC valve (1), EGR valve (2), EVAP canister purge valve (3), MAP sensor, clamps and each hoses to intake collector and throttle body if removed.

NOTE: Use new gasket, when installing IAC valve and EGR valve.

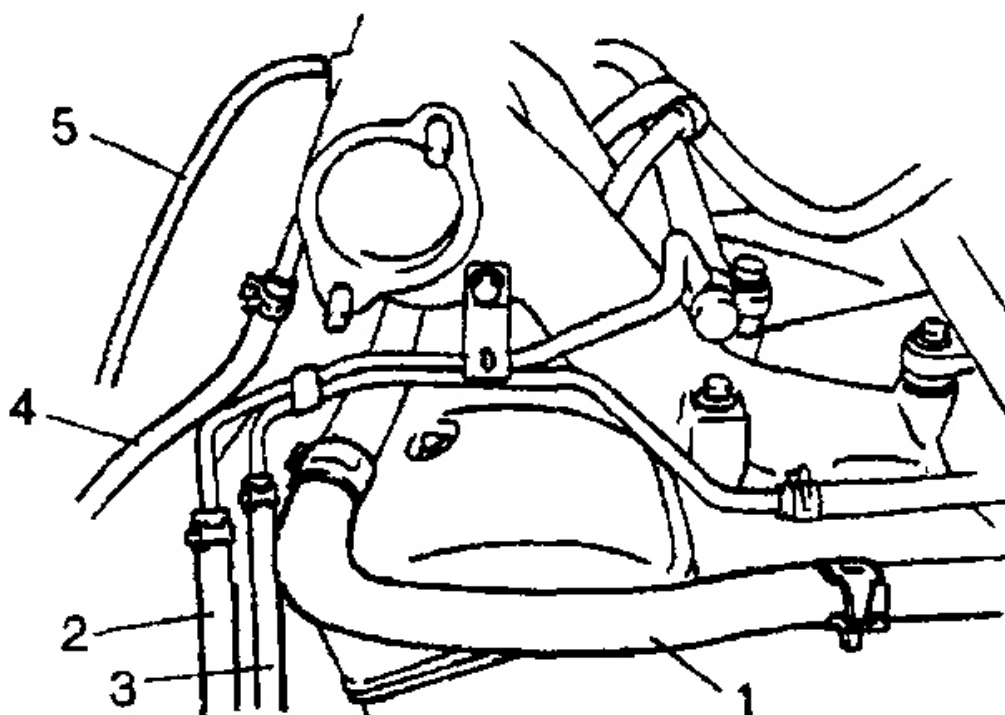


4. EVAP canister purge valve hose
5. IAC valve hose
6. Clamp

G02263880

Fig. 35: Installing Components & Hoses To Intake Collector & Throttle Body
Courtesy of SUZUKI OF AMERICA CORP.

5. Install throttle body and intake collector assembly to intake manifold with new intake collector gaskets.
6. Connect heater hose (1), EVAP canister hose (4), tank pressure control solenoid valve hose (5), fuel feed hose (2) and fuel return hose (3).

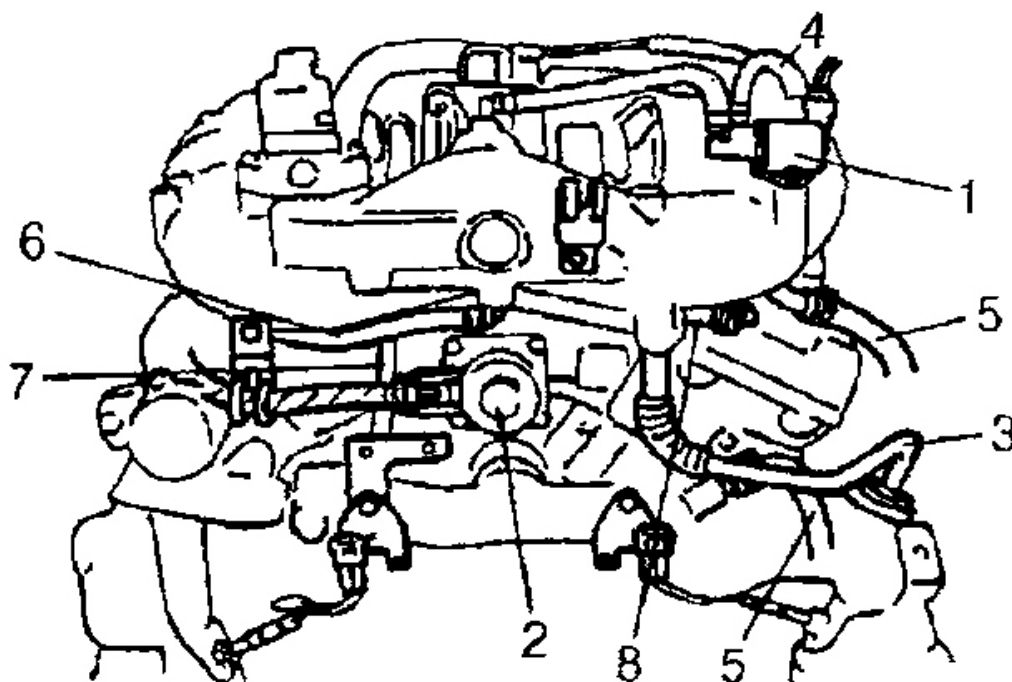


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Fig. 36: Connecting Hoses

Courtesy of SUZUKI OF AMERICA CORP.

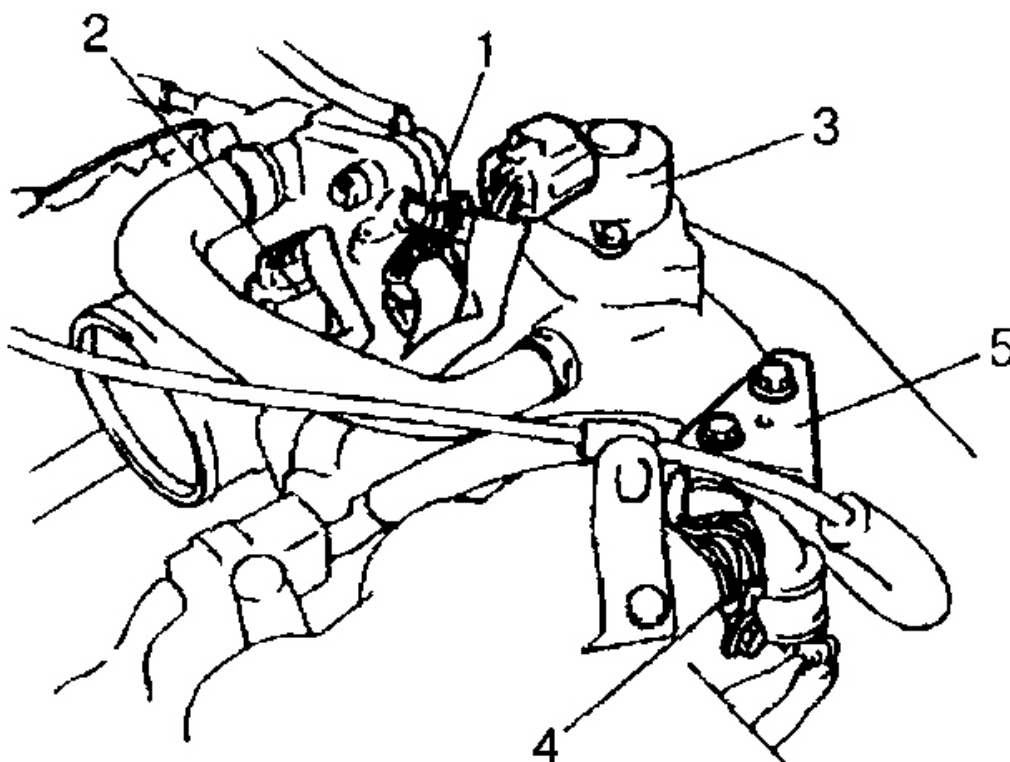
7. Install EGR pipe (3) with new gaskets.
8. Connect EVAP canister purge valve hose (4) and heater hose (5).
9. Connect PCV hose (6), breather hose (8) and water hose (7).
10. Connect couplers of MAP sensor, EVAP canister purge valve (1) and EGR valve (2). Fix wire harness with clamps.



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Fig. 37: Connecting Couplers & Hoses
Courtesy of SUZUKI OF AMERICA CORP.

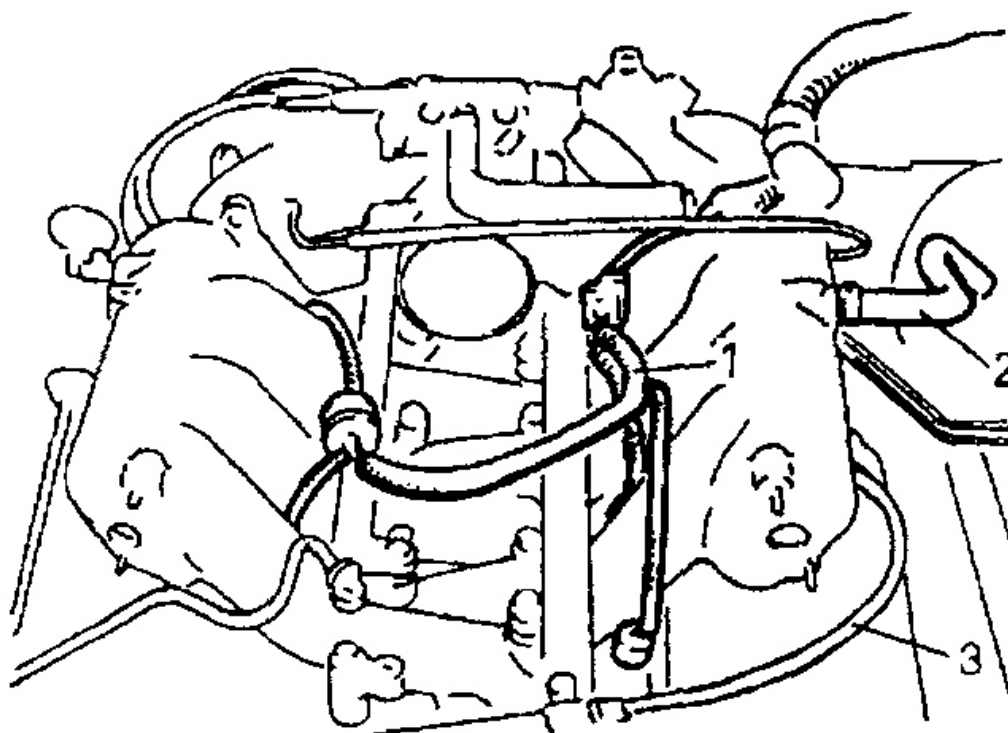
11. Install clamp bracket (5) to intake collector.
12. Connect earth terminal (4) to intake collector.
13. Connect TP sensor coupler (1), MAF sensor coupler (2) and IAC valve coupler (3).



G02263883

Fig. 38: Installing Clamp Bracket To Intake Collector
Courtesy of SUZUKI OF AMERICA CORP.

14. Connect brake booster hose (2) and fuel pressure regulator vacuum hose (3) to intake manifold.
15. Connect injector wire (1) coupler.

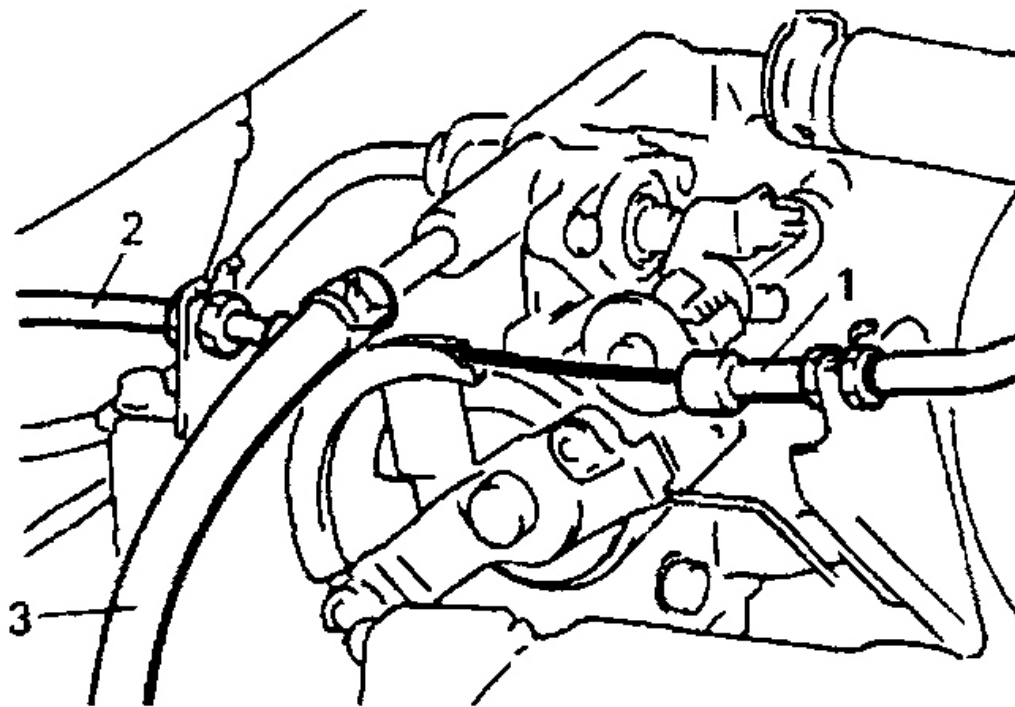


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Fig. 39: Connecting Hoses To Intake Manifold

Courtesy of SUZUKI OF AMERICA CORP.

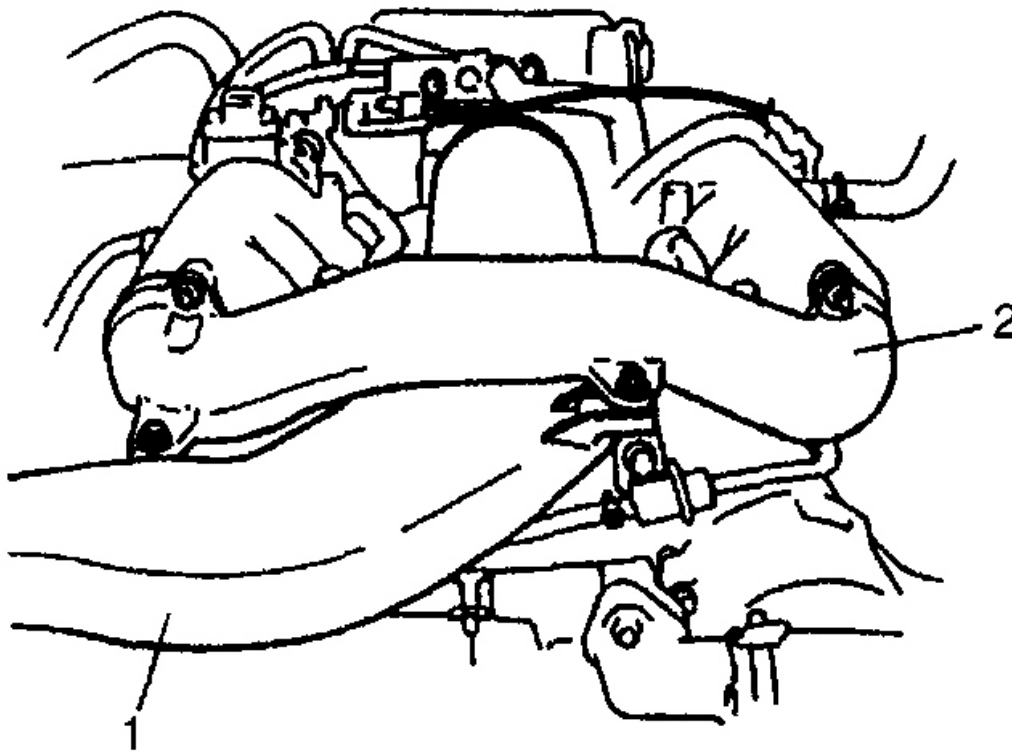
16. Connect water hoses (3) to throttle body.
17. Connect accelerator cable (1) and A/T throttle cable (for A/T model) (2) to throttle body, and adjust these cables referring to **ACCELERATOR CABLE ADJUSTMENT** and **A/T THROTTLE CABLE ADJUSTMENT (H25 ENGINE WITH A/T ONLY)**.



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Fig. 40: Connecting Accelerator Cable & A/T Throttle Cable (For A/T Model)
Courtesy of SUZUKI OF AMERICA CORP.

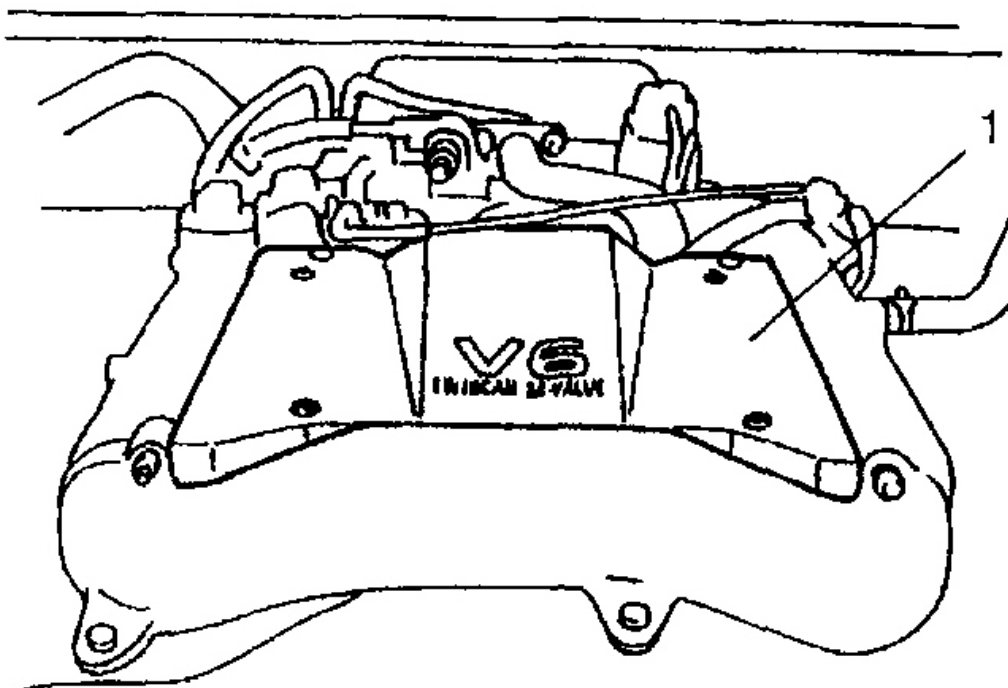
18. Install surge tank pipe (2) to intake manifold with new gaskets and intake air pipe (1) to throttle body.



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Fig. 41: Installing Surge Tank Pipe
Courtesy of SUZUKI OF AMERICA CORP.

19. Install surge tank cover (1).



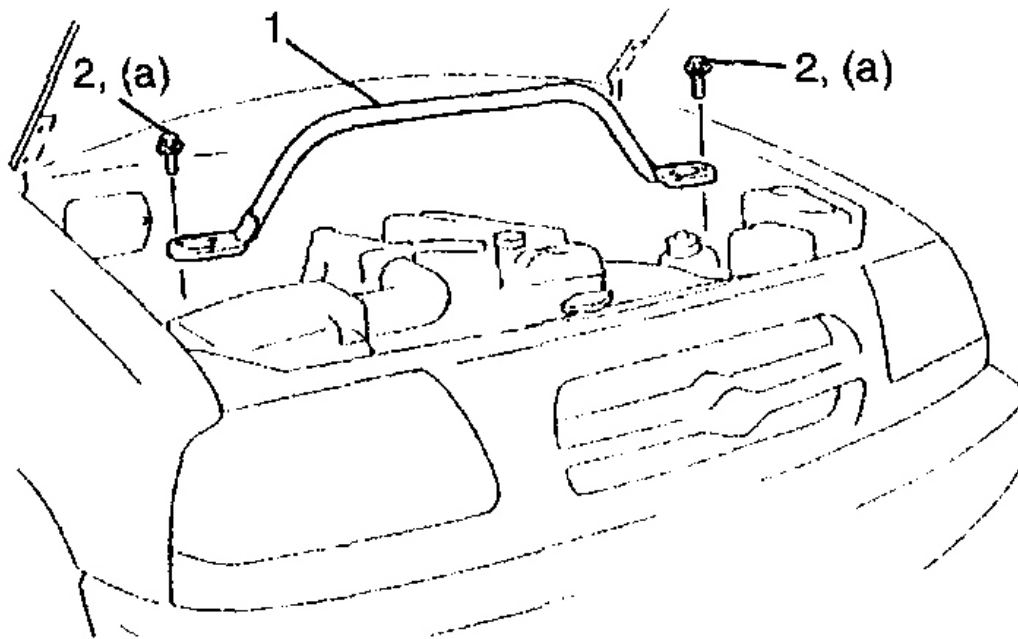
G02263887

Fig. 42: Installing Surge Tank Cover
Courtesy of SUZUKI OF AMERICA CORP.

20. Install air cleaner upper case referring to **AIR CLEANER ELEMENT REMOVAL & INSTALLATION**.
21. Connect coupler to intake air temperature sensor.
22. Install strut tower bar (1) and tighten strut tower bar mounting bolts (2) to specification.

Tightening torque

Strut tower bar mounting bolts (a): 50 N.m (5.0 kg-m, 36.5 lb-ft)



G02263888

Fig. 43: Installing Strut Tower Bar
Courtesy of SUZUKI OF AMERICA CORP.

23. Install fuse/relay box.
24. Check to ensure that all removed parts are back in place. Reinstall any necessary parts which have not been reinstalled.
25. Refill cooling system referring to **COOLING SYSTEM FLUSH & REFILL** .
26. Connect negative (-) cable at battery.
27. Upon completion of installation, verify that there is no fuel leakage at each connection according to procedure described in **FUEL LEAKAGE CHECK PROCEDURE** .

CYLINDER HEAD COVERS REMOVAL & INSTALLATION

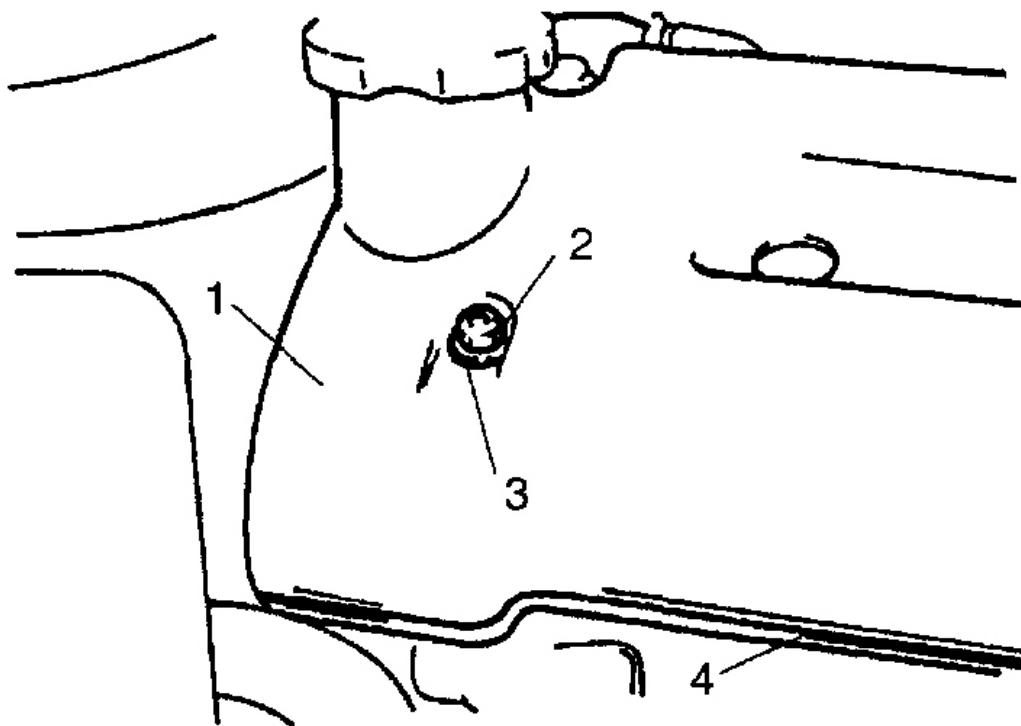
Removal

1. Remove throttle body and intake manifold.

Refer to **THROTTLE BODY & INTAKE MANIFOLD REMOVAL & INSTALLATION (H25 ENGINE)** .

2. Remove ignition coil covers.

3. Disconnect ignition coil couplers and remove ignition coils referring to **IGNITION COIL ASSEMBLY (IGNITER & IGNITION COIL) REMOVAL & INSTALLATION**.
4. Remove cylinder head covers (1).



2. Nut
3. Seal washer
4. Cylinder head cover gasket

G02263911

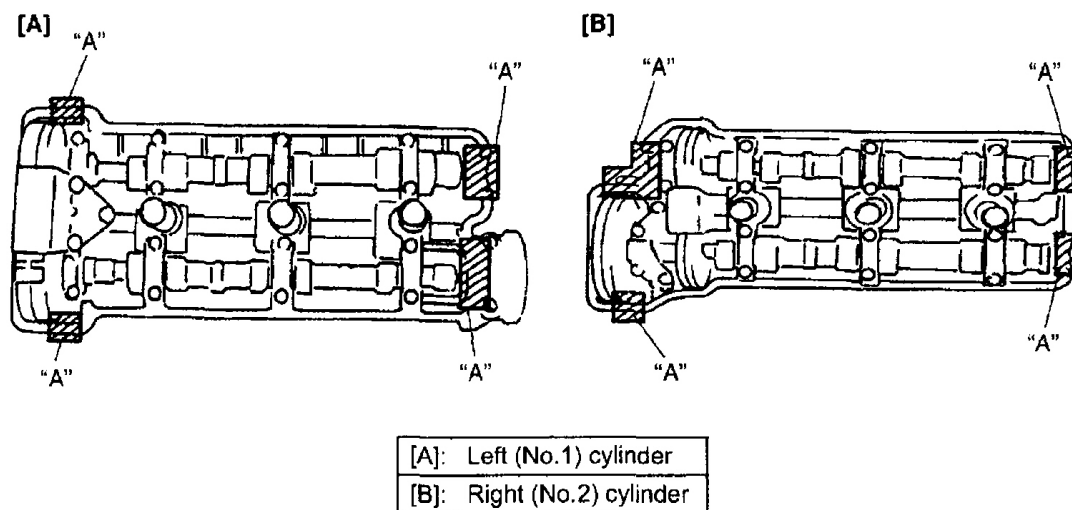
Fig. 44: Removing Cylinder Head Covers
Courtesy of SUZUKI OF AMERICA CORP.

Installation

1. Clean sealing surfaces on cylinder heads and covers.
2. Remove oil, old sealant, and dust from sealing surfaces. After cleaning, apply sealant "A" to cylinder

heads sealing surface area as shown in the figure.

"A": Water tight sealant 99000-31250



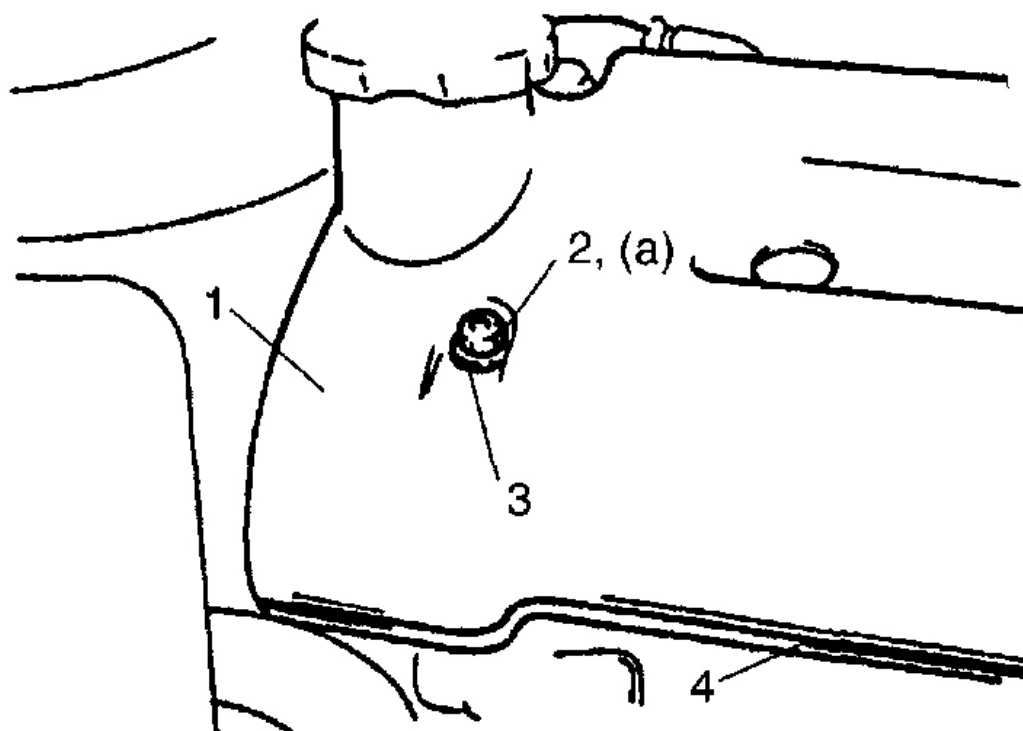
G02263912

Fig. 45: Applying Sealant To Cylinder Heads Sealing Surface Area
Courtesy of SUZUKI OF AMERICA CORP.

3. Install new cylinder head cover gaskets (4) to head covers (1).
4. Install cylinder head covers (1) to cylinder heads.
5. Using new seal washers (3), tighten nuts (2) to specified torque.

Tightening torque

Cylinder head cover nut (a): 10.5 N.m (1.1 kg-m, 7.5 lb-ft)



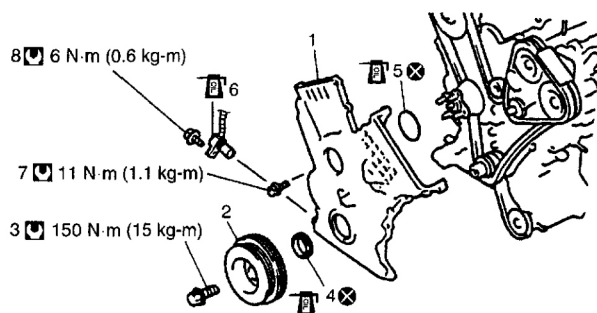
G02263913

Fig. 46: Installing Cylinder Head Covers
Courtesy of SUZUKI OF AMERICA CORP.

6. Install ignition coils and connect ignition coil couplers referring to **IGNITION COIL ASSEMBLY (IGNITER & IGNITION COIL) REMOVAL & INSTALLATION**.
7. Install ignition coil covers.
8. Install intake manifold with throttle body.

Refer to **THROTTLE BODY & INTAKE MANIFOLD REMOVAL & INSTALLATION (H25 ENGINE)**.

TIMING CHAIN COVER COMPONENTS



1. Timing chain cover	4. Oil seal	7. Timing chain cover bolt	⊗ : Do not reuse
2. Crankshaft pulley	5. O-ring	8. CKP sensor bolt	P : Apply engine oil
3. Crankshaft pulley bolt	6. CKP sensor	Ⓜ : Tightening torque	

G02263914

Fig. 47: Exploded View Of Timing Chain Cover Components
Courtesy of SUZUKI OF AMERICA CORP.

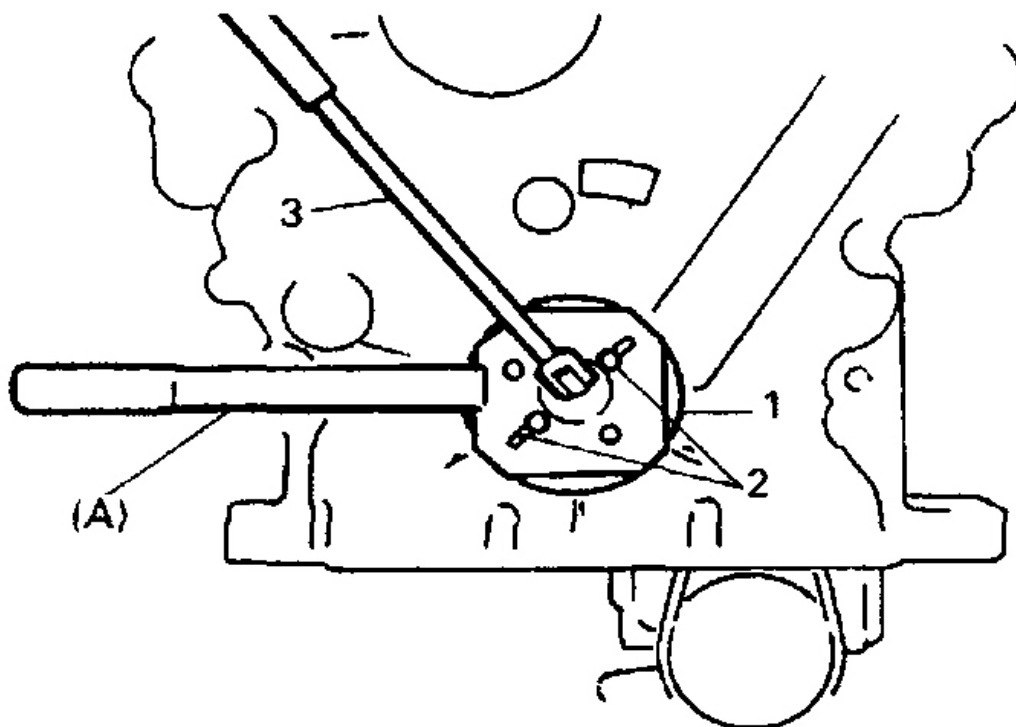
TIMING CHAIN COVER REMOVAL & INSTALLATION

Removal

1. Disconnect negative (-) cable at battery.
2. Drain engine oil.
3. Drain coolant referring to **COOLANT DRAINING**.
4. Remove throttle body and intake manifold.

Refer to **THROTTLE BODY & INTAKE MANIFOLD REMOVAL & INSTALLATION (H25 ENGINE)**.

5. Remove cylinder head covers. Refer to **CYLINDER HEAD COVERS REMOVAL & INSTALLATION**.
6. Remove P/S pump (A/C compressor) drive belt. Refer to **P/S PUMP DRIVE BELT INSPECTION & ADJUSTMENT**.
7. Remove cooling fan, fan clutch and water pump pulley. Refer to **COOLING FAN & FAN CLUTCH REMOVAL & INSTALLATION**.
8. Remove radiator. Refer to **RADIATOR REMOVAL & INSTALLATION**.
9. Remove thermostat cap. Refer to **THERMOSTAT REMOVAL & INSTALLATION**.
10. Remove P/S pump and P/S pump bracket. Refer to **P/S PUMP REMOVAL & INSTALLATION**.
11. Raise vehicle.
12. Remove oil pan. Refer to **OIL PAN & OIL PUMP STRAINER REMOVAL & INSTALLATION**.
13. Remove crankshaft pulley bolt (1). To lock crankshaft pulley, use special tool (camshaft pulley holder) as shown in the figure.

Special tool**(A):** 09917-68221

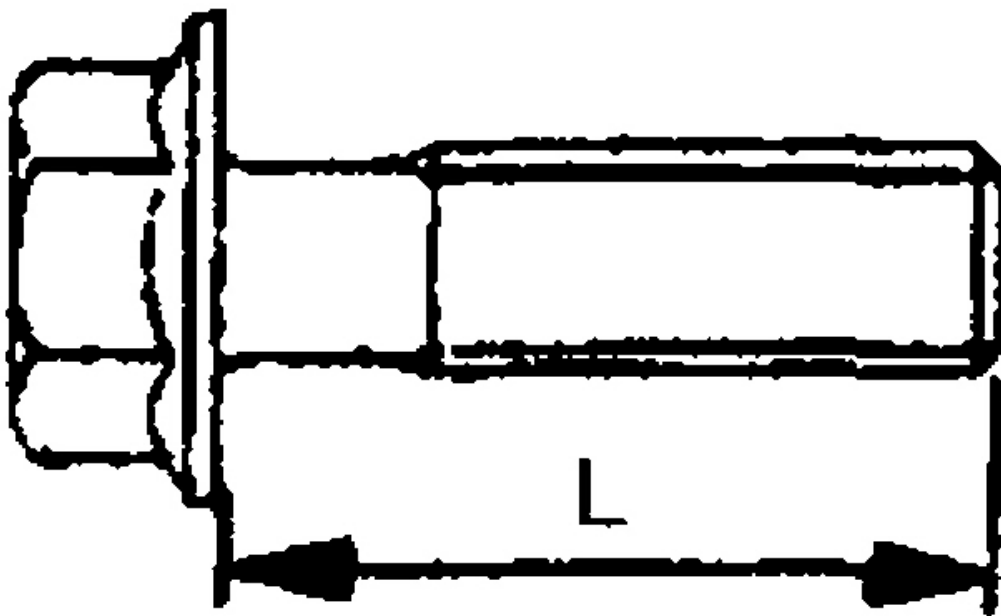
2. Bolt

3. Wrench

G02263915

Fig. 48: Removing Crankshaft Pulley Bolt
Courtesy of SUZUKI OF AMERICA CORP.

NOTE: Be sure to use the following bolt for fixing special tool to crankshaft pulley.
Bolt size: M8, P1.25 L = 45 mm
Strength: 7T



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Fig. 49: Identifying Bolt For Fixing Special Tool To Crankshaft Pulley
Courtesy of SUZUKI OF AMERICA CORP.

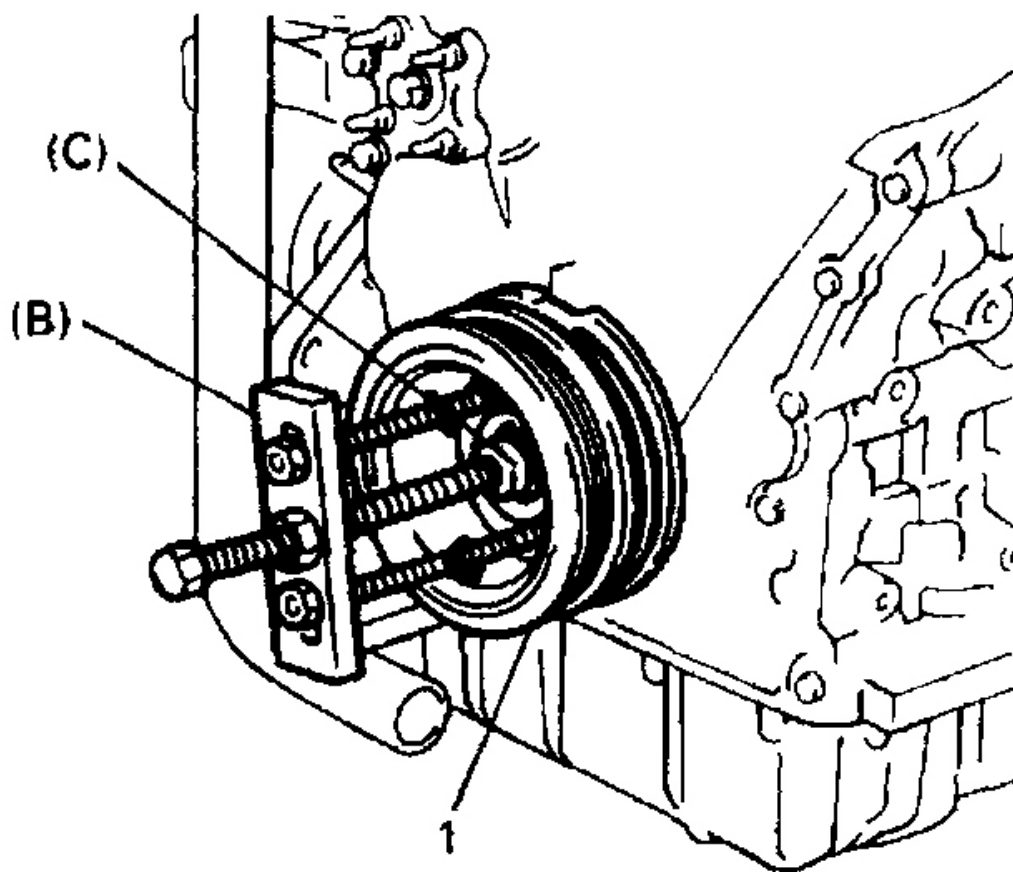
14. Remove crankshaft pulley (1).

If it is hard to remove, use special tools (Steering wheel remover, Bearing puller attachment) as shown in the figure. If bolts of steering wheel remover are too long, replace them with those of suitable length.

Special tool

(B): 09944-36011

(C): 09926-58010



G02263917

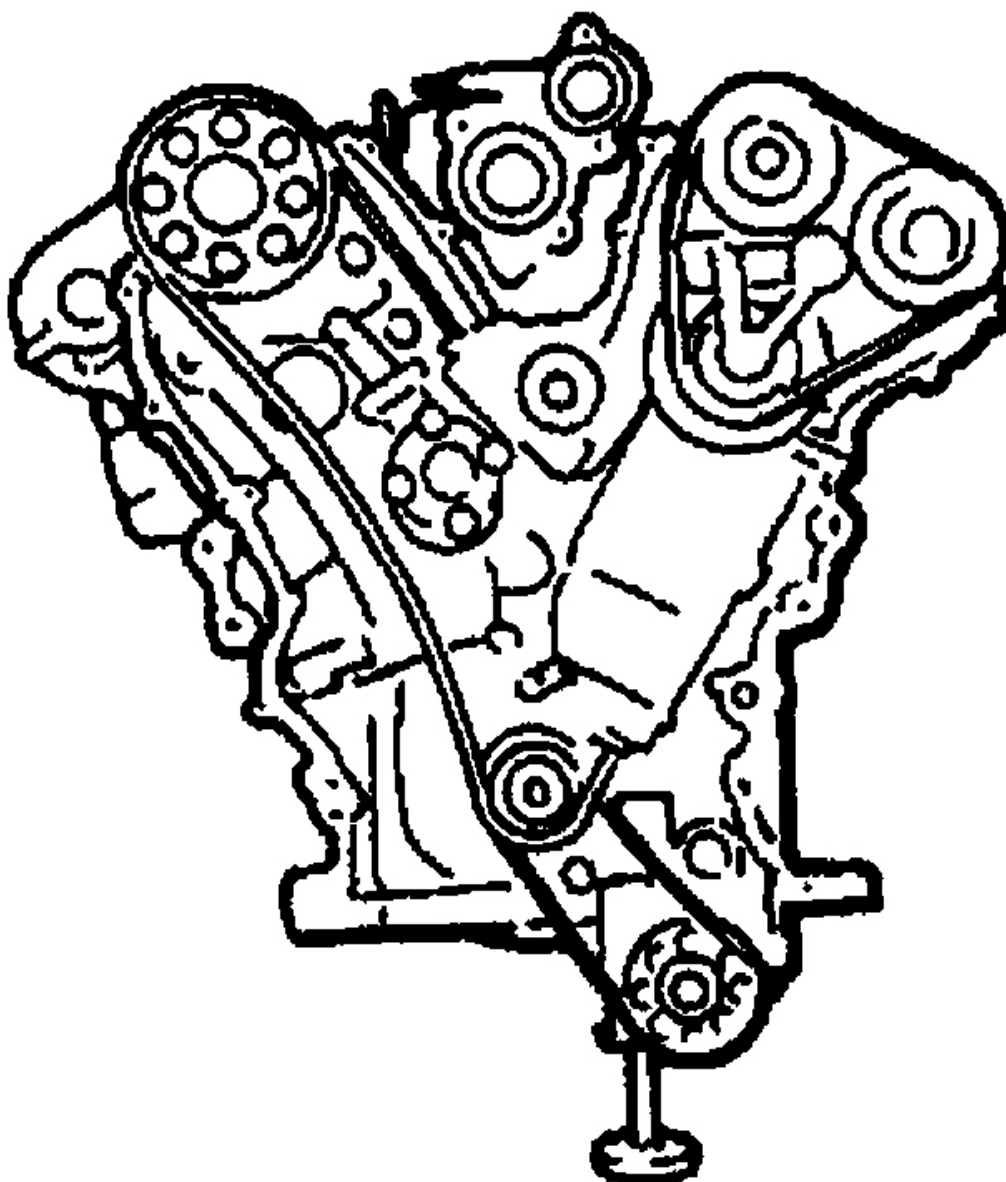
Fig. 50: Removing Crankshaft Pulley
Courtesy of SUZUKI OF AMERICA CORP.

15. Disconnect CKP sensor connector and remove CKP sensor if necessary.
16. Remove timing chain cover.

Installation

Reverse removal sequence to install timing chain cover noting the following points.

- Clean sealing surface on timing chain cover, crankcase, cylinder block and cylinder heads. Remove oil, old sealant, and dust from sealing surface.



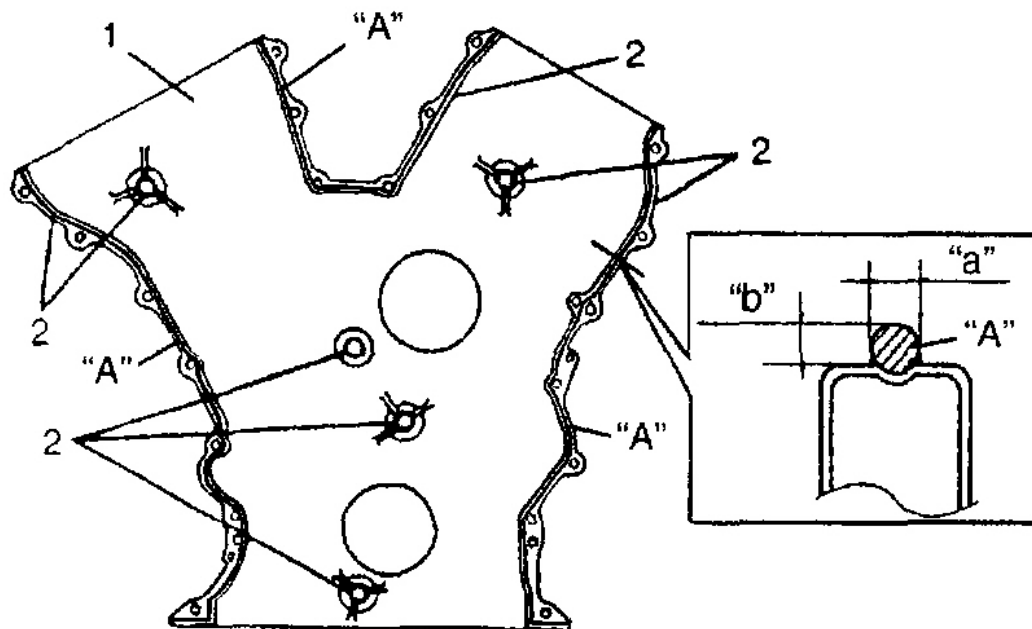
G02263918

Fig. 51: Cleaning Sealing Surface On Timing Chain Cover, Crankcase, Cylinder Block & Cylinder Heads

Courtesy of SUZUKI OF AMERICA CORP.

- Apply sealant "A" to timing chain cover sealing surface area as shown in the figure.

"A": Water tight sealant 99000-31250



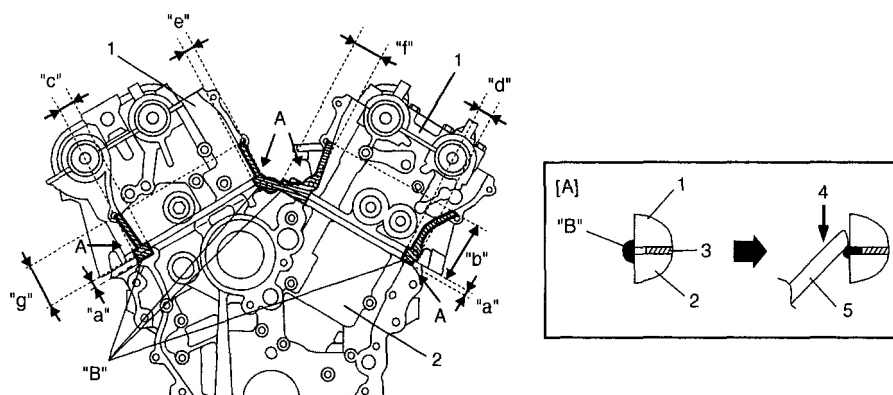
"a": 3 mm (0.12 in)	1. Timing chain cover
"b": 2 mm (0.08 in)	2. Sealant "A"

G02263919

Fig. 52: Applying Sealant To Timing Chain Cover Sealing Surface Area
Courtesy of SUZUKI OF AMERICA CORP.

- Apply sealant "B" to mating surfaces of cylinder head and cylinder block as shown.

"B": Water tight sealant 99000-31140



[A]: View A	3. Cylinder head gasket	"a": 7 mm (0.28 in.)	"d": 18 mm (0.71 in.)	"g": 50 mm (1.97 in.)
1. Cylinder head	4. Rub into	"b": 67 mm (2.64 in.)	"e": 10 mm (0.39 in.)	
2. Cylinder block	5. Jig	"c": 17 mm (0.67 in.)	"f": 34 mm (1.34 in.)	

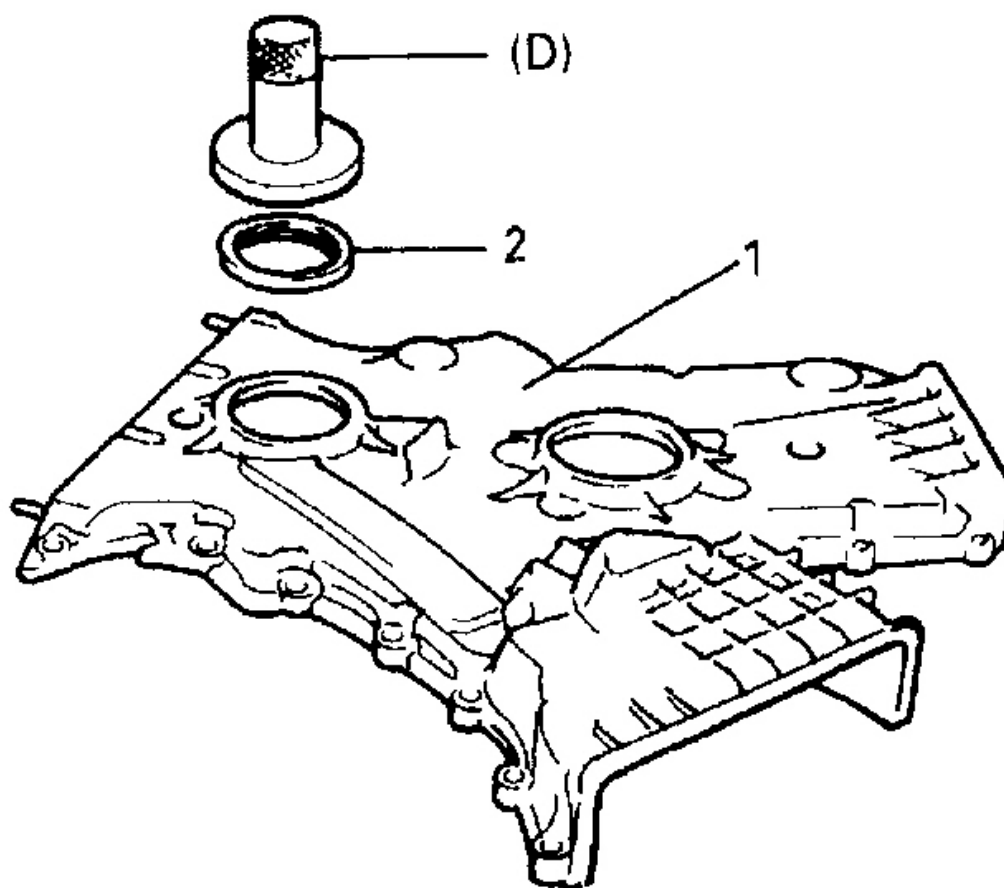
G02263920

Fig. 53: Applying Sealant To Mating Surfaces Of Cylinder Head & Cylinder Block
 Courtesy of SUZUKI OF AMERICA CORP.

- Apply engine oil to new oil seal lip and water pump O-ring. Using special tool (bearing installer), install new oil seal (2) with its surface is flush with edge of timing chain cover (1).

Special tool

(D): 09913-75510



G02263921

Fig. 54: Installing New Oil Seal

Courtesy of SUZUKI OF AMERICA CORP.

- Install timing chain cover.

Tightening torque**Timing chain cover bolt:** 11 N.m (1.1 kg-m, 8.0 lb-ft)

- Apply engine oil to O-ring of CKP sensor and install CKP sensor (4) to timing chain cover.

Tightening torque**CKP sensor bolt (b):** 6 N.m (0.6 kg-m, 4.5 lb-ft)

- Install crankshaft pulley (1).

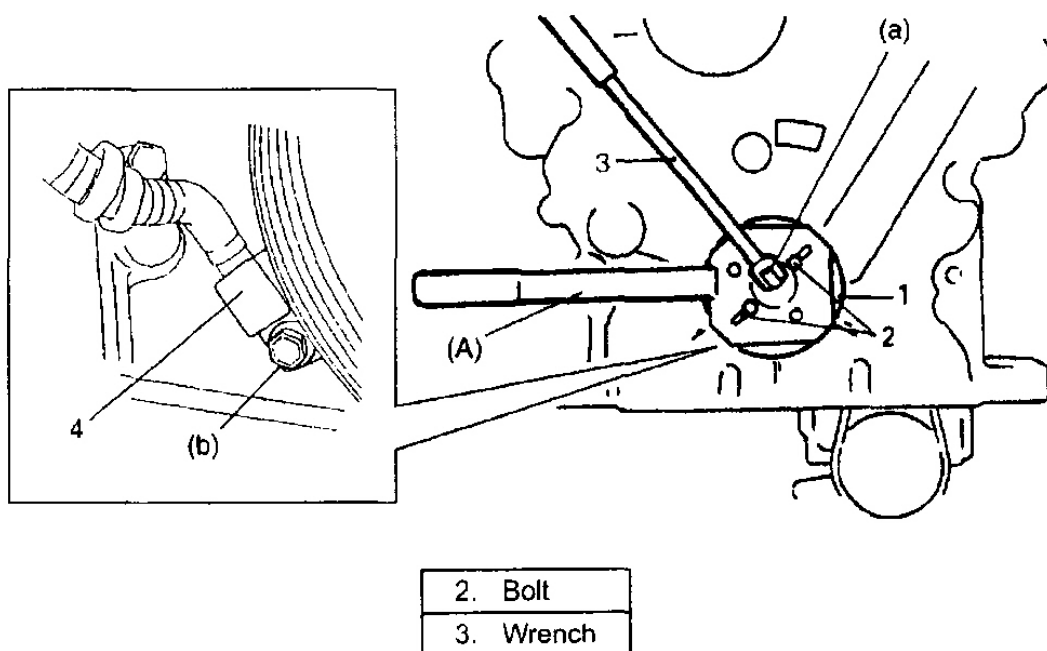
To lock crankshaft pulley, use special tool (camshaft pulley holder) with it at shown in the figure.

Special tool

(A): 09917-68221

Tightening torque

Crankshaft pulley bolt (a): 150 N.m (15 kg-m, 108.5 lb-ft)

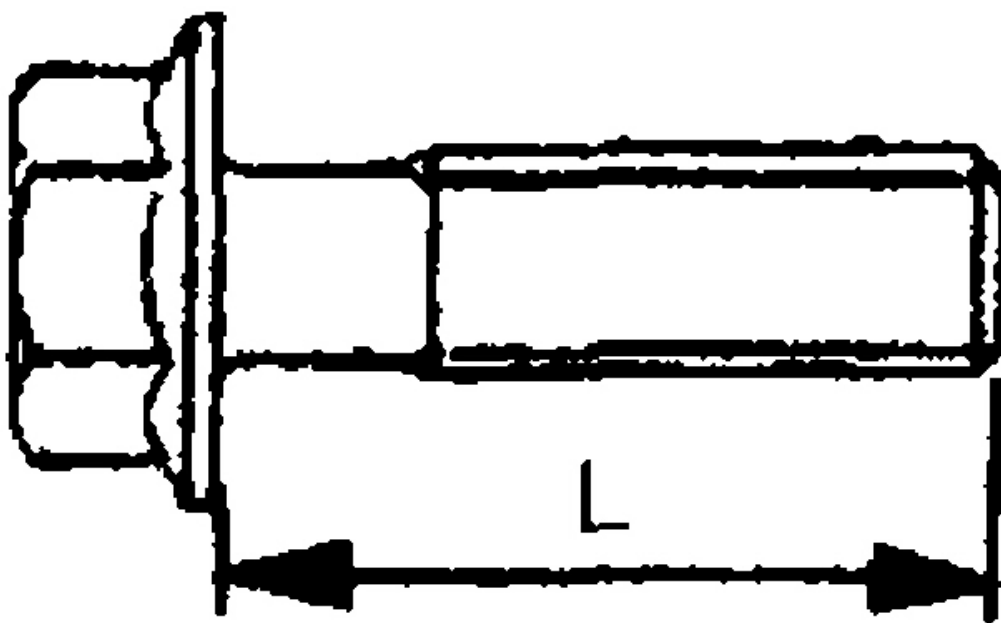


G02263922

Fig. 55: Installing Crankshaft Pulley

Courtesy of SUZUKI OF AMERICA CORP.

NOTE: Be sure to use the following bolt for fixing special tool to crank pulley.
Bolt size: M8, P1.25 L = 45 mm
Strength: 7T



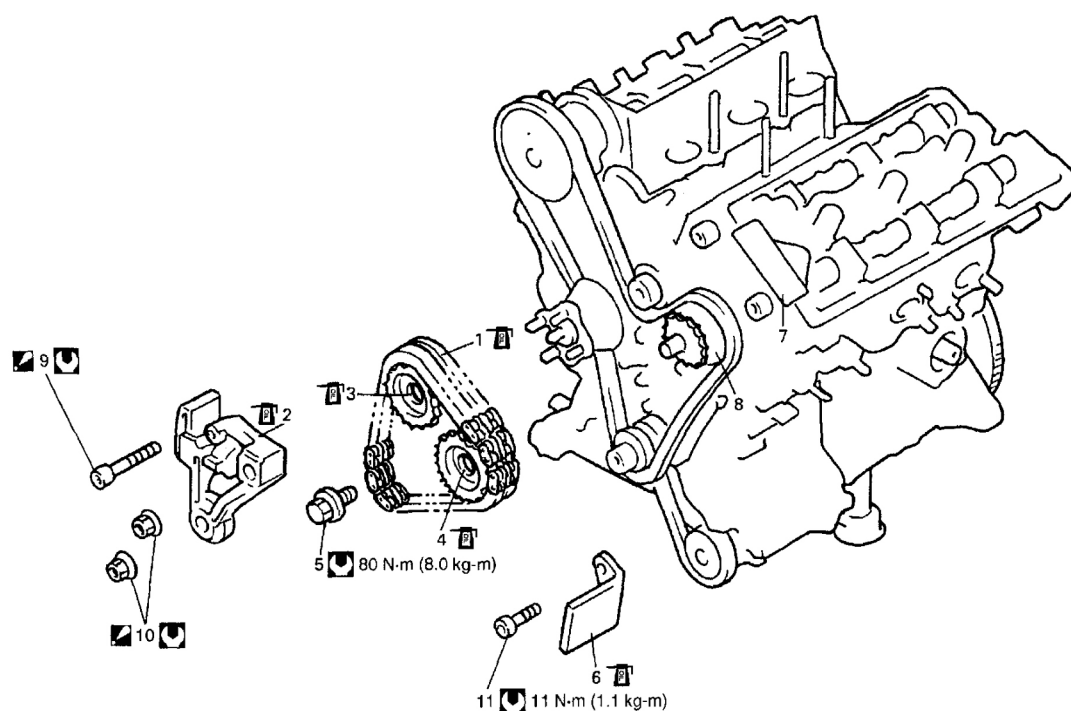
G02263923

Fig. 56: Identifying Bolt For Fixing Special Tool To Crankshaft Pulley
Courtesy of SUZUKI OF AMERICA CORP.

TIMING CHAIN COVER INSPECTION

Check oil seal lip for damages or deterioration. Replace as necessary.

LH (NO. 1) BANK 2ND TIMING CHAIN & CHAIN TENSIONER COMPONENTS



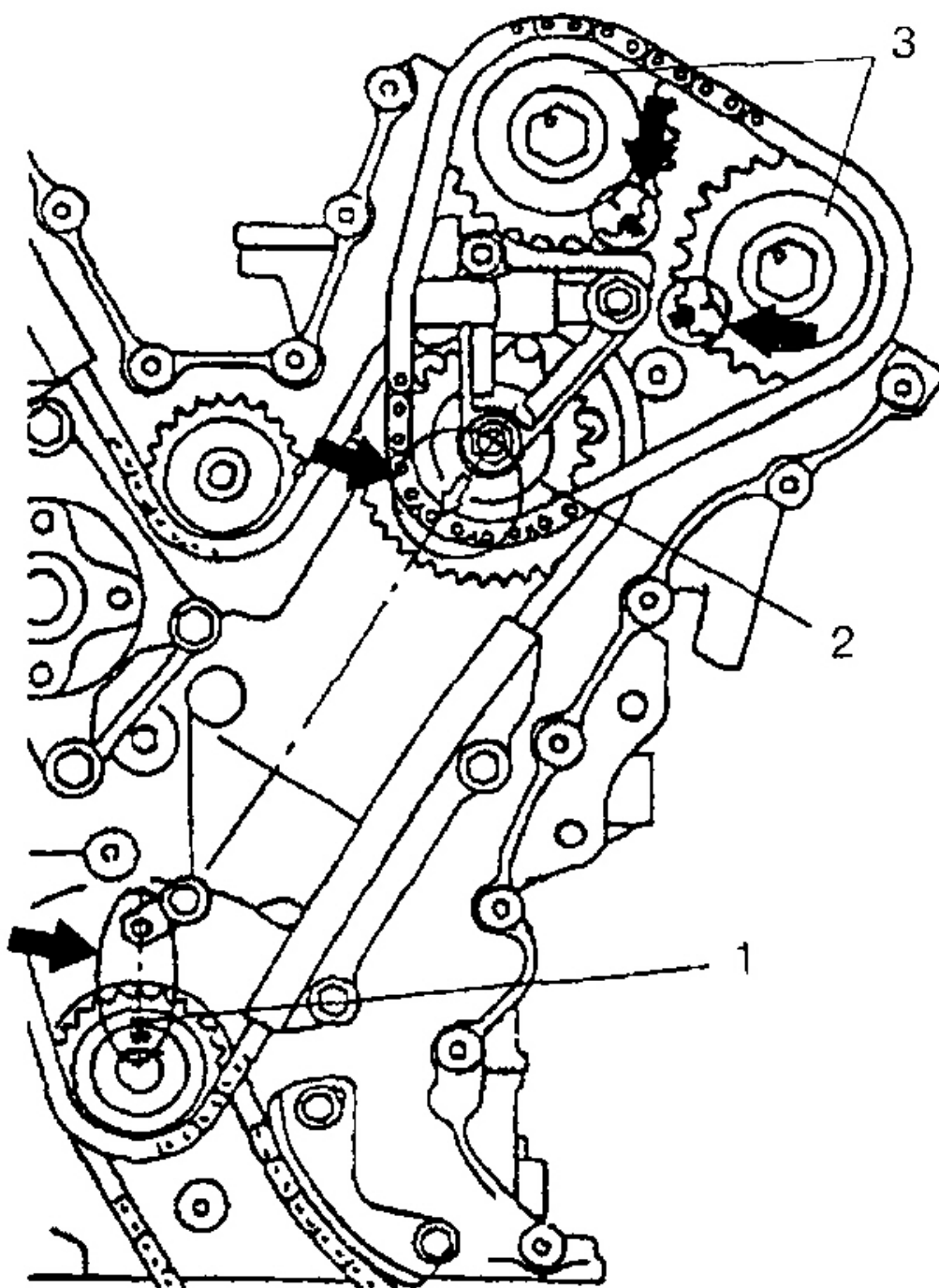
1. LH bank 2nd timing chain	6. Timing chain guide No.4	11. Timing chain guide No. 4 bolt
2. Timing chain tensioner adjuster No.3	7. Timing chain guide No.5	: Apply engine oil to sliding surface of each point.
3. LH bank intake camshaft sprocket	8. Idler sprocket No.2	: Tightening torque
4. LH bank exhaust camshaft sprocket	9. Timing chain tensioner adjuster No. 3 bolt : Tighten 11 N· m (1.1 kg-m, 8.0 lb-ft) by the specified procedure	
5. Camshaft sprocket bolt	10. Timing chain tensioner adjuster No. 3 nut : Tighten 45 N· m (4.5 kg-m, 32.5 lb-ft) by the specified procedure	

G02263924

Fig. 57: Exploded View Of LH (No. 1) Bank 2nd Timing Chain & Chain Tensioner Components
 Courtesy of SUZUKI OF AMERICA CORP.

LH (NO. 1) BANK 2ND TIMING CHAIN & CHAIN TENSIONER REMOVAL

1. Disconnect negative (-) cable at battery.
2. Drain engine oil.
3. Drain coolant referring to **COOLANT DRAINING**.
4. Remove timing chain cover. Refer to **TIMING CHAIN COVER REMOVAL & INSTALLATION**.
5. Turn crankshaft to meet the following condition.
 - Key (1) on crankshaft positions as shown.
 - Arrow mark on idler sprocket No. 2 (2) points the center of crankshaft.
 - The marks on sprockets (3) match with marks on cylinder head.



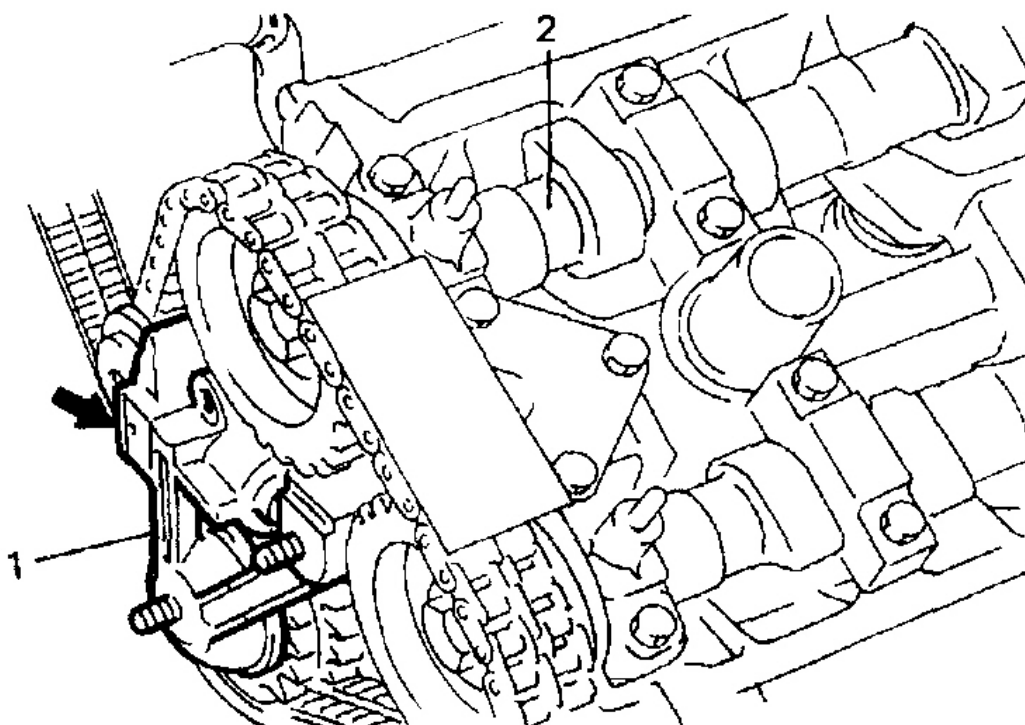
G02263925

Fig. 58: Aligning Timing Marks

Courtesy of SUZUKI OF AMERICA CORP.

6. Remove timing chain tensioner adjuster No. 3 (1).

To remove it, slacken LH bank 2nd timing chain by turning intake camshaft (2) counterclockwise a little while pushing back pad.



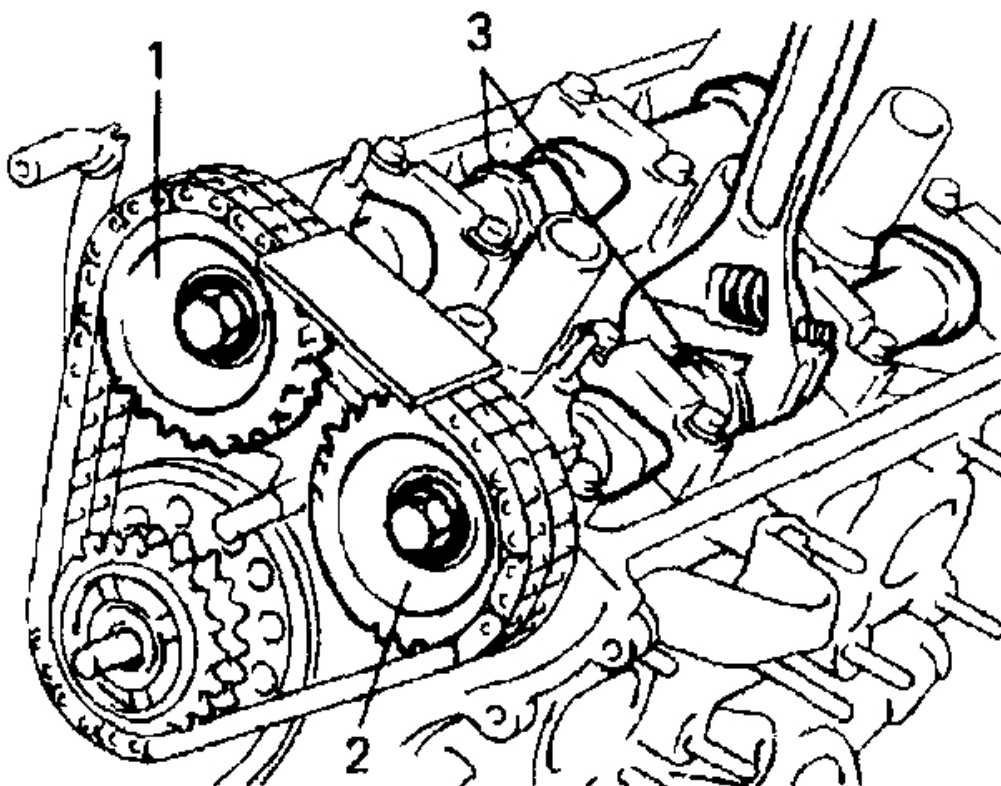
G02263926

Fig. 59: Removing Timing Chain Tensioner Adjuster No. 3

Courtesy of SUZUKI OF AMERICA CORP.

7. Remove LH bank intake and exhaust camshaft sprocket bolts.

To remove it, fit a spanner to hexagonal part (3) at the center of camshaft to hold it stationary.



1. LH bank intake camshaft sprocket

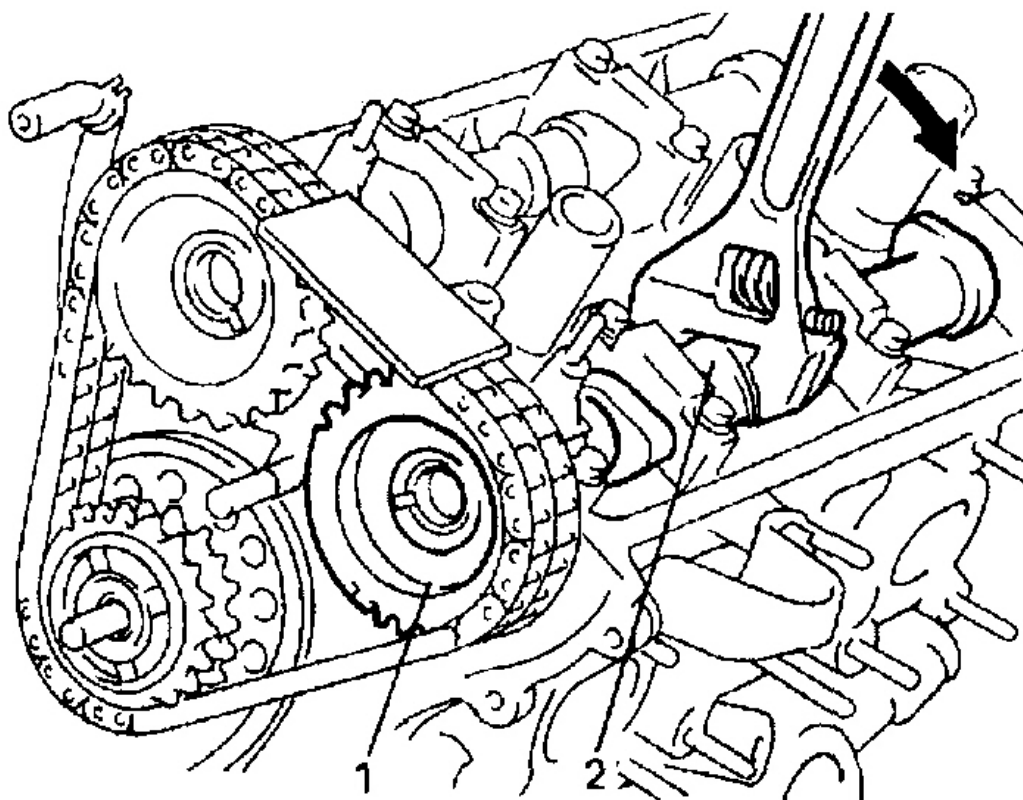
2. LH bank exhaust camshaft sprocket

G02263927

Fig. 60: Removing LH Bank Intake & Exhaust Camshaft Sprocket Bolts
Courtesy of SUZUKI OF AMERICA CORP.

8. Remove LH bank exhaust camshaft sprocket (1).

CAUTION: Removing sprocket (1) from camshaft (2) may cause cam to turn, resulting in damage to valve and piston. To prevent this, when removing sprocket, hold camshaft stationary by using a spanner at its hexagonal part.



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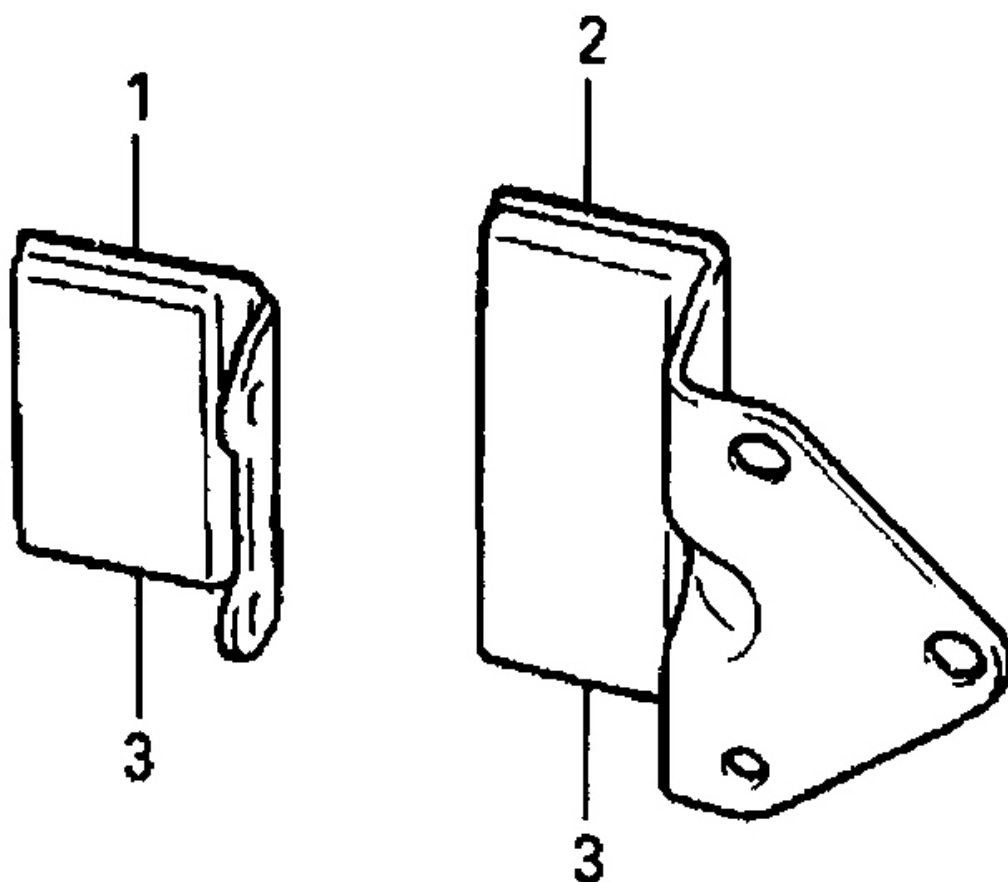
Fig. 61: Removing LH Bank Exhaust Camshaft Sprocket
Courtesy of SUZUKI OF AMERICA CORP.

9. Remove LH bank intake camshaft sprocket.
10. Remove LH bank 2nd timing chain.

LH (NO. 1) BANK 2ND TIMING CHAIN & CHAIN TENSIONER INSPECTION

Timing Chain Guide No. 4 & No. 5

Check shoe (3) for wear or damage.



1. Timing chain guide No.4

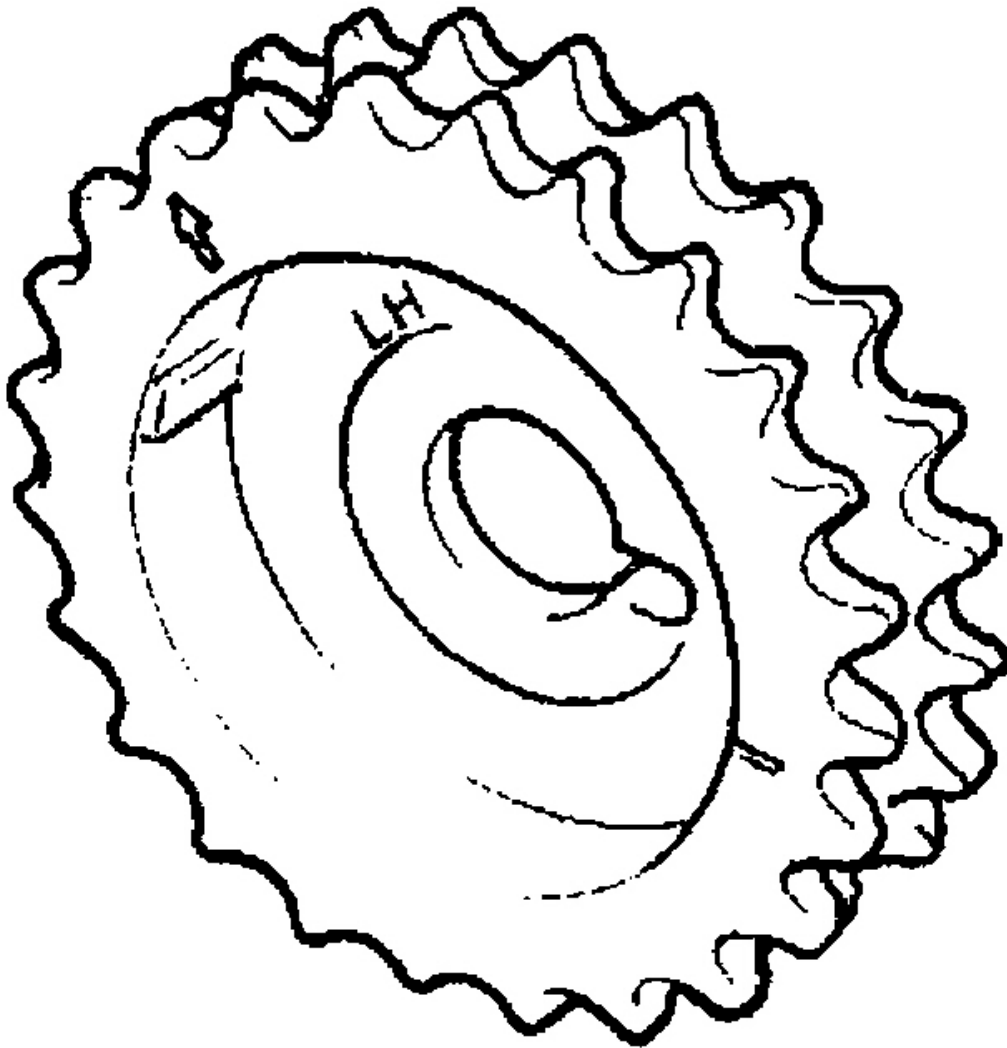
2. Timing chain guide No.5

G02263929

Fig. 62: Checking Timing Chain Guide No. 4 & No. 5
Courtesy of SUZUKI OF AMERICA CORP.

Camshaft Sprocket

Check teeth of sprocket for wear or damage.

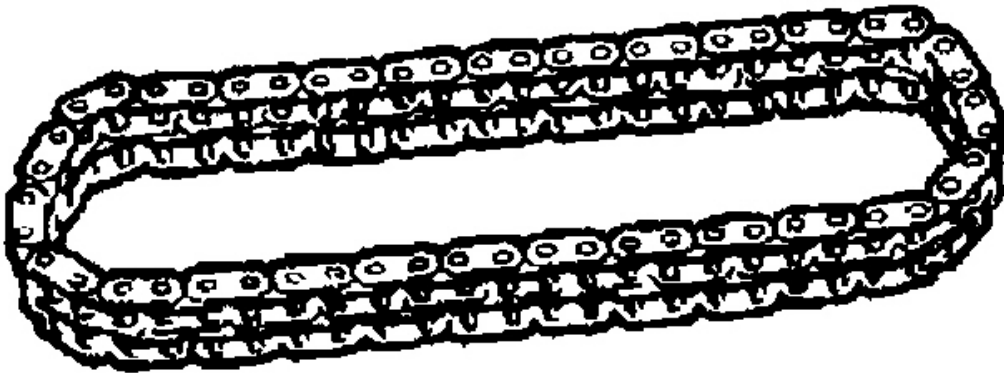


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Fig. 63: Checking Camshaft Sprocket
Courtesy of SUZUKI OF AMERICA CORP.

Timing Chain

Check timing chain for wear or damage.



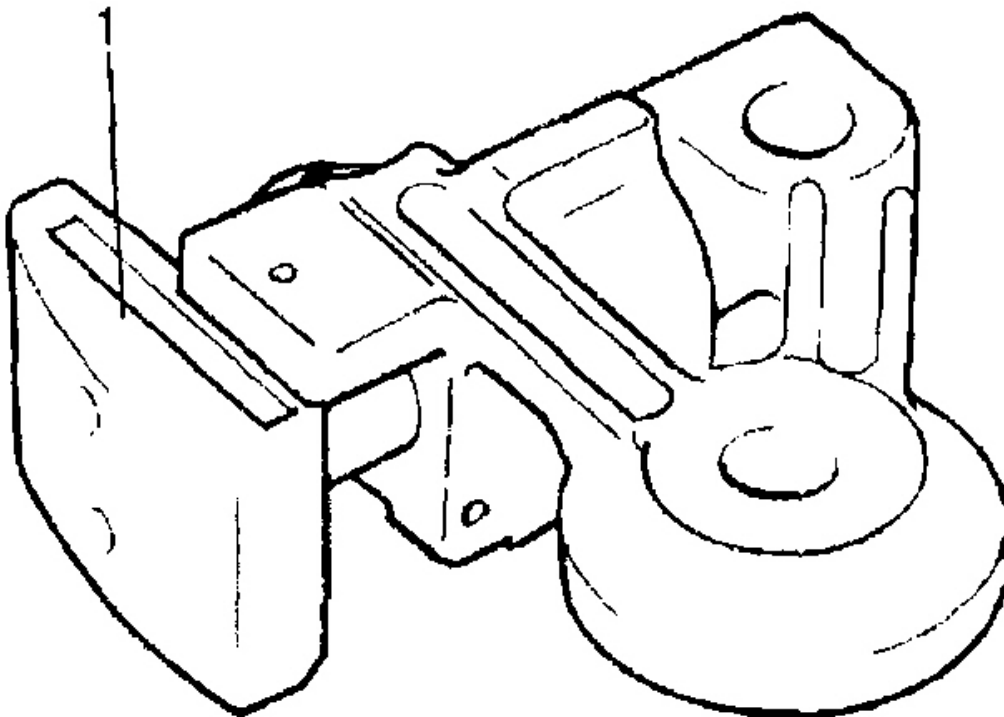
G02263931

Fig. 64: Checking Timing Chain

Courtesy of SUZUKI OF AMERICA CORP.

Tensioner Adjuster No. 3

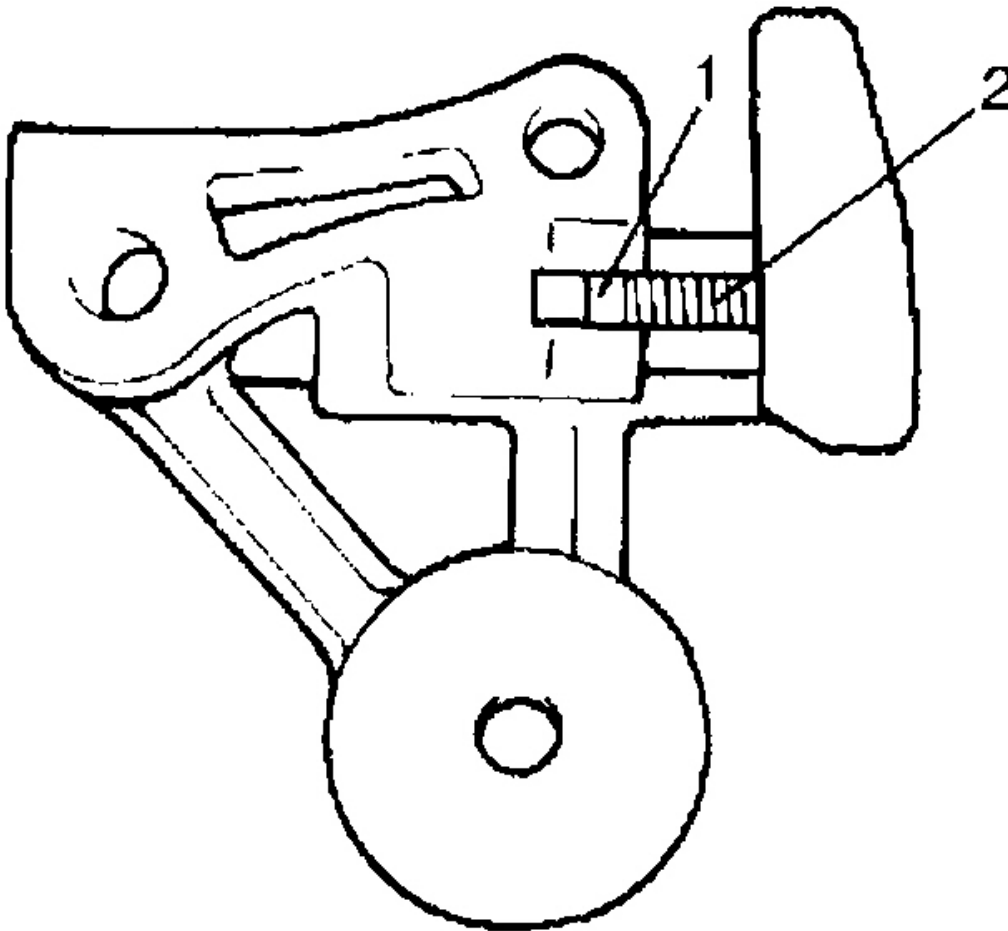
- Check shoe (1) for wear or damage.



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Fig. 65: Checking Tensioner Adjuster No. 3 Shoe
Courtesy of SUZUKI OF AMERICA CORP.

- Check that latch (1) and tooth surface (2) are free from damage and latch functions properly.

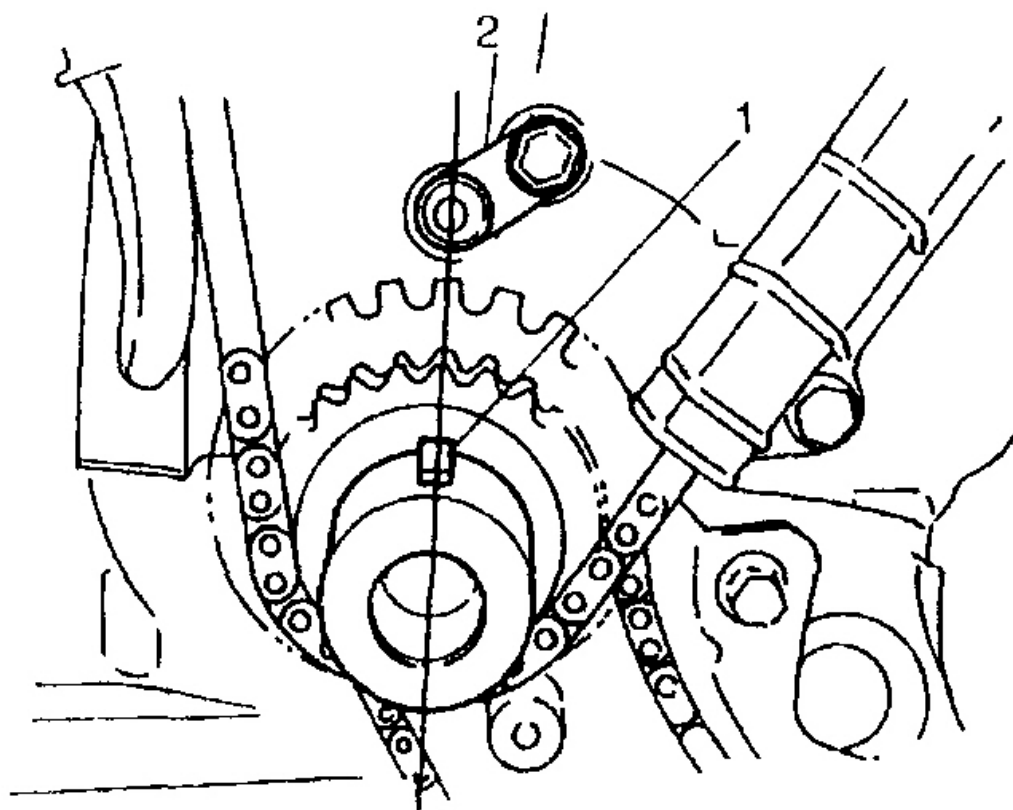


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Fig. 66: Checking Tensioner Adjuster No. 3 Latch & Tooth Surface
Courtesy of SUZUKI OF AMERICA CORP.

LH (NO. 1) BANK 2ND TIMING CHAIN & CHAIN TENSIONER INSTALLATION

1. Check timing mark on crankshaft as shown in the figure.

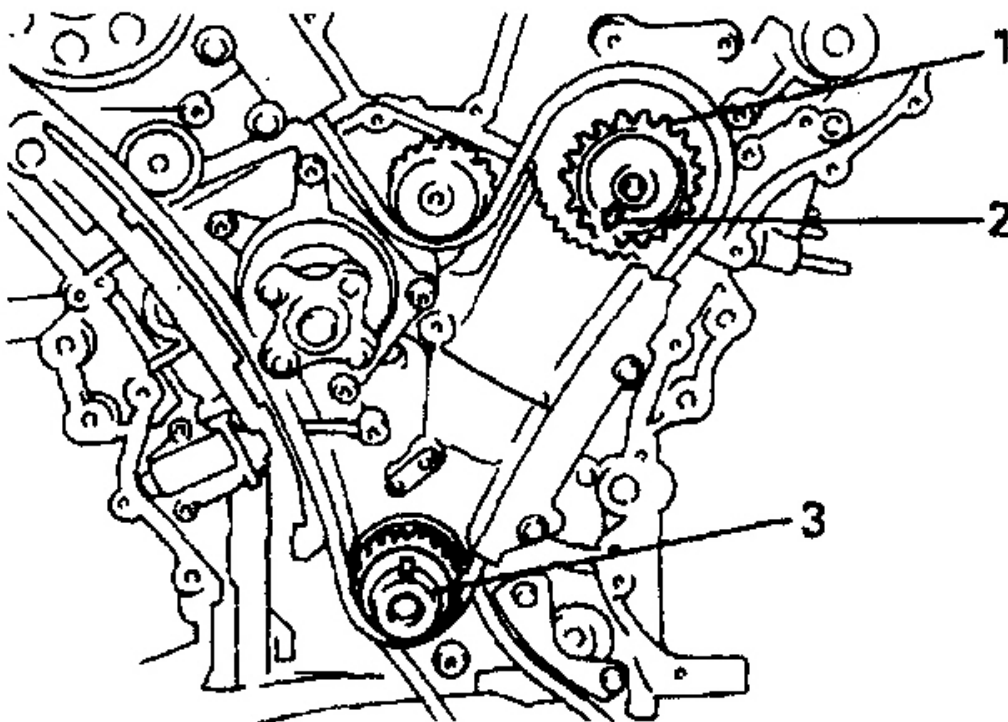


1. Crank timing pulley key
2. Oil jet

G02263934

Fig. 67: Checking Timing Mark On Crankshaft
Courtesy of SUZUKI OF AMERICA CORP.

2. Check timing mark on idler sprocket No. 2 (1) as shown in the figure.



2. Match mark of idler sprocket No.2

3. Crankshaft

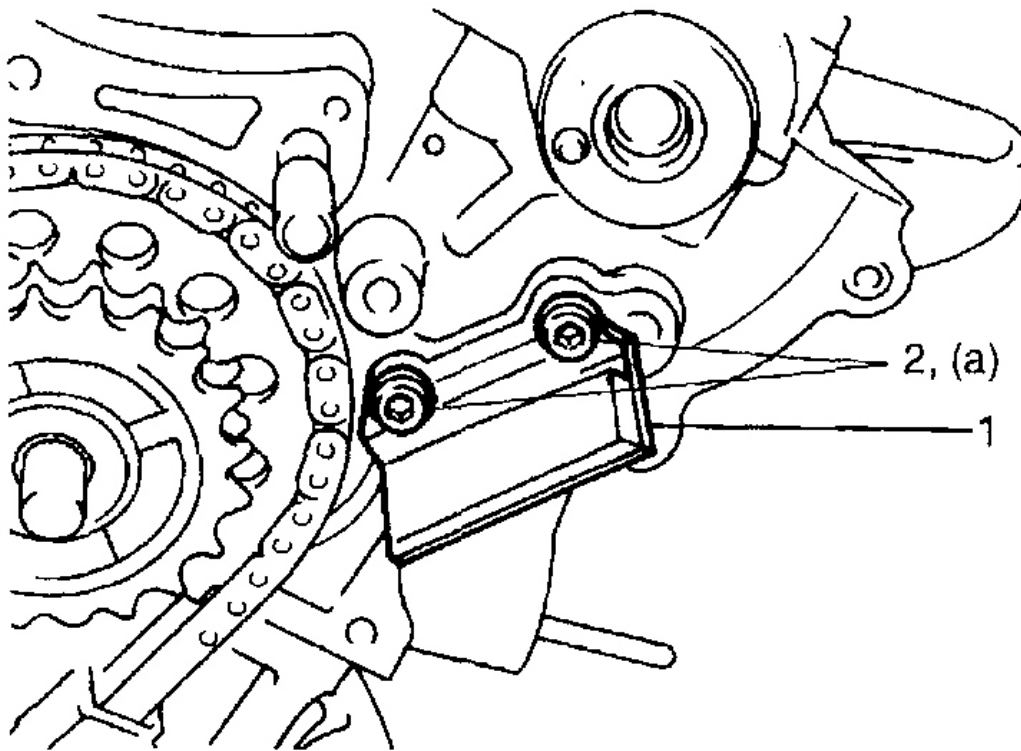
G02263935

Fig. 68: Checking Timing Mark On Idler Sprocket No. 2
Courtesy of SUZUKI OF AMERICA CORP.

3. Install timing chain guide No. 4 (1).

Tightening torque

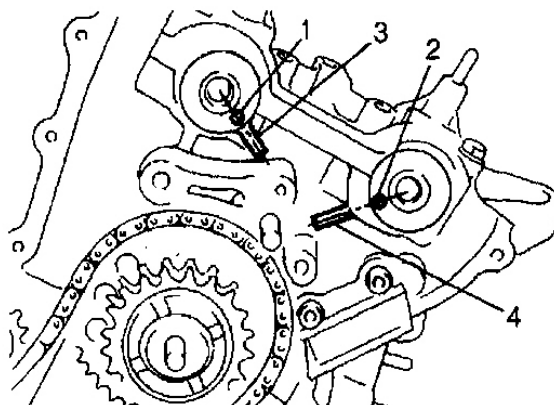
Timing chain guide No. 4 bolt (a): 11 N.m (1.1 kg-m, 8.0 lb-ft)

**2. Bolts**

G02263936

Fig. 69: Installing Timing Chain Guide No. 4
Courtesy of SUZUKI OF AMERICA CORP.

4. Check that knock-pins of intake and exhaust camshafts are aligned with match marks on cylinder head as shown in the figure.



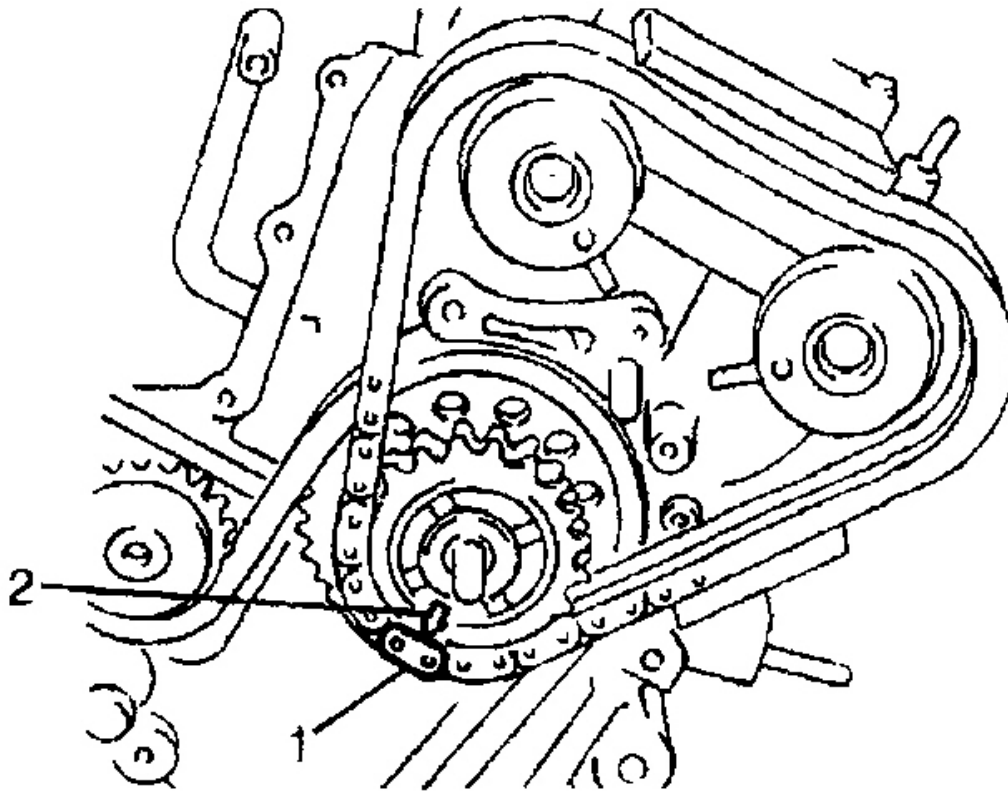
1. Knock pin of LH bank intake camshaft	3. Match mark of intake side
2. Knock pin of LH bank exhaust camshaft	4. Match mark of exhaust side

G02263937

Fig. 70: Checking That Knock-Pins Of Intake & Exhaust Camshafts Are Aligned With Match Marks On Cylinder Head

Courtesy of SUZUKI OF AMERICA CORP.

5. Install by aligning match marks (2) on yellow plate (1) of LH bank 2nd timing chain and idler sprocket No. 2.



G02263938

Fig. 71: Aligning Match Marks On Yellow Plate Of LH Bank 2nd Timing Chain & Idler Sprocket No. 2

Courtesy of SUZUKI OF AMERICA CORP.

6. Install sprockets to intake and exhaust camshafts by aligning silver plate (1) of LH bank 2nd timing chain, match marks on intake sprocket and exhaust sprocket respectively.

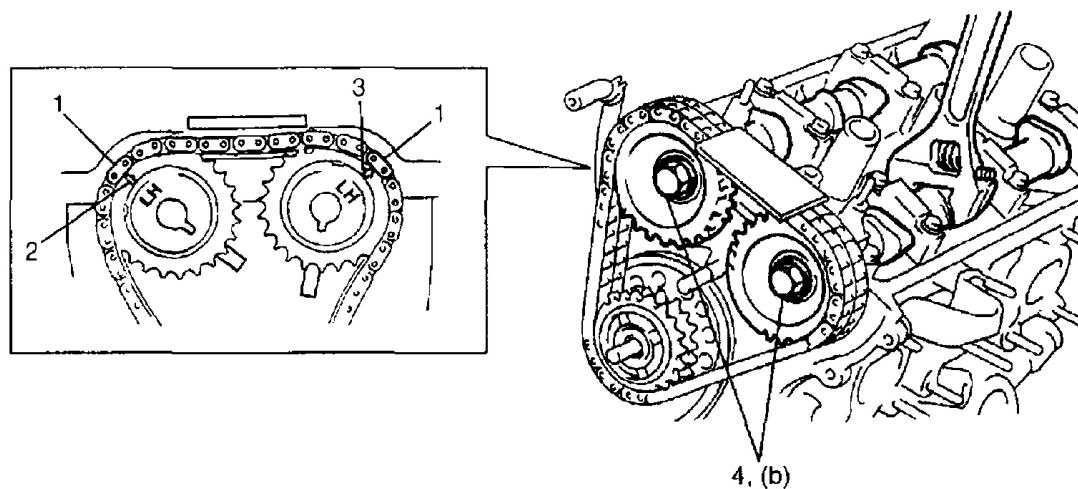
CAUTION: Do not turn camshaft more than necessary. If turned excessively, valve and piston may get damaged.

7. Install LH bank intake and exhaust camshaft timing sprockets.

To install it, fit a spanner to hexagonal part at the center of camshaft to hold stationary.

Tightening torque

Camshaft timing sprocket bolt (b): 80 N.m (8.0 kg-m, 58.0 lb-ft)



- | |
|---|
| 2. Arrow mark on intake camshaft timing sprocket |
| 3. Arrow mark on exhaust camshaft timing sprocket |
| 4. Sprocket bolt |

G02263939

Fig. 72: Installing LH Bank Intake & Exhaust Camshaft Timing Sprockets
Courtesy of SUZUKI OF AMERICA CORP.

8. With latch (2) of tensioner adjuster No. 3 returned and plunger (1) pushed back into body, insert stopper (pin) (4) into set hole (3).

After inserting it, check to make sure that plunger will not come out.

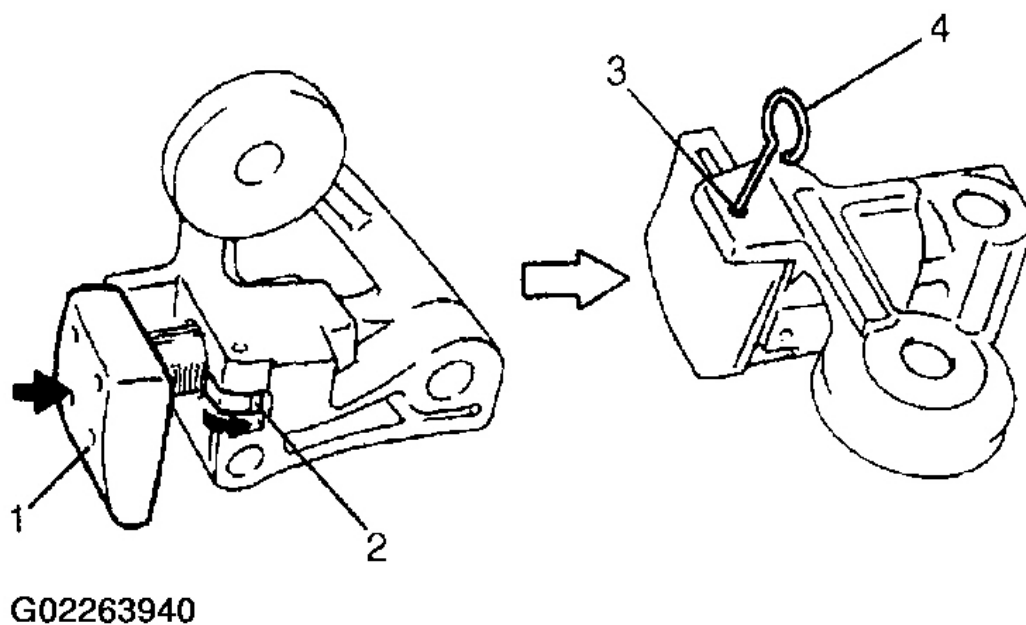


Fig. 73: Collapsing & Locking Tensioner Adjuster No. 3

Courtesy of SUZUKI OF AMERICA CORP.

9. Install timing chain tensioner adjuster No. 3 (1) in tightening order below.

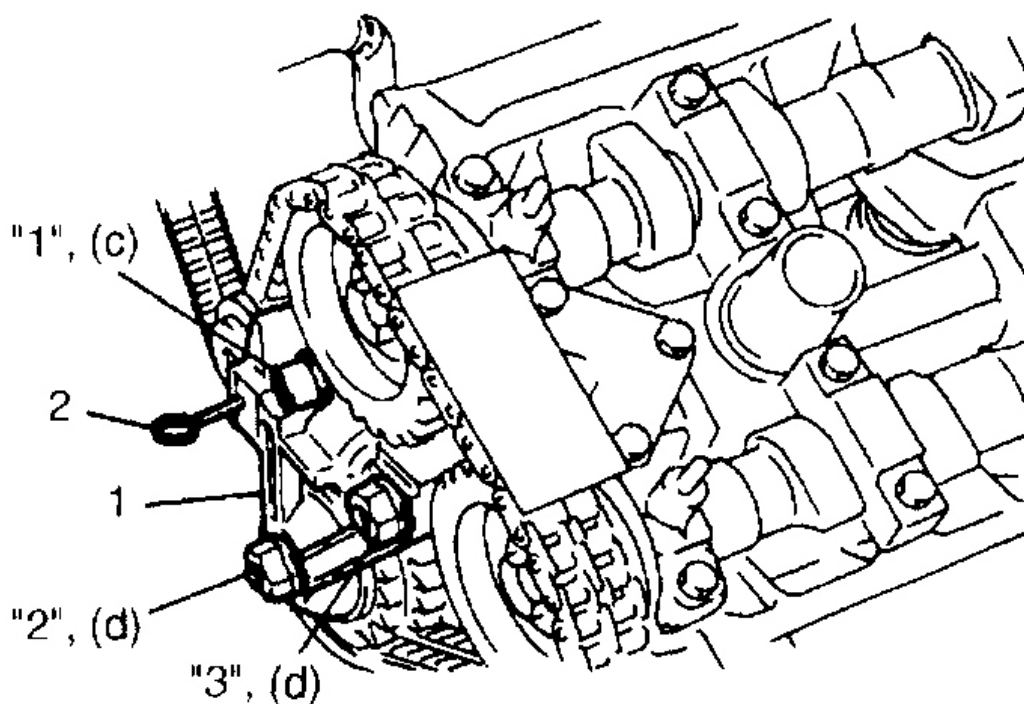
Tightening torque

Timing chain tensioner adjuster No. 3 bolt (c): Tighten 11 N. m (1.1 kg-m, 7.5 lb-ft) by the specified procedure

Timing chain tensioner adjuster No. 3 nut (d): Tighten 55 N. m (5.5 kg-m, 40.0 lb-ft) by the specified procedure

Tightening order for tensioner bolt and nuts: "1" -->"2" -->"3"

10. Pull out stopper (pin) (2) from set hole.

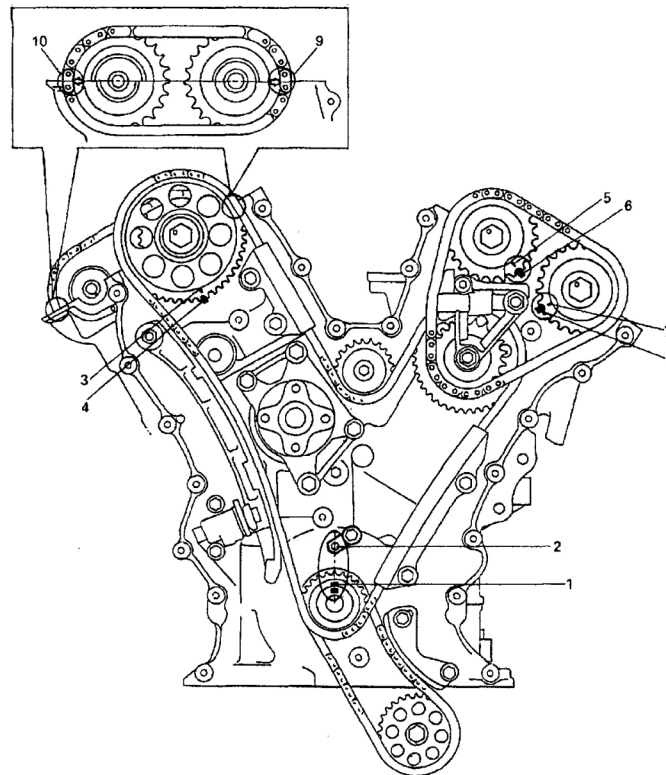


G02263941

Fig. 74: Installing Timing Chain Tensioner Adjuster No. 3
Courtesy of SUZUKI OF AMERICA CORP.

11. Turn crankshaft two rotations clockwise then align timing mark on crankshaft and timing mark on cylinder block as shown in figure.

Check each other timing marks that align them shown in the figure.



1. Crank timing pulley key	5. Timing mark of LH bank 2nd timing chain intake sprocket	9. Timing mark of RH bank 2nd timing chain intake sprocket
2. Oil jet	6. Timing mark of LH bank 2nd timing chain	10. Timing mark of RH bank 2nd timing chain exhaust sprocket
3. Timing mark of RH bank 1st timing chain sprocket	7. Timing mark of LH bank 2nd timing chain exhaust sprocket	
4. Timing mark of RH bank 1st timing chain	8. Timing mark of LH bank 2nd timing chain	

G02263942

Fig. 75: Identifying Timing Chain Marks
Courtesy of SUZUKI OF AMERICA CORP.

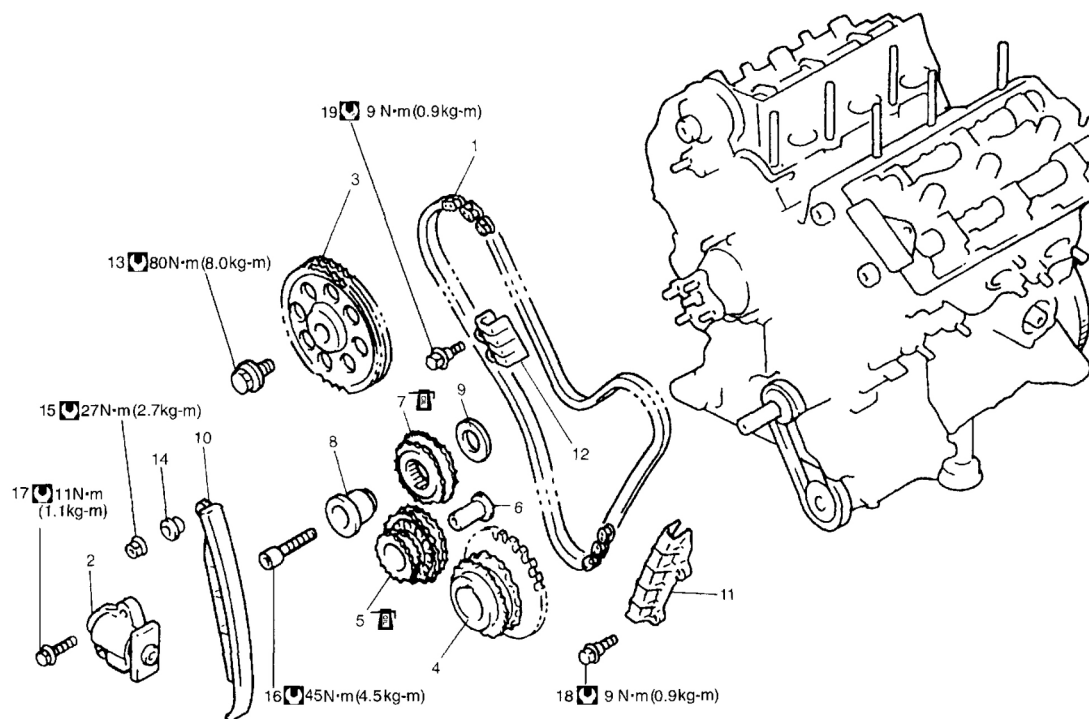
12. Apply oil to timing chains, tensioner adjusters sprockets and guides.
13. Install timing chain cover referring to **TIMING CHAIN COVER REMOVAL & INSTALLATION**.
14. Install oil pan referring to **OIL PAN & OIL PUMP STRAINER REMOVAL & INSTALLATION**.
15. Install front differential referring to **FRONT DIFFERENTIAL DISMOUNTING & REMOUNTING**.
16. Install P/S system referring to **P/S PUMP REMOVAL & INSTALLATION**.
17. Install cooling system referring to **COOLING FAN & FAN CLUTCH REMOVAL & INSTALLATION** and **RADIATOR REMOVAL & INSTALLATION**.
18. Install intake manifold with throttle body.

Refer to **THROTTLE BODY & INTAKE MANIFOLD REMOVAL & INSTALLATION (H25 ENGINE)**.

19. Refill coolant referring to **COOLING SYSTEM FLUSH & REFILL**.
20. Refill engine oil.

21. Refill P/S fluid and bleed air in P/S system referring to **P/S SYSTEM AIR BLEEDING PROCEDURE**.
22. Check wheel alignment referring to **SPECIFICATIONS & PROCEDURES**.
23. Verify that there is no fuel leakage, water leakage and oil leakage at each connection.

1ST TIMING CHAIN & CHAIN TENSIONER COMPONENTS



1. 1st timing chain	8. Shaft	15. Timing chain tensioner nut
2. Timing chain tensioner adjuster No.1	9. Washer	16. Idler sprocket No.1 bolt
3. RH bank 1st timing chain intake camshaft sprocket	10. Timing chain tensioner	17. Timing tensioner adjuster No.1 bolt
4. 1st timing chain crankshaft sprocket	11. Timing chain guide No.1	18. Timing chain guide No.1 bolt
5. Idler sprocket No.2	12. Timing chain guide No.2	19. Timing chain guide No.2 bolt
6. Shaft	13. Camshaft sprocket bolt	⌚ : Tightening torque
7. Idler sprocket No.1	14. Spacer	🛢 : Apply engine oil to sliding parts.

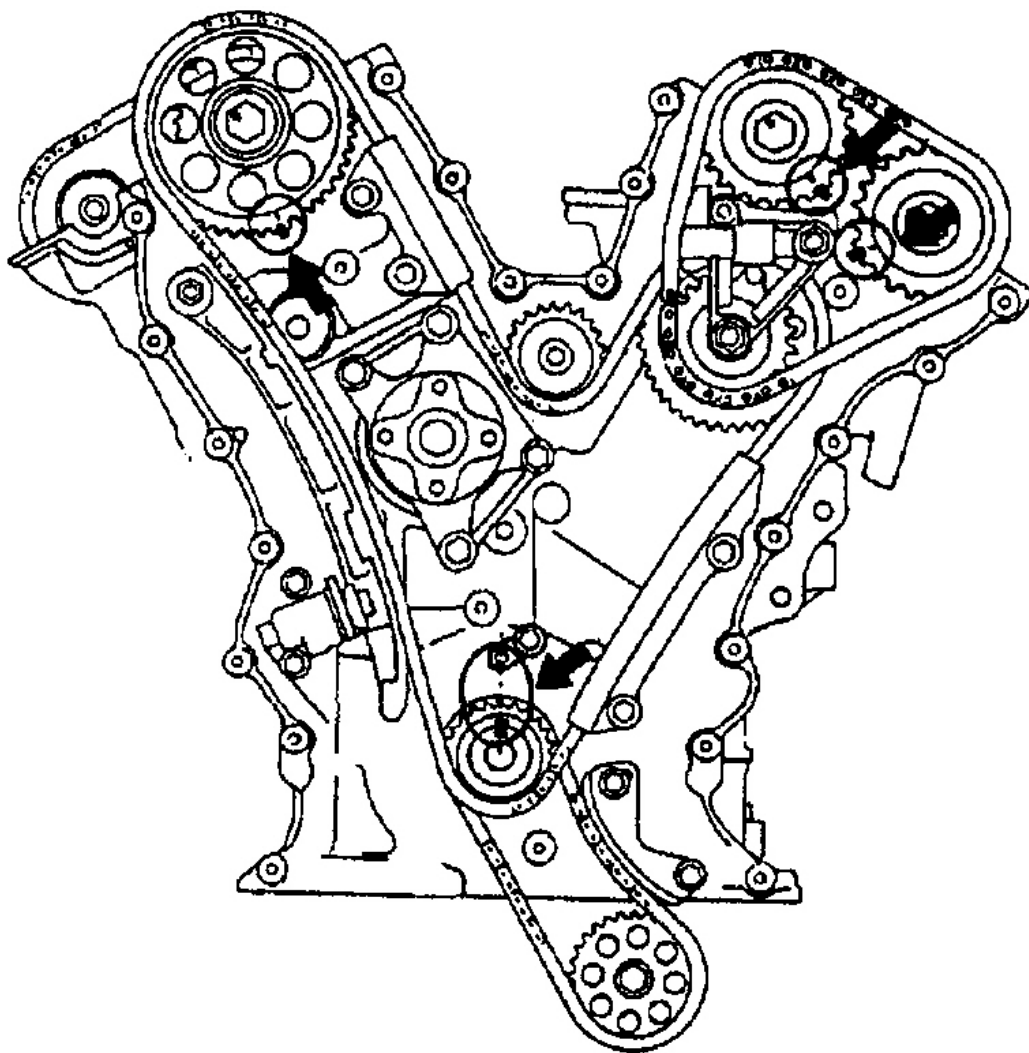
G02263943

Fig. 76: Exploded View Of 1st Timing Chain & Chain Tensioner Components
 Courtesy of SUZUKI OF AMERICA CORP.

1ST TIMING CHAIN & CHAIN TENSIONER REMOVAL

1. Disconnect negative cable at battery.
2. Drain engine oil.
3. Drain coolant referring to **COOLANT DRAINING**.
4. Remove timing chain cover. Refer to **TIMING CHAIN COVER REMOVAL & INSTALLATION**.

5. For reinstallation of timing chain, align 8 timing marks as shown in the figure by turning crankshaft.

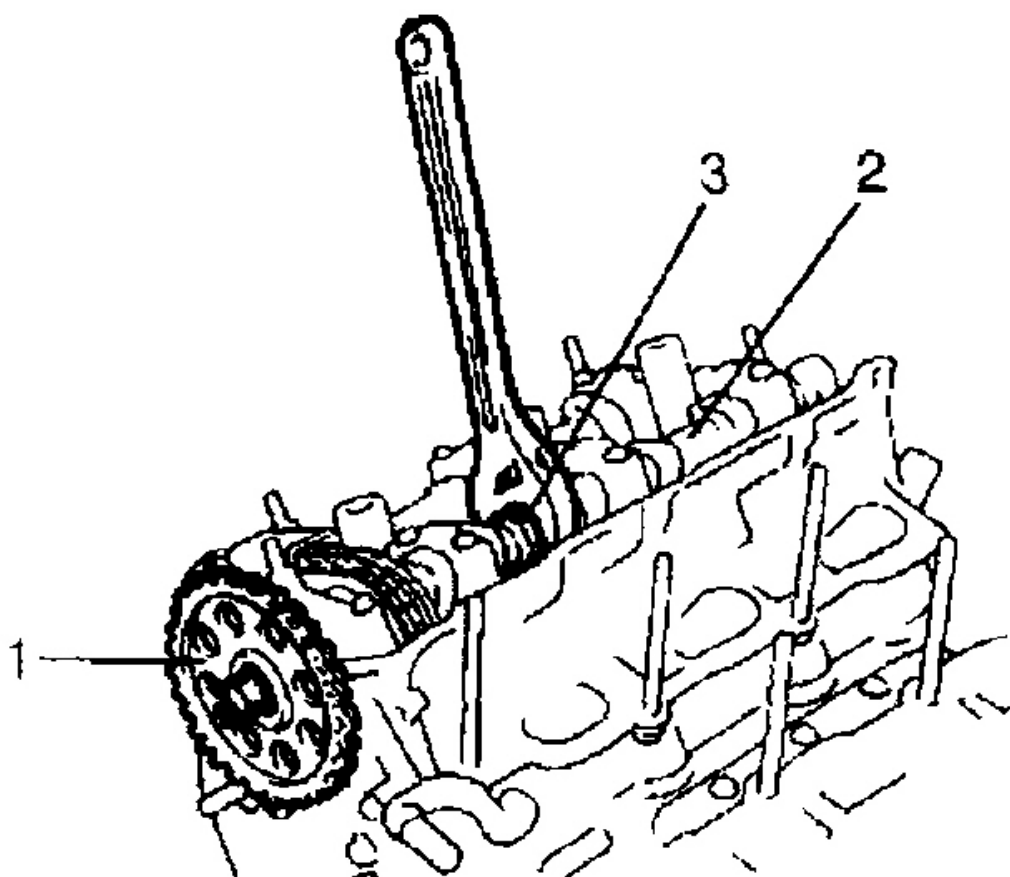


G02263944

Fig. 77: Identifying Timing Chain Marks
Courtesy of SUZUKI OF AMERICA CORP.

6. Remove LH bank 2nd timing chain. Refer to **LH (NO. 1) BANK 2ND TIMING CHAIN & CHAIN TENSIONER REMOVAL** .
7. Remove the following parts referring to **1ST TIMING CHAIN & CHAIN TENSIONER COMPONENTS** .
- Timing chain guide No. 1 and No. 2.

- Timing chain tensioner.
 - Timing chain tensioner adjuster.
 - Idler sprocket No. 1 and 1st timing chain.
 - Idler sprocket No. 2 and sprocket shaft.
8. Remove RH bank 1st timing chain intake camshaft sprocket bolt. To remove it, fit a spanner to hexagonal part (3) at the center of camshaft (2) to hold it stationary.
 9. Remove RH bank 1st timing chain intake camshaft sprocket (1).



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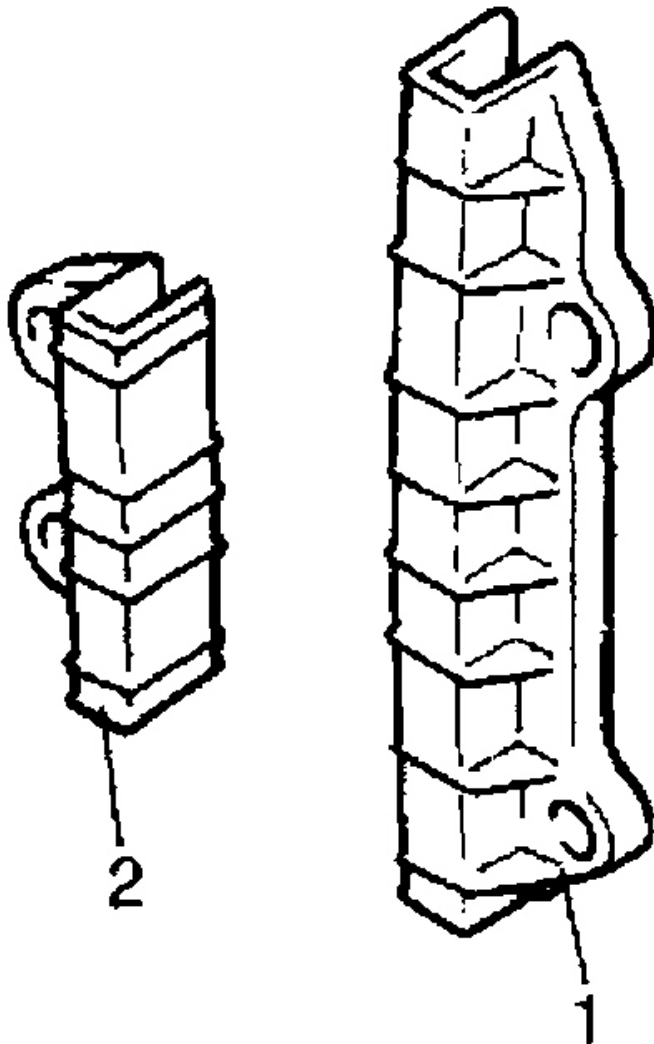
Fig. 78: Remove RH Bank 1st Timing Chain Intake Camshaft Sprocket & Bolt
Courtesy of SUZUKI OF AMERICA CORP.

10. Remove 1st timing chain crankshaft sprocket.

1ST TIMING CHAIN & CHAIN TENSIONER INSPECTION

Timing Chain Guides No. 1 & No. 2

Check shoe for excessive wear or damage. If any malfunction is found, replace it.



1. Timing chain guide No.1

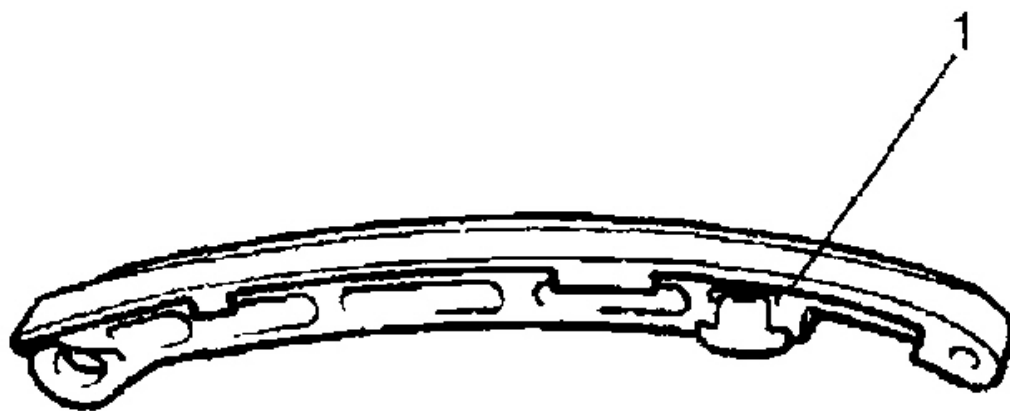
2. Timing chain guide No.2

G02263946

Fig. 79: Checking Timing Chain Guides No. 1 & No. 2 Shoe
Courtesy of SUZUKI OF AMERICA CORP.

Timing Chain Tensioner

Check shoe (1) for wear or damage. If any malfunction is found, replace it.

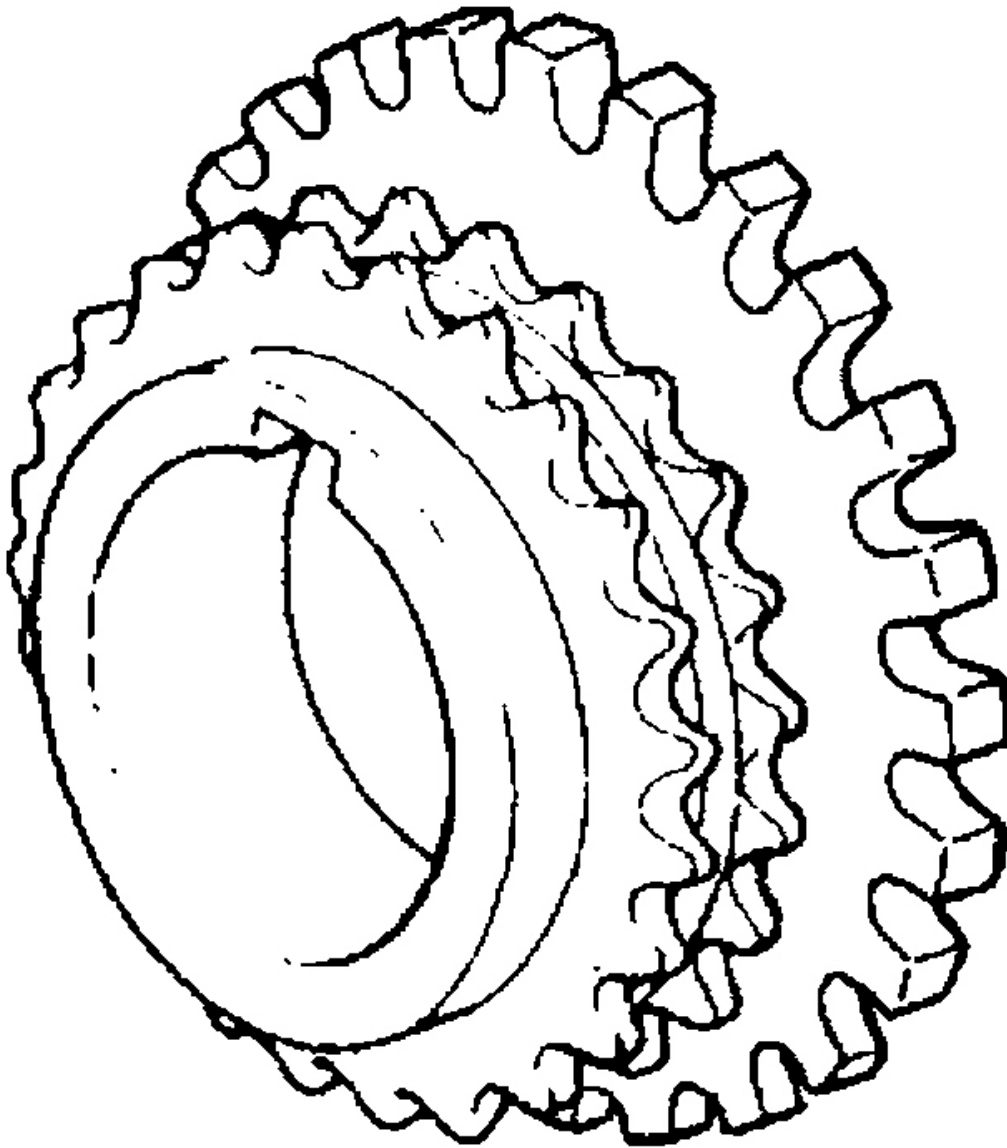


G02263947

Fig. 80: Checking Timing Chain Tensioner Shoe
Courtesy of SUZUKI OF AMERICA CORP.

1st Timing Chain Crankshaft Sprocket

Check teeth of sprocket for wear or damage. If any malfunction is found, replace it.

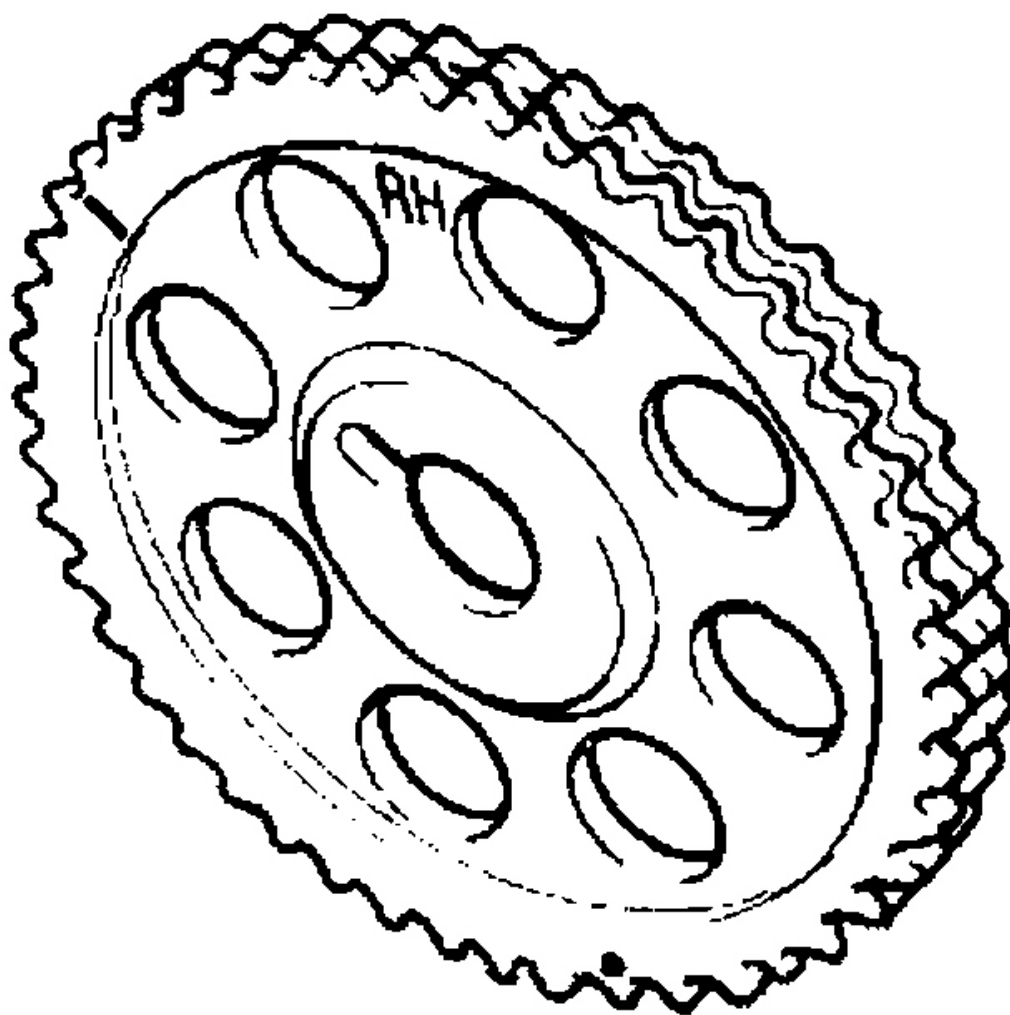


G02263948

Fig. 81: Checking 1st Timing Chain Crankshaft Sprocket
Courtesy of SUZUKI OF AMERICA CORP.

RH Bank 1st Timing Chain Intake Camshaft Sprocket

Check teeth of sprocket for wear or damage. If any malfunction is found, replace it.



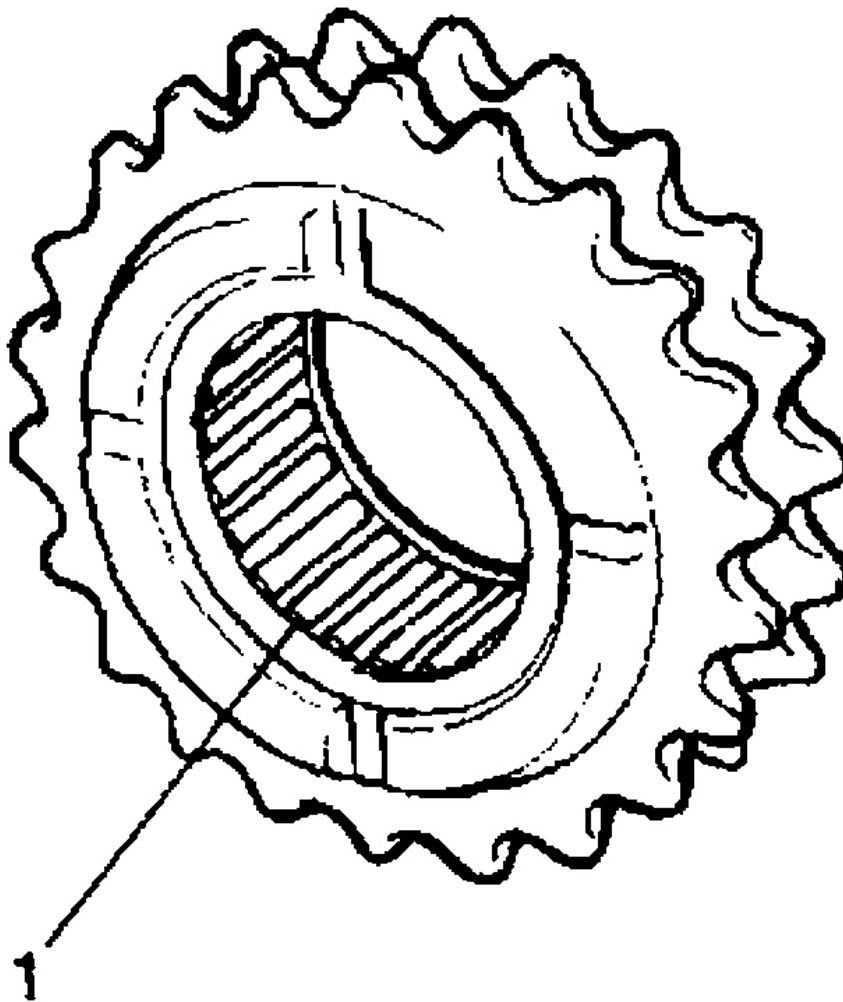
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Fig. 82: Checking RH Bank 1st Timing Chain Intake Camshaft Sprocket
Courtesy of SUZUKI OF AMERICA CORP.

Idler Sprocket No. 1

Check teeth of sprocket for wear or damage.

If any malfunction is found, replace it.



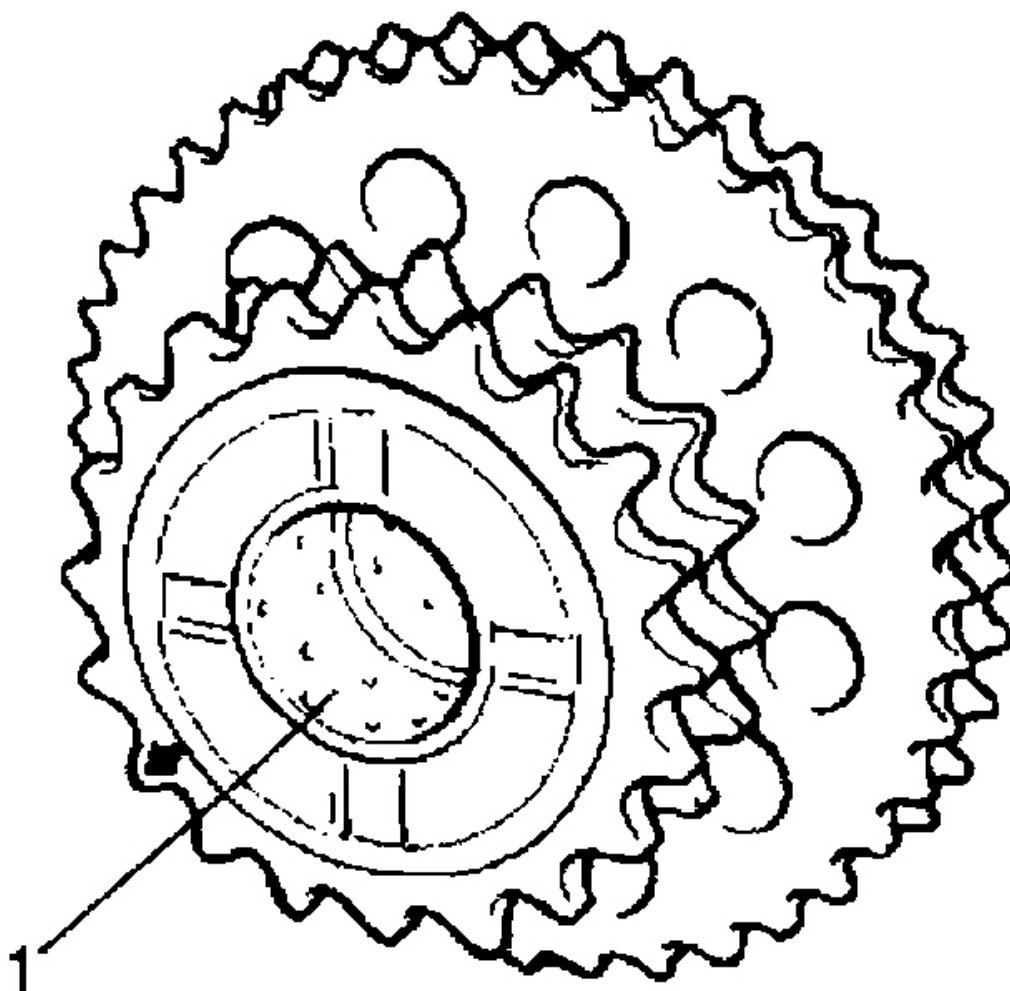
1. Bearing

G02263950

Fig. 83: Checking Idler Sprocket No. 1
Courtesy of SUZUKI OF AMERICA CORP.

Idler Sprocket No . 2

Check teeth of sprocket for wear or damage. If any malfunction is found, replace it.



1. Bush

G02263951

Fig. 84: Checking Idler Sprocket No. 2
Courtesy of SUZUKI OF AMERICA CORP.

1st Timing Chain

Check timing chain for wear or damage. If any malfunction is found, replace it.

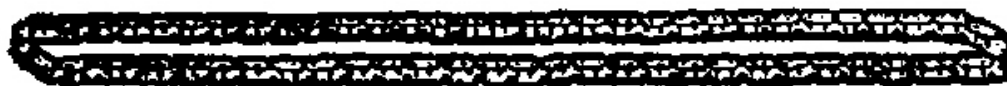
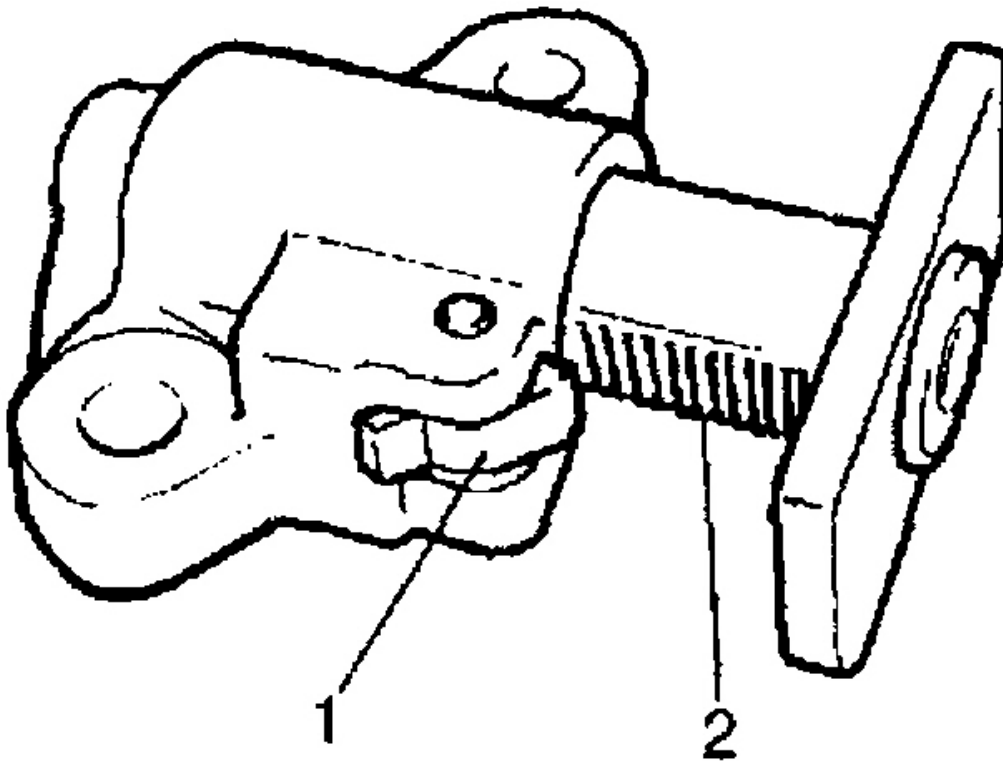
**G02263952**

Fig. 85: Checking 1st Timing Chain
Courtesy of SUZUKI OF AMERICA CORP.

Timing Chain Tensioner Adjuster No. 1

Check that latch (1) and tooth surface (2) are free from damage and latch functions properly. If any malfunction is found, replace it.

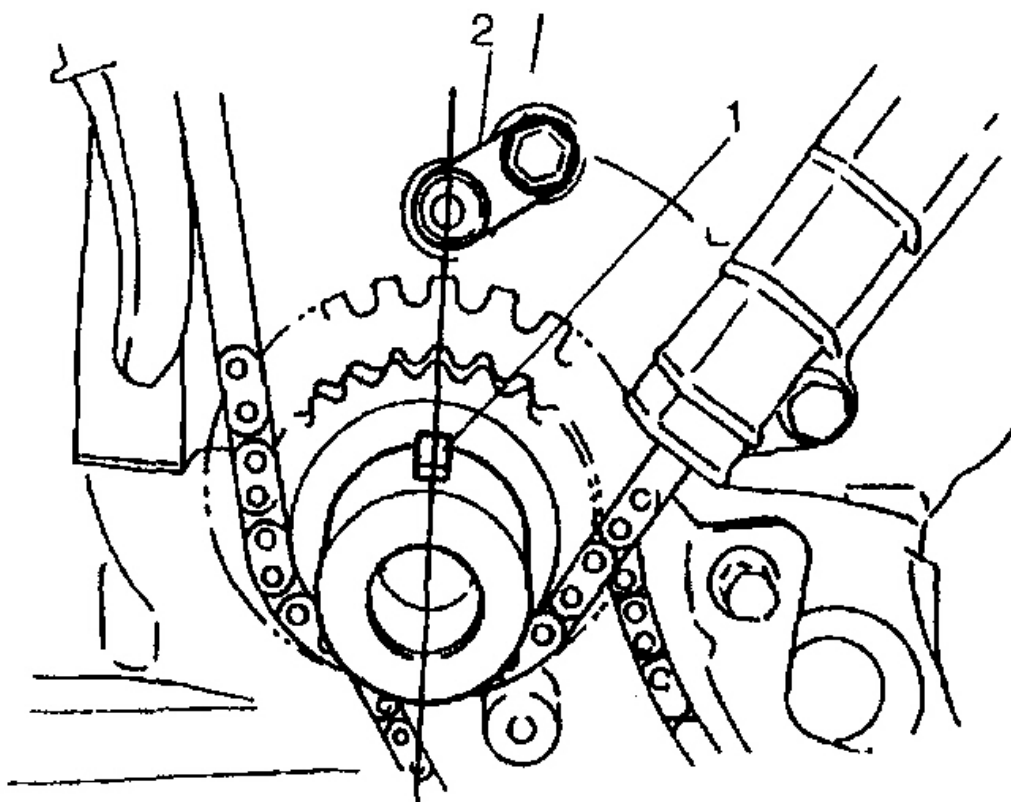


G02263953

Fig. 86: Checking Timing Chain Tensioner Adjuster No. 1 Latch & Tooth Surface
Courtesy of SUZUKI OF AMERICA CORP.

1ST TIMING CHAIN & CHAIN TENSIONER INSTALLATION

1. Check timing mark on crankshaft as shown in the figure.

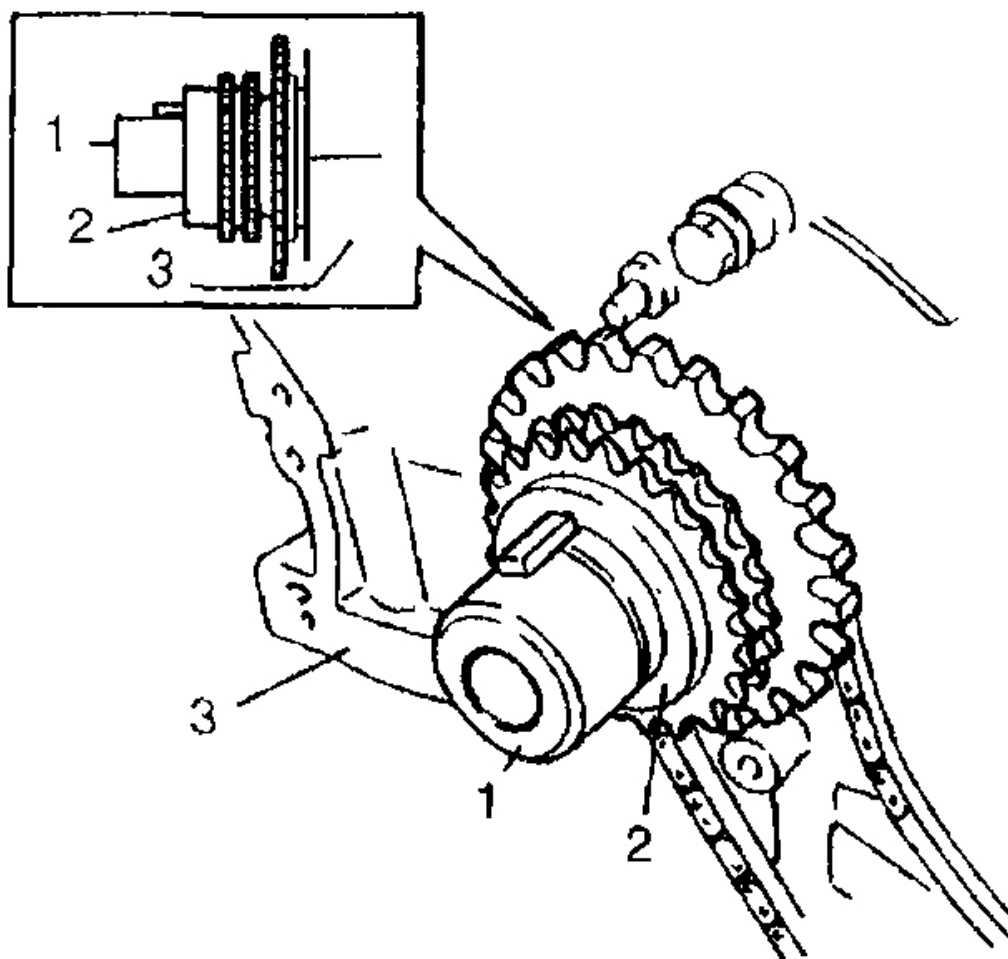


1. Crank timing pulley key
2. Oil jet

G02263954

Fig. 87: Checking Timing Mark On Crankshaft
Courtesy of SUZUKI OF AMERICA CORP.

2. Install 1st timing chain crankshaft sprocket (2) to crankshaft (1) as shown in the figure. Confirm that tooth for CKP sensor are free from metal particles and damage.

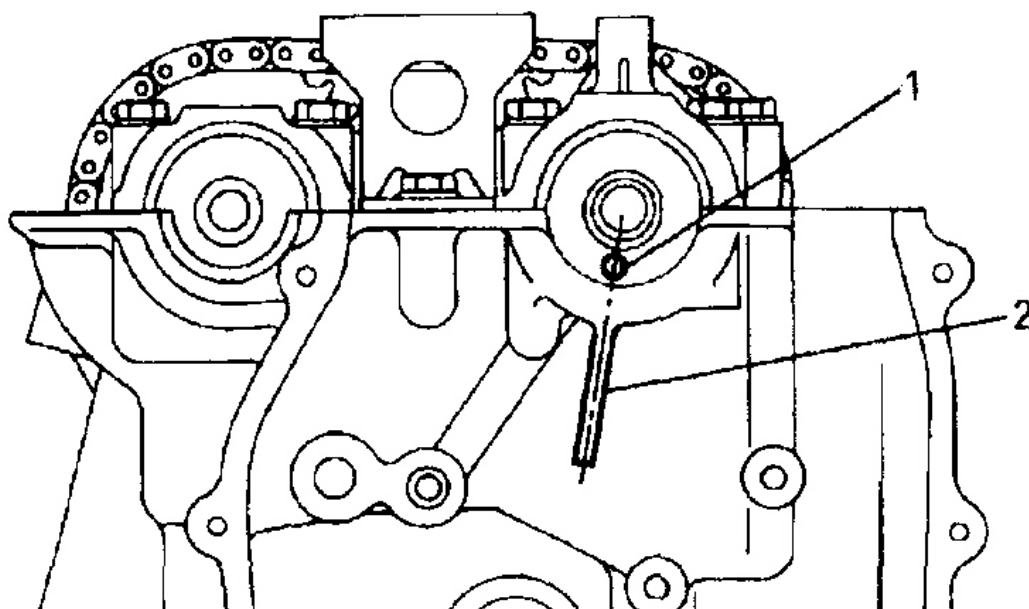


3. Lower crankcase

G02263955

Fig. 88: Installing 1st Timing Chain Crankshaft Sprocket To Crankshaft
Courtesy of SUZUKI OF AMERICA CORP.

3. Check timing mark on RH bank intake camshaft as shown in the figure.



- | |
|---------------------------------|
| 1. Knock pin of intake camshaft |
| 2. Match mark |

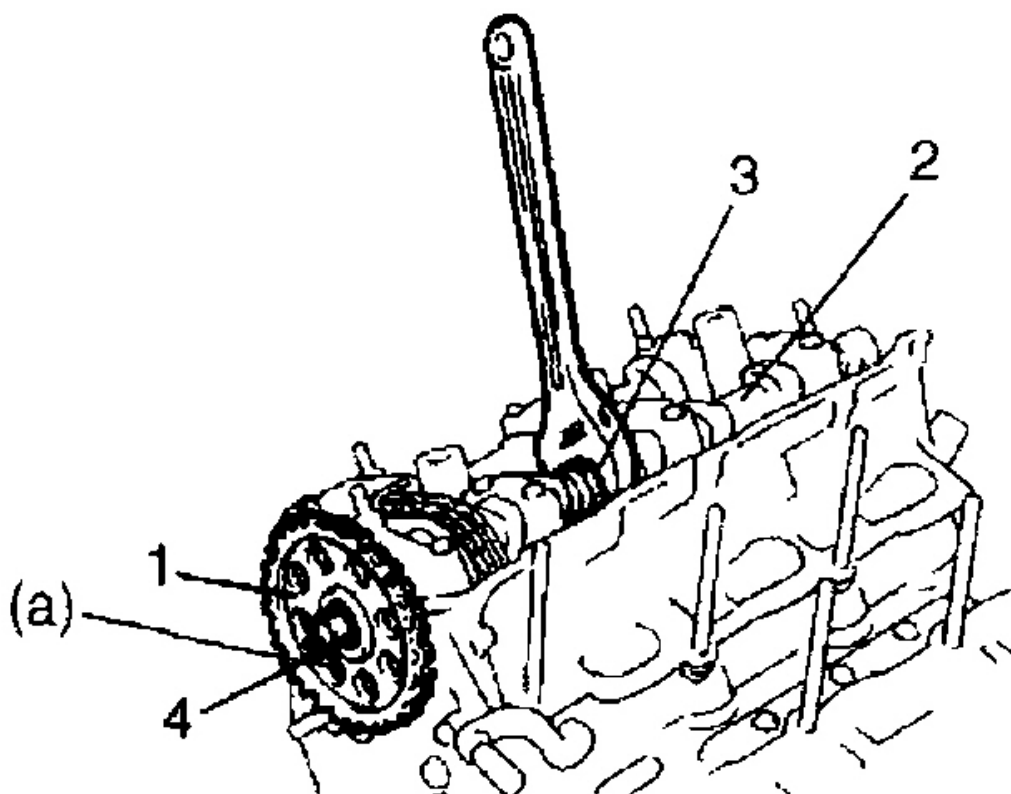
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Fig. 89: Checking Timing Mark On RH Bank Intake Camshaft
Courtesy of SUZUKI OF AMERICA CORP.

4. Install RH bank 1st timing chain intake camshaft sprocket (1) noting the following points.
 - The sprocket should be set in such way that its RH mark (4) can be seen.
 - Camshaft (2) should be held stationary by using a spanner at its hexagonal parts (3) as shown in the figure.

Tightening torque

RH bank 1st timing chain intake camshaft sprocket bolt (a): 80 N.m (8.0 kg-m, 58.0 lb.ft)



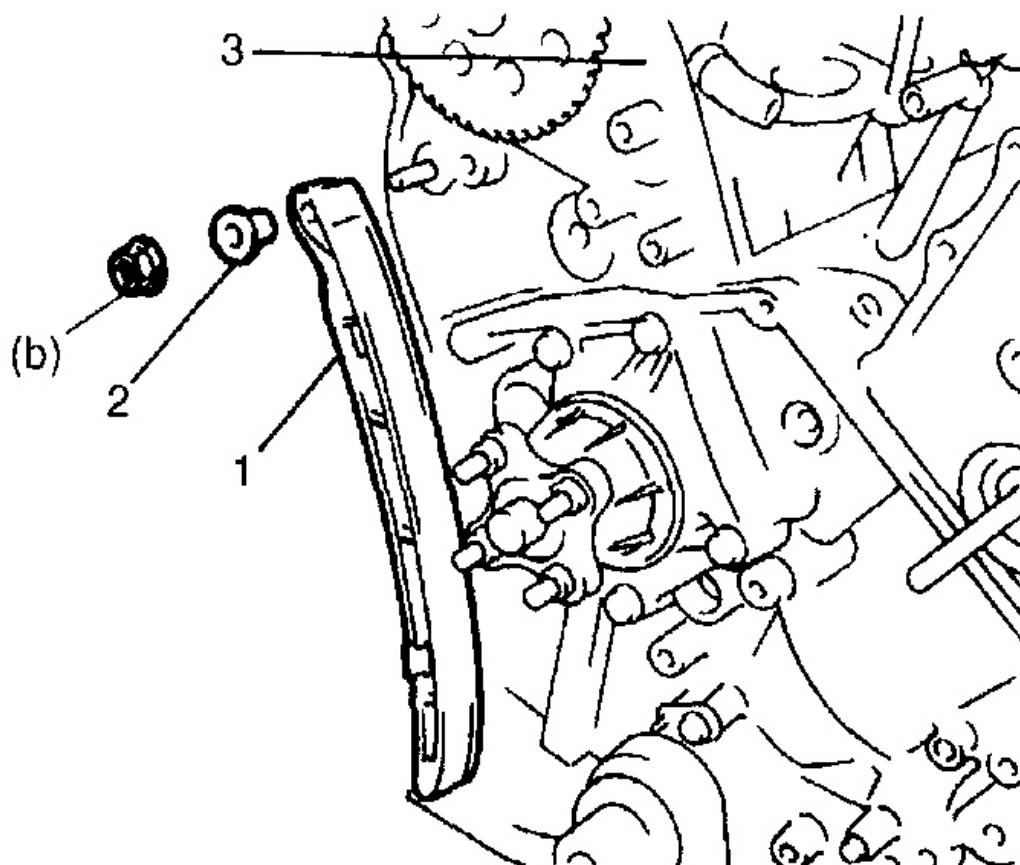
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Fig. 90: Installing RH Bank 1st Timing Chain Intake Camshaft Sprocket
Courtesy of SUZUKI OF AMERICA CORP.

5. Install timing chain tensioner (1) as shown in the figure.

Tightening torque

Timing chain tensioner nut (b): 27 N.m (2.7 kg-m, 19.5 lb.ft)



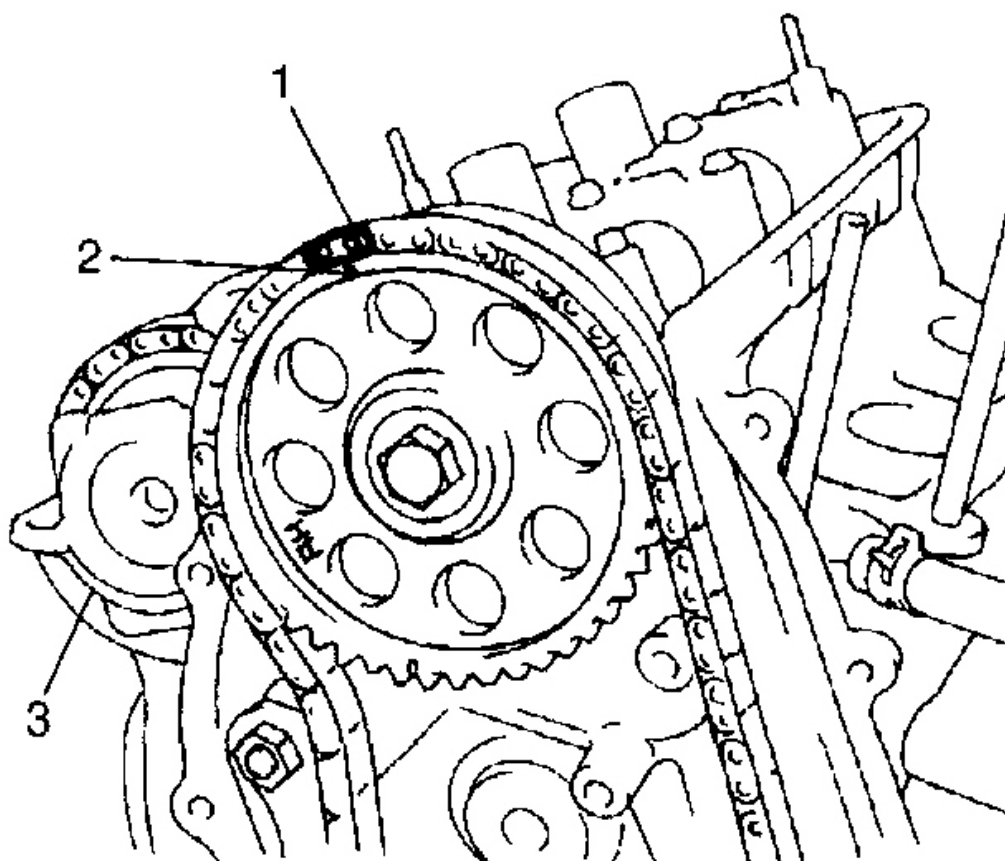
2. Spacer

3. RH bank cylinder head

G02263958

Fig. 91: Installing Timing Chain Tensioner
Courtesy of SUZUKI OF AMERICA CORP.

6. Install 1st timing chain by aligning match marks (2) on RH silver plate (1) of 1st timing chain and RH bank 1st timing chain intake camshaft sprocket.

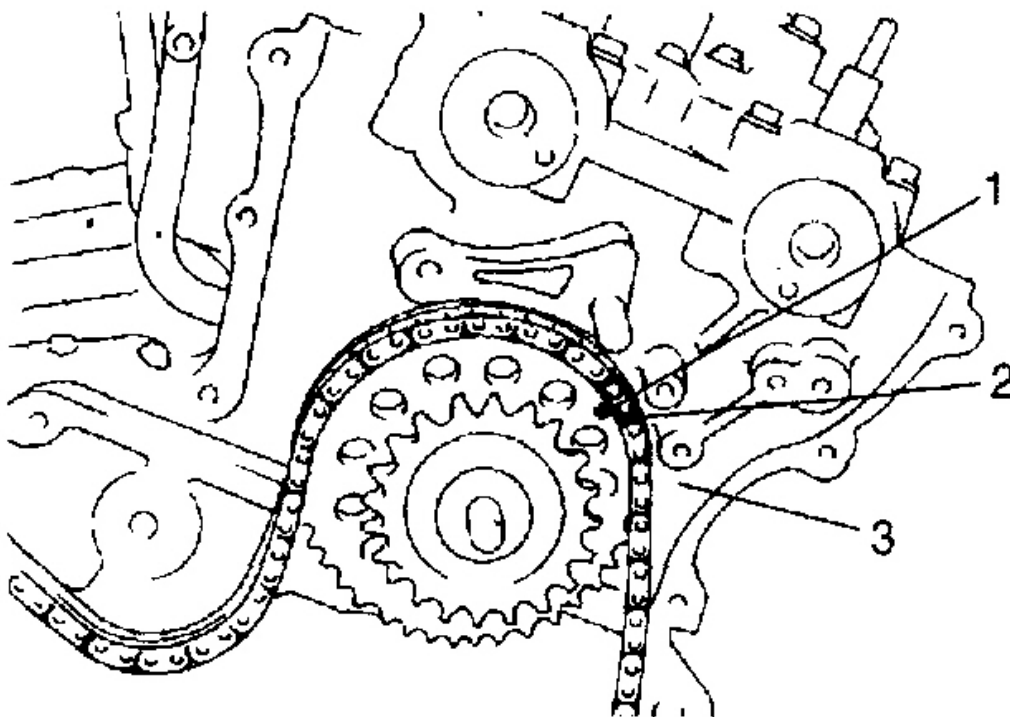


3. RH bank cylinder head

G02263959

Fig. 92: Installing 1st Timing Chain By Aligning Match Marks
Courtesy of SUZUKI OF AMERICA CORP.

7. Apply oil to bush of idler sprocket No. 2.
8. Install idler sprocket No. 2 and sprocket shaft.
9. Install idler sprocket No. 2 by aligning match marks (2) on LH silver plate (1) of 1st timing chain.



3. RH bank cylinder head

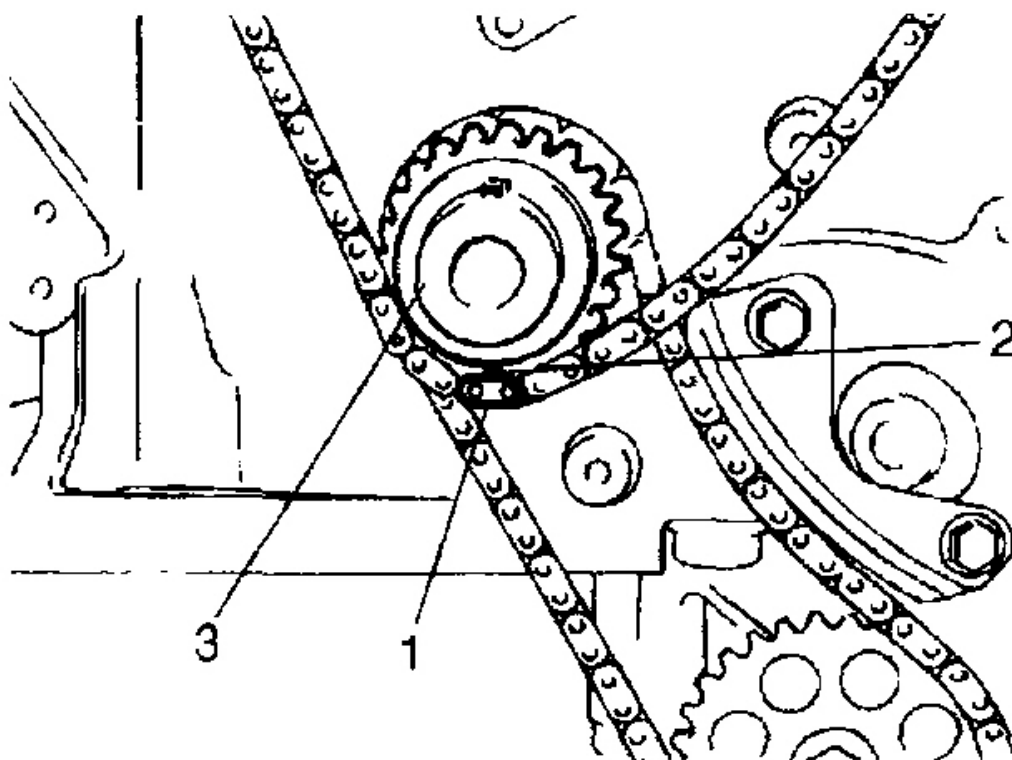
G02263960

Fig. 93: Installing Idler Sprocket No. 2 & Sprocket Shaft
Courtesy of SUZUKI OF AMERICA CORP.

10. Install crankshaft sprocket by aligning match marks (2) on yellow plate (1) of 1st timing chain and crankshaft timing sprocket.

To install it, fit a spanner to hexagonal part at the center of RH bank intake camshaft to turn a little.

CAUTION: Do not turn camshaft more than necessary. If turned excessively, valve and piston may get damaged.



3. Crankshaft

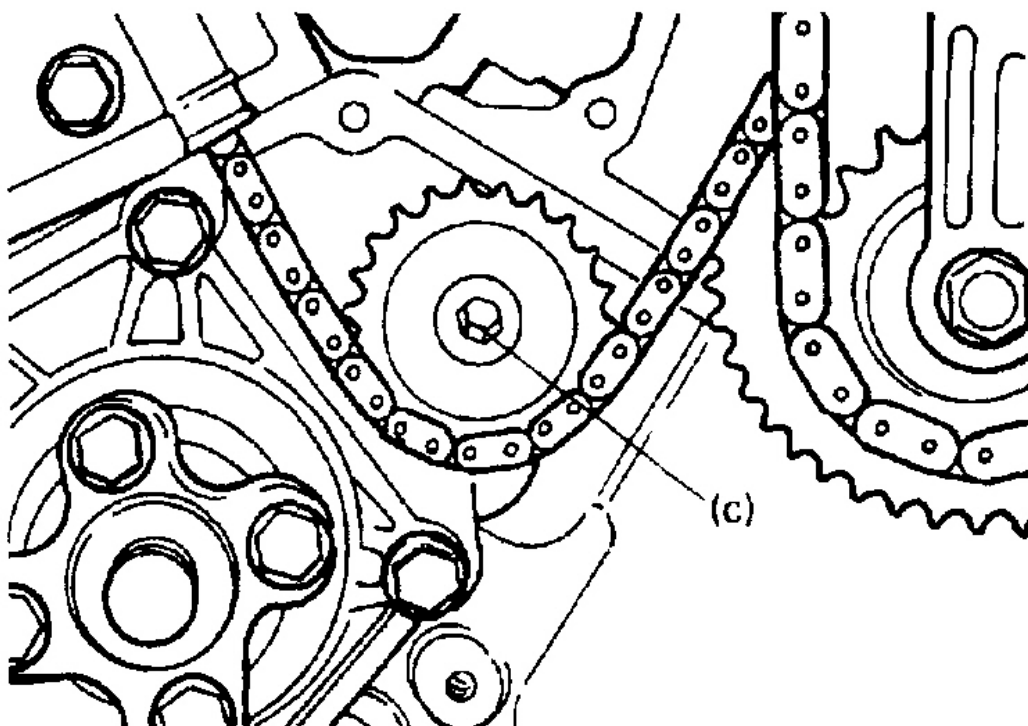
G02263961

Fig. 94: Installing Crankshaft Sprocket
Courtesy of SUZUKI OF AMERICA CORP.

11. Apply oil to bearing of idler sprocket No. 1.
12. Install idler sprocket No. 1.

Tightening torque

Idler sprocket No. 1 bolt (c): 45 N.m (4.5 kg-m, 32.5 lb.ft)

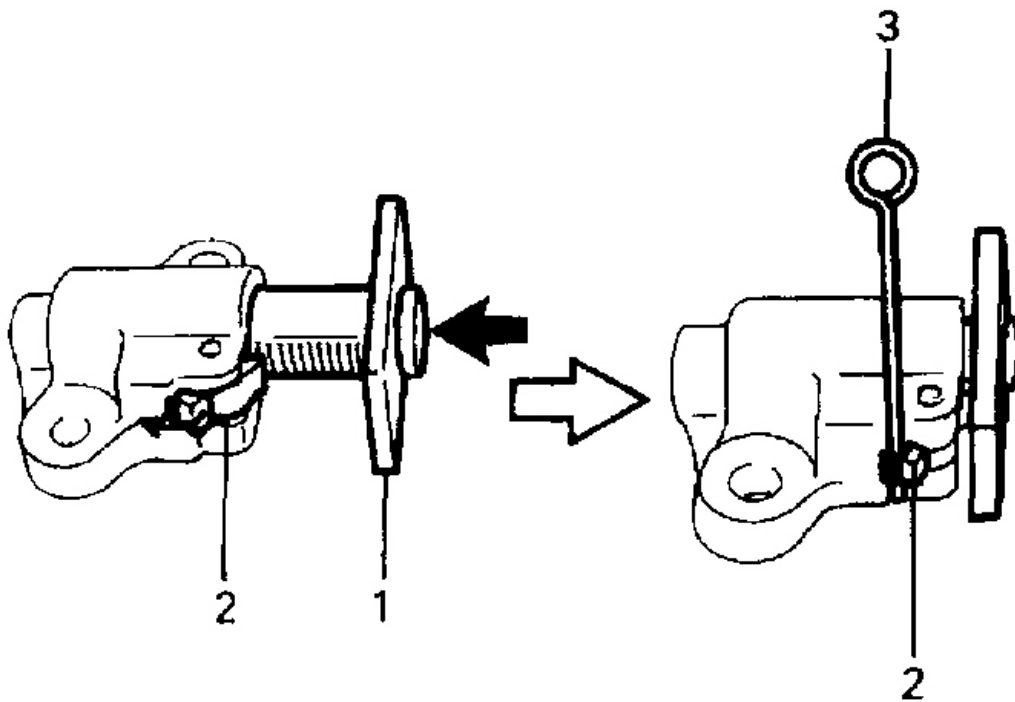


G02263962

Fig. 95: Installing Idler Sprocket No. 1
Courtesy of SUZUKI OF AMERICA CORP.

13. With latch of tensioner adjuster No. 1 returned and plunger (1) pushed back into body, insert stopper (3) into latch (2) and body.

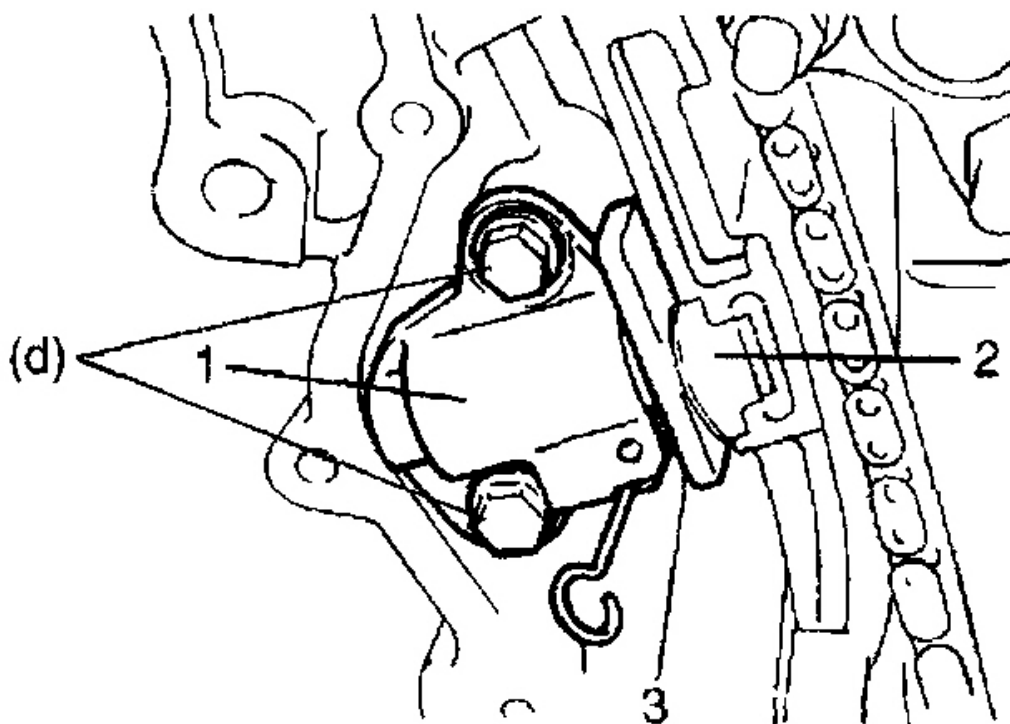
After inserting it, check to make sure that plunger (1) will not come out.



G02263963

Fig. 96: Collapsing & Locking Tensioner Adjuster No. 1
Courtesy of SUZUKI OF AMERICA CORP.

14. Install timing chain tensioner adjuster No. 1 (1).



2. Timing chain tensioner

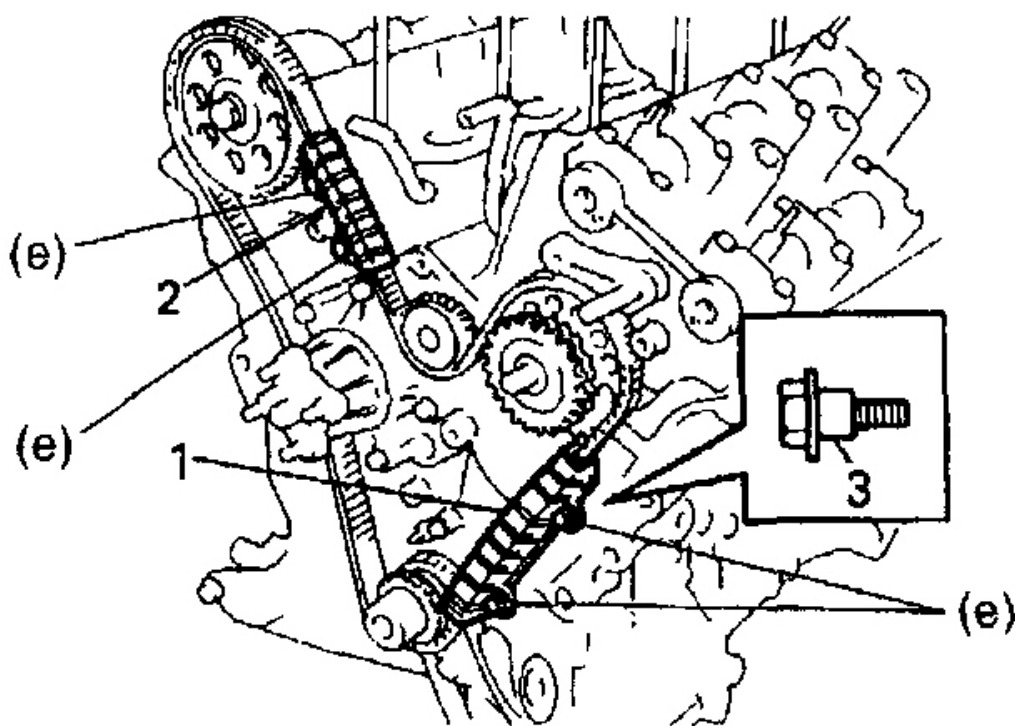
G02263964

Fig. 97: Installing Timing Chain Tensioner Adjuster No. 1
Courtesy of SUZUKI OF AMERICA CORP.

Tightening torque

Timing chain tensioner adjuster No. 1 bolt (d): 11 N.m (1.1 kg-m, 8.0 lb.ft)

15. Pull out stopper (3) from adjuster No. 1 (1).



3. Guide bolts

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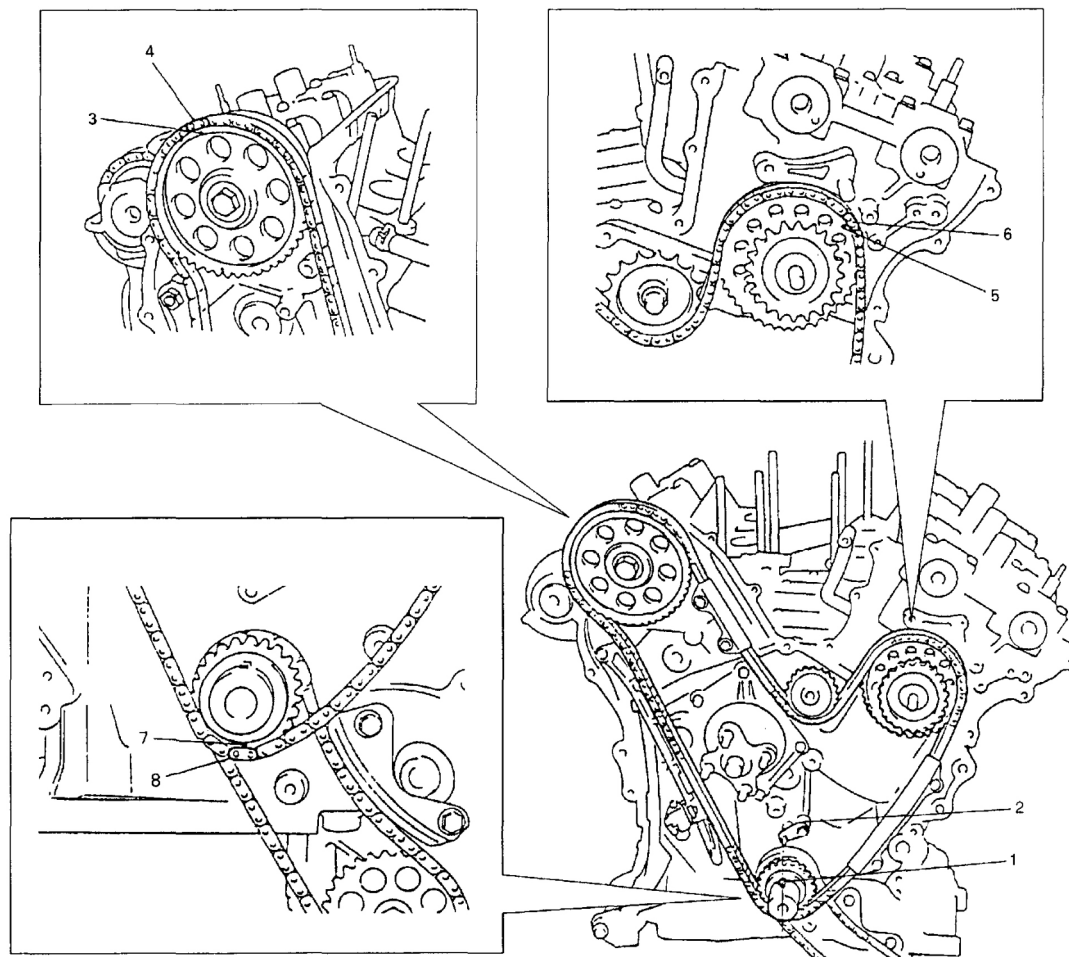
Fig. 98: Pulling Out Stopper From Adjuster No. 1
Courtesy of SUZUKI OF AMERICA CORP.

16. Install timing chain guide No. 1 (2) and No. 2 (1).

Tightening torque

Timing chain guide No. 1 and No. 2 bolt (e): 9 N.m (0.9 kg-m, 6.5 lb.ft)

17. Check each aligned timing marks as shown in the figure.



1. Crank timing pulley key	4. Silver plate (LH) of 1st timing chain	7. Match mark of crankshaft timing sprocket
2. Oil jet	5. Match mark of idler sprocket No.2	8. Gold or Yellow plate of 1st timing chain
3. Match mark of RH bank 1st timing chain sprocket	6. Silver plate (RH) of 1st timing chain	

G02263966

Fig. 99: Installing Timing Chain Guide No. 1 & No. 2
Courtesy of SUZUKI OF AMERICA CORP.

18. Install LH bank 2nd timing chain. Refer to **LH (NO. 1) BANK 2ND TIMING CHAIN & CHAIN TENSIONER INSTALLATION** .
19. Install timing chain cover. Refer to **TIMING CHAIN COVER REMOVAL & INSTALLATION** .
20. Install oil pan referring to **OIL PAN & OIL PUMP STRAINER REMOVAL & INSTALLATION** .
21. Install front differential housing referring to **FRONT DIFFERENTIAL DISMOUNTING & REMOUNTING** .
22. Install P/S system referring to **P/S PUMP REMOVAL & INSTALLATION** .
23. Install cooling system referring to **COOLING FAN & FAN CLUTCH REMOVAL & INSTALLATION** and **RADIATOR REMOVAL & INSTALLATION** .

24. Install intake manifold with throttle body.

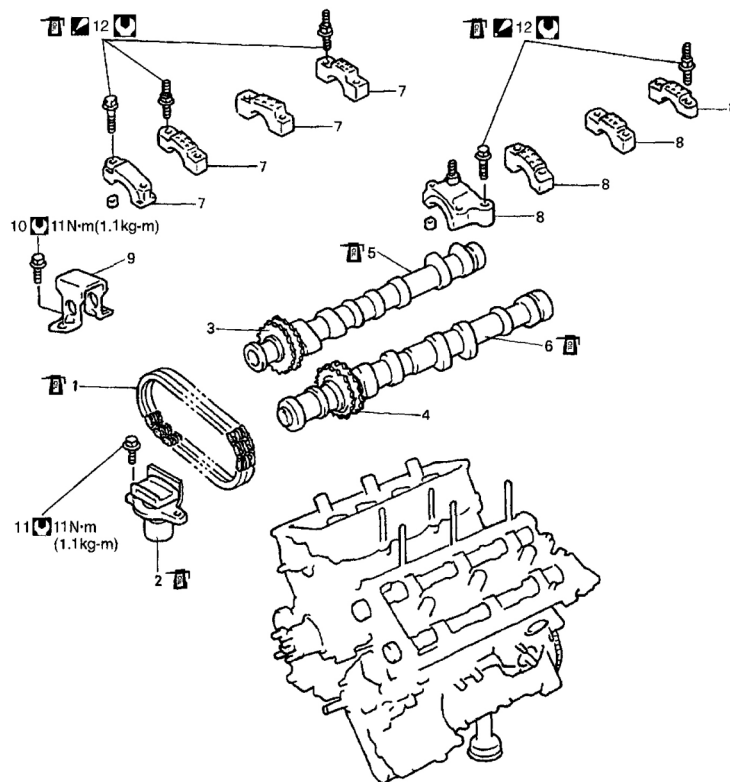
Refer to **THROTTLE BODY & INTAKE MANIFOLD REMOVAL & INSTALLATION (H25 ENGINE)** .

25. Refill cooling system with coolant, front differential with gear oil, P/S system with specified fluid and engine with engine oil.

26. Check wheel alignment referring to **SPECIFICATIONS & PROCEDURES** .

27. Verify that there is no fuel leakage, water leakage and oil leakage at each connection.

RH (NO. 2) BANK 2ND TIMING CHAIN & CHAIN TENSIONER COMPONENTS



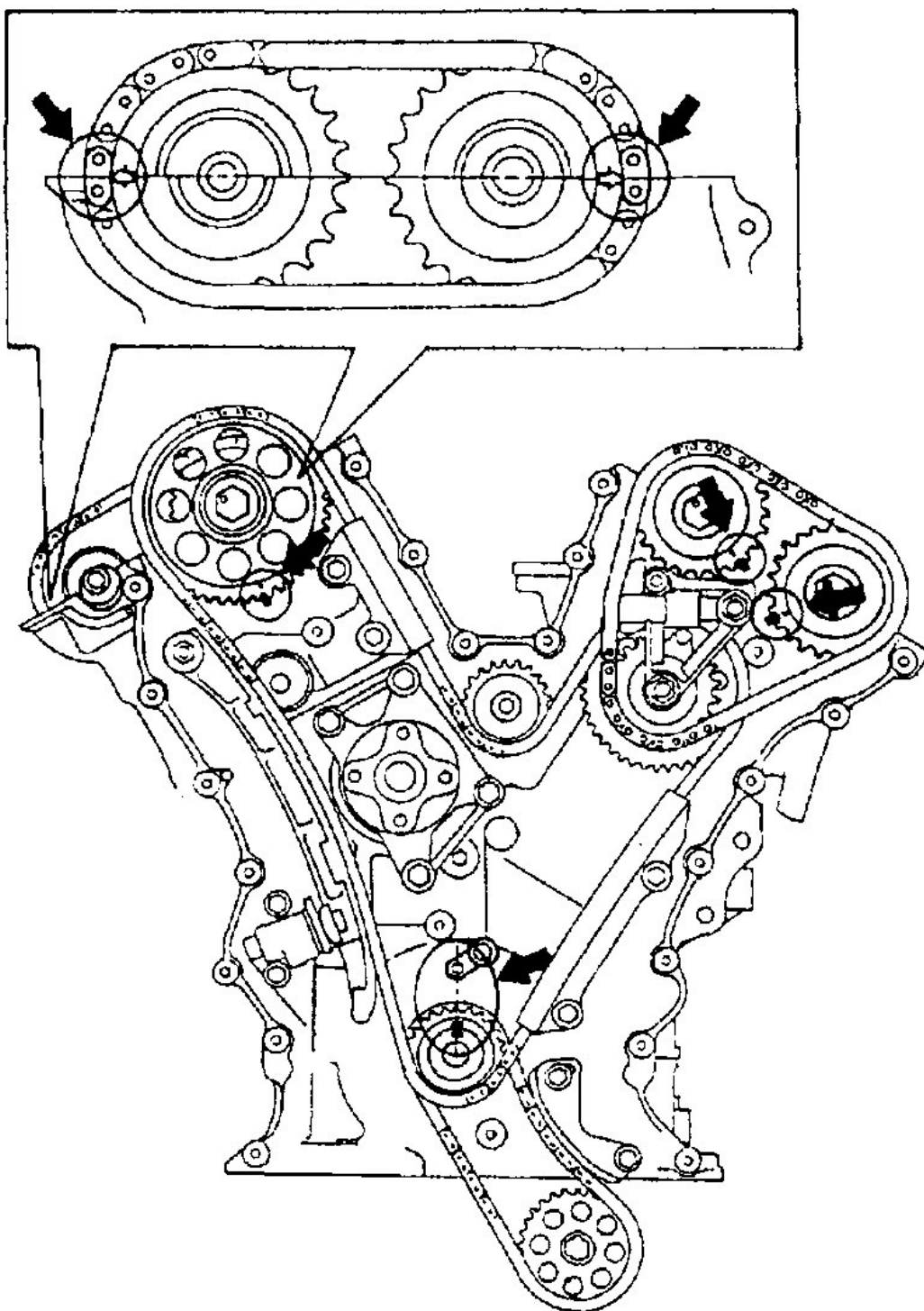
1. RH bank 2nd timing chain	6. RH bank intake camshaft	11. Timing chain tensioner adjuster No.2 bolt
2. Timing chain tensioner adjuster No.2	7. RH bank exhaust camshaft housing	12. Camshaft housing bolt : Tighten 12 N·m (1.2 kg-m, 9.0 lb-ft) by the specified procedure
3. RH bank exhaust camshaft sprocket	8. RH bank intake camshaft housing	: Apply engine oil to sliding surface of each part.
4. RH bank 2nd timing chain intake camshaft sprocket	9. Timing chain guide No.3	: Tightening torque
5. RH bank exhaust camshaft	10. Timing chain guide No.3 bolt	

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Fig. 100: Exploded View Of RH (No. 2) Bank 2nd Timing Chain & Chain Tensioner Components
Courtesy of SUZUKI OF AMERICA CORP.

RH (NO. 2) BANK 2ND TIMING CHAIN & CHAIN TENSIONER REMOVAL

1. For reinstallation of timing chain, align 12 timing marks as shown in the figure by turning crankshaft.

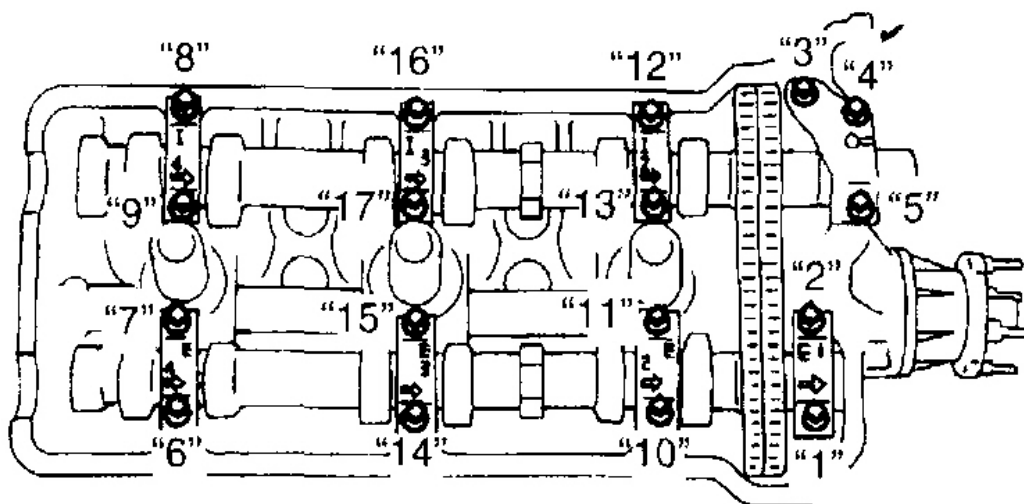


G02263968

Fig. 101: Aligning Timing Marks

Courtesy of SUZUKI OF AMERICA CORP.

2. Remove LH bank 2nd timing chain. Refer to LH (NO. 1) BANK 2ND TIMING CHAIN & CHAIN TENSIONER REMOVAL.
3. Remove 1st timing chain. Refer to 1ST TIMING CHAIN & CHAIN TENSIONER REMOVAL.
4. Remove timing chain guide No. 3 referring to RH (NO. 2) BANK 2ND TIMING CHAIN & CHAIN TENSIONER COMPONENTS :
5. Loosen camshaft housing bolts in such order ("1" - "17") as indicated in the figure and remove them.
6. Remove camshaft housings.



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Fig. 102: Loosening Camshaft Housing Bolts In Order

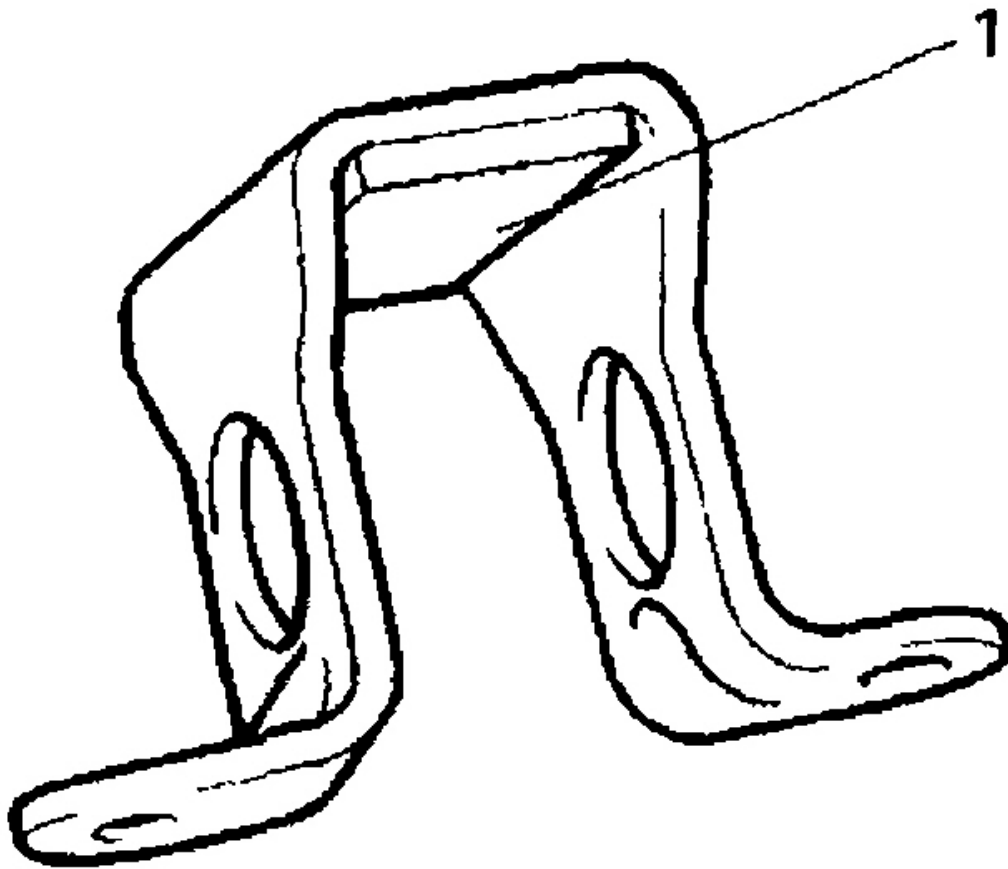
Courtesy of SUZUKI OF AMERICA CORP.

7. Remove RH bank intake camshaft, RH bank exhaust camshaft, and RH bank 2nd timing chain as a set referring to RH (NO. 2) BANK 2ND TIMING CHAIN & CHAIN TENSIONER COMPONENTS.
8. Remove timing chain tensioner adjuster No. 2, referring to RH (NO. 2) BANK 2ND TIMING CHAIN & CHAIN TENSIONER COMPONENTS.

RH (NO. 2) BANK 2ND TIMING CHAIN & CHAIN TENSIONER INSPECTION

Timing Chain Guide No. 3

Check shoe (1) for excessive wear or damage. If any malfunction is found, replace it.

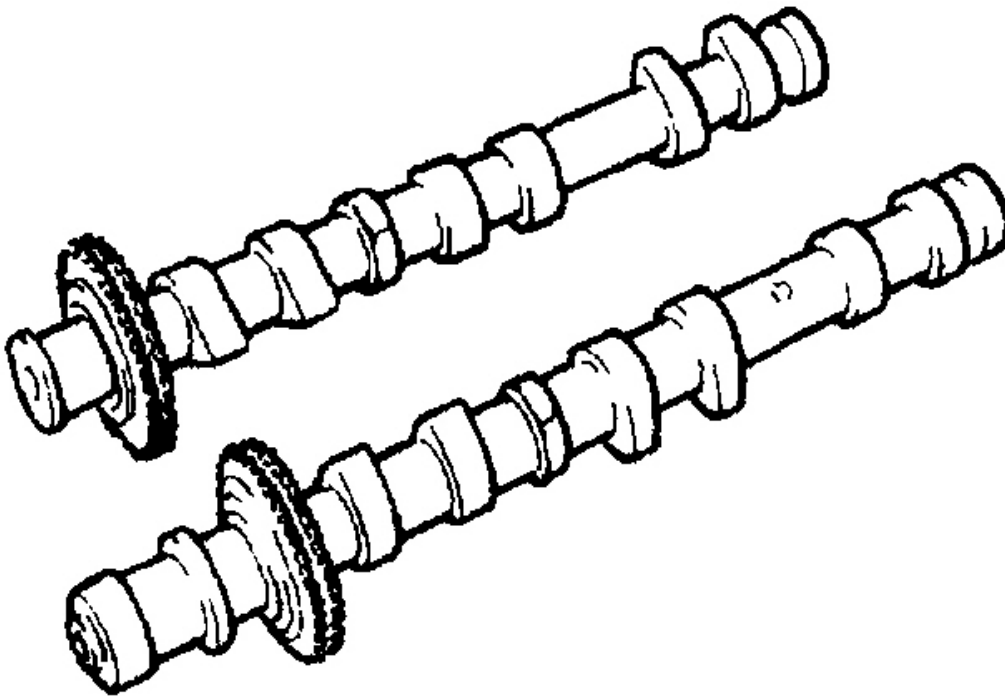


G02263970

Fig. 103: Checking Timing Chain Guide No. 3 Shoe
Courtesy of SUZUKI OF AMERICA CORP.

RH Bank 2nd Timing Chain Sprockets

Check teeth of sprocket for wear or damage.

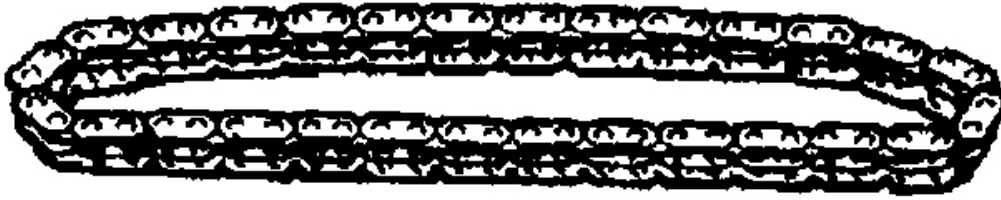


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Fig. 104: Checking RH Bank 2nd Timing Chain Sprockets
Courtesy of SUZUKI OF AMERICA CORP.

RH Bank 2nd Timing Chain

Check timing chain for wear or damage.

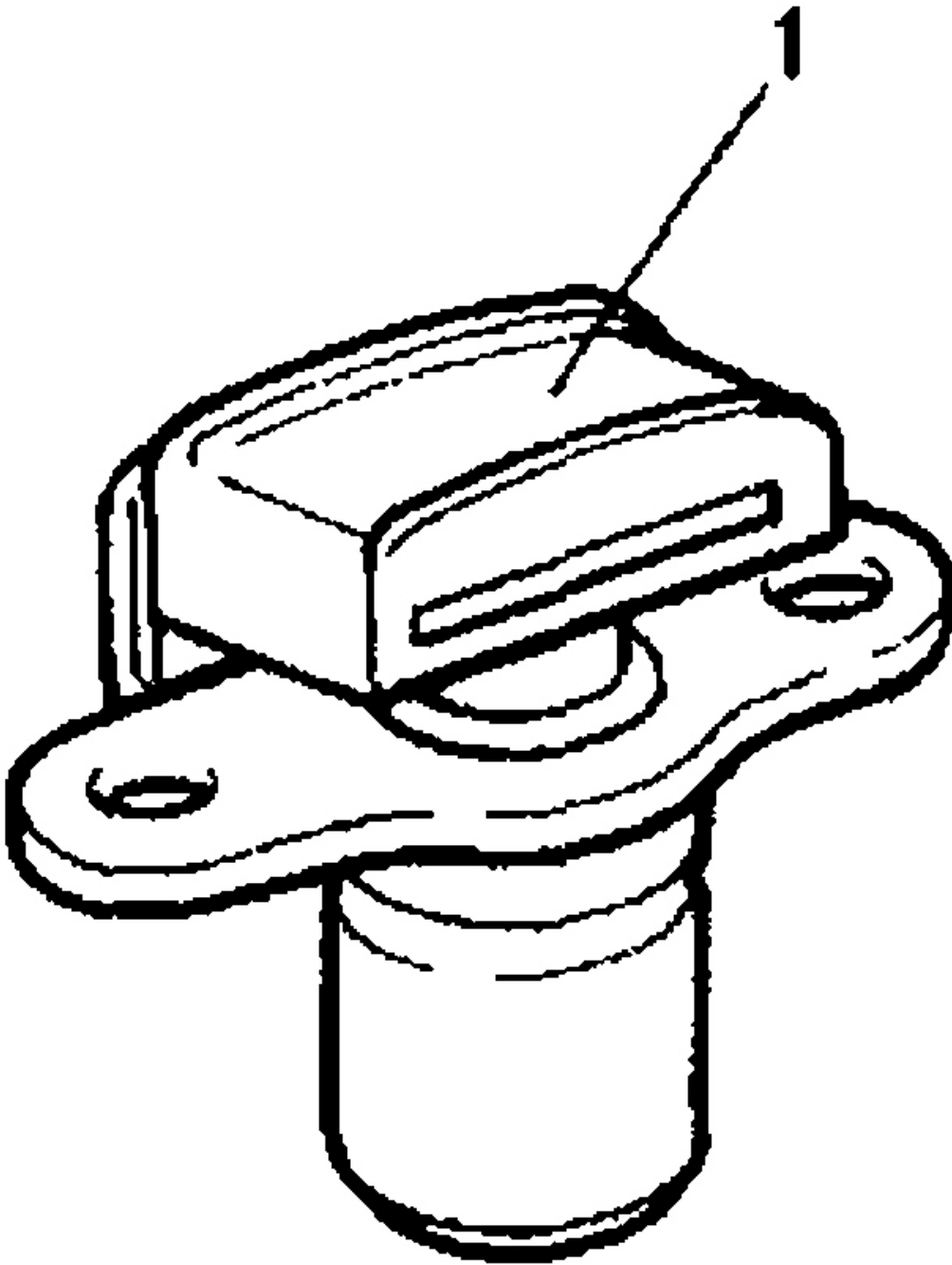


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Fig. 105: Checking RH Bank 2nd Timing Chain
Courtesy of SUZUKI OF AMERICA CORP.

Timing Chain Tensioner Adjuster No. 2

- Check shoe (1) for wear or damage.
- Check that plunger slides smoothly.

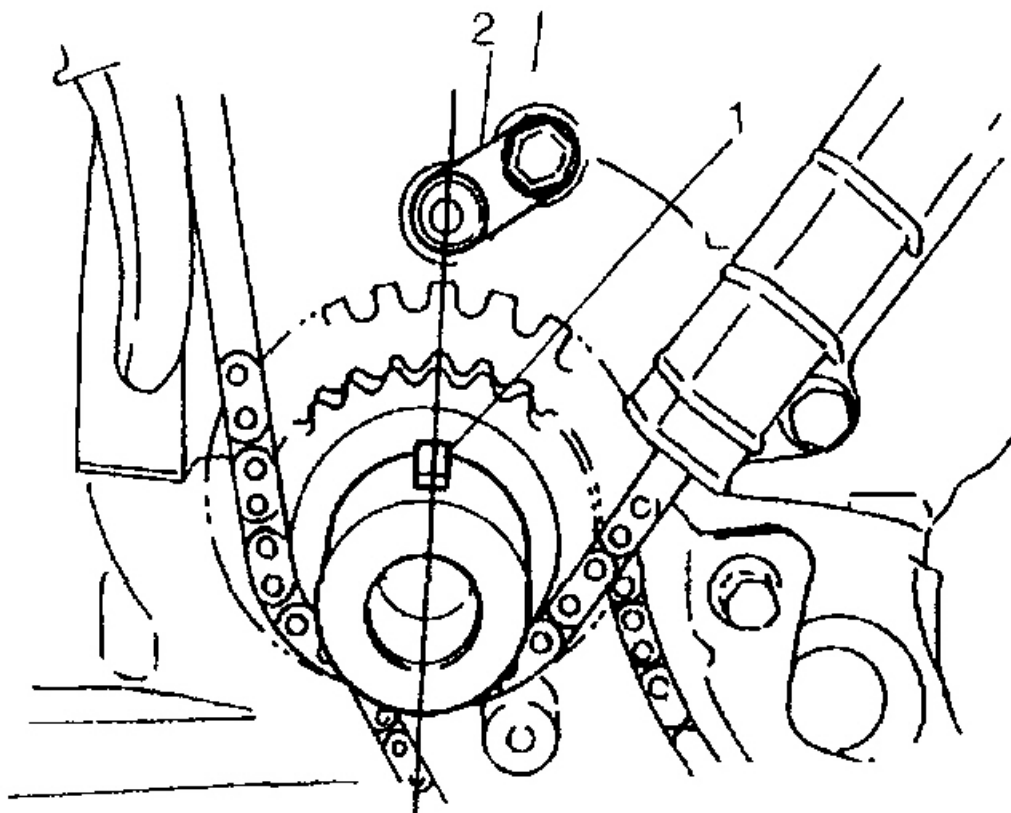


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Fig. 106: Checking Timing Chain Tensioner Adjuster No. 2
Courtesy of SUZUKI OF AMERICA CORP.

RH (NO. 2) BANK 2ND TIMING CHAIN & CHAIN TENSIONER INSTALLATION

1. Check timing mark on crankshaft as shown in the figure.



1. Crank timing pulley key

2. Oil jet

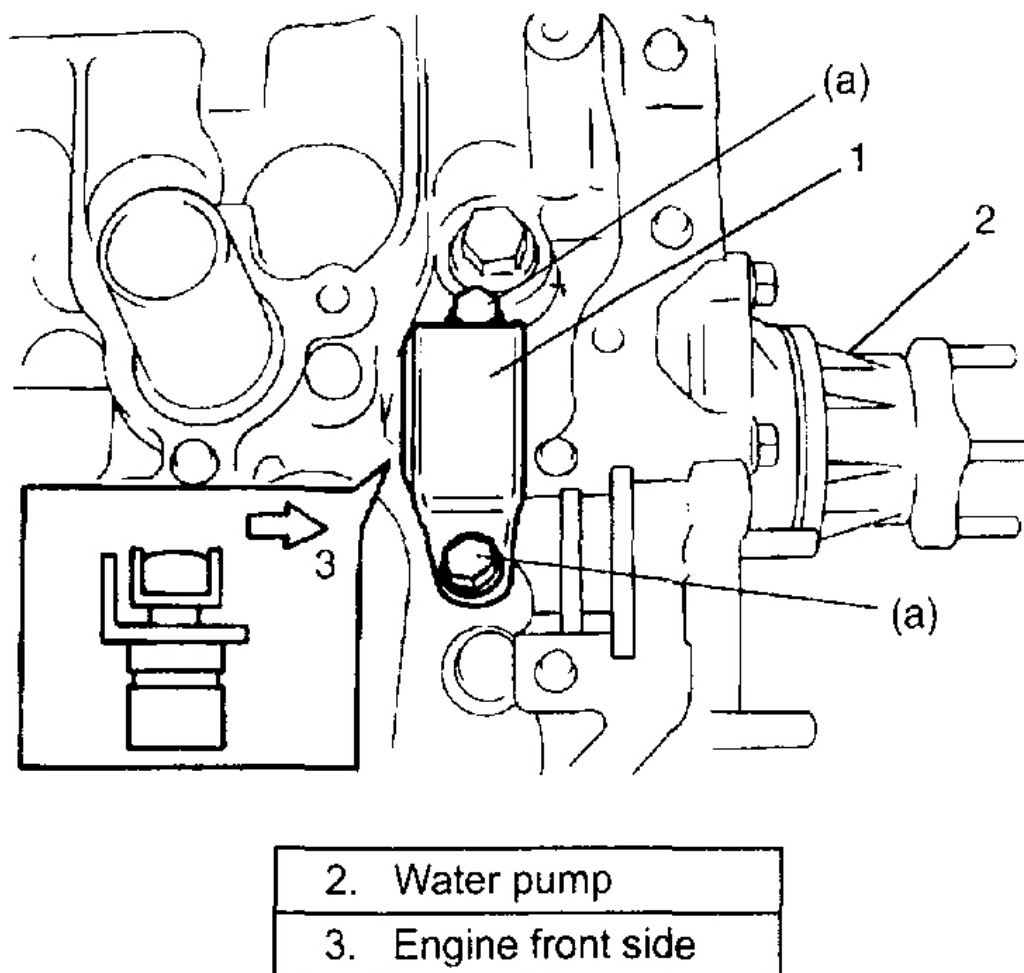
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Fig. 107: Checking Timing Mark On Crankshaft
Courtesy of SUZUKI OF AMERICA CORP.

2. Apply oil to timing chain tensioner adjuster No. 2 (1).
3. Install timing chain tensioner adjuster No. 2 (1).

Tightening torque

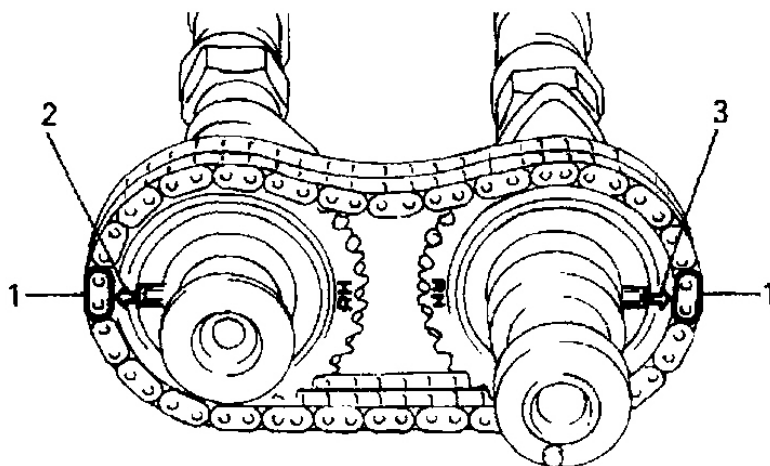
Timing chain tensioner adjuster No. 2 bolt (a): 11 N.m (1.1 kg-m, 8.0 lb-ft)



G02263975

Fig. 108: Installing Timing Chain Tensioner Adjuster No. 2
Courtesy of SUZUKI OF AMERICA CORP.

4. Apply oil to sliding surface of each camshafts and camshaft journals.
5. Install RH bank 2nd timing chain by aligning match marks on yellow or silver plates (1) of RH bank 2nd timing chain, RH bank 2nd timing chain intake camshaft sprocket and RH bank 2nd timing chain exhaust camshaft sprocket as shown.



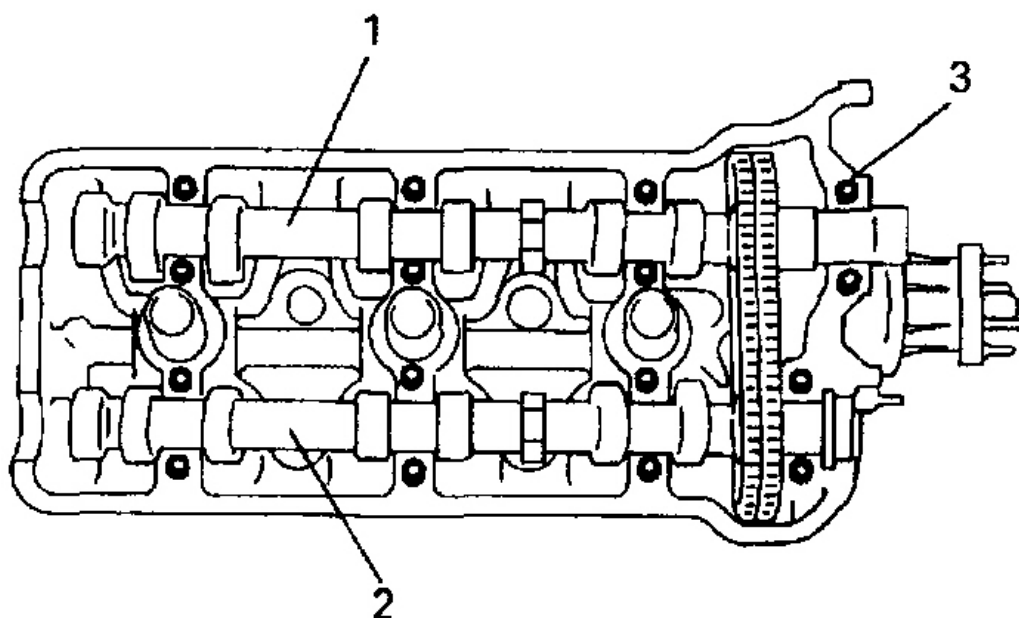
2. Match mark of RH bank 2nd timing chain exhaust camshaft sprocket

3. Match mark of RH bank 2nd timing chain intake camshaft sprocket
--

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Fig. 109: Aligning Match Marks Of RH Bank 2nd Timing Chain, RH Bank 2nd Timing Chain Intake Camshaft Sprocket & RH Bank 2nd Timing Chain Exhaust Camshaft Sprocket
Courtesy of SUZUKI OF AMERICA CORP.

6. Install camshaft housing pins (3) as shown in the figure.



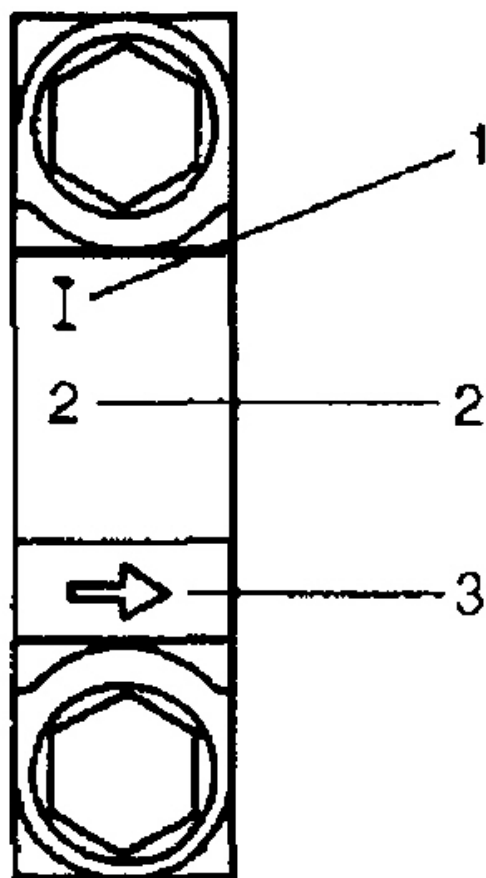
1. RH bank intake camshaft
2. RH bank exhaust camshaft

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Fig. 110: Installing Camshaft Housing Pins
Courtesy of SUZUKI OF AMERICA CORP.

7. Check position of camshaft housings.

Embossed marks are provided on each camshaft housing, indicating position and direction for installation. Install housings as indicated by these marks.



1. I: Intake side, E: Exhaust side

2. Position from timing chain side

3. Timing chain side

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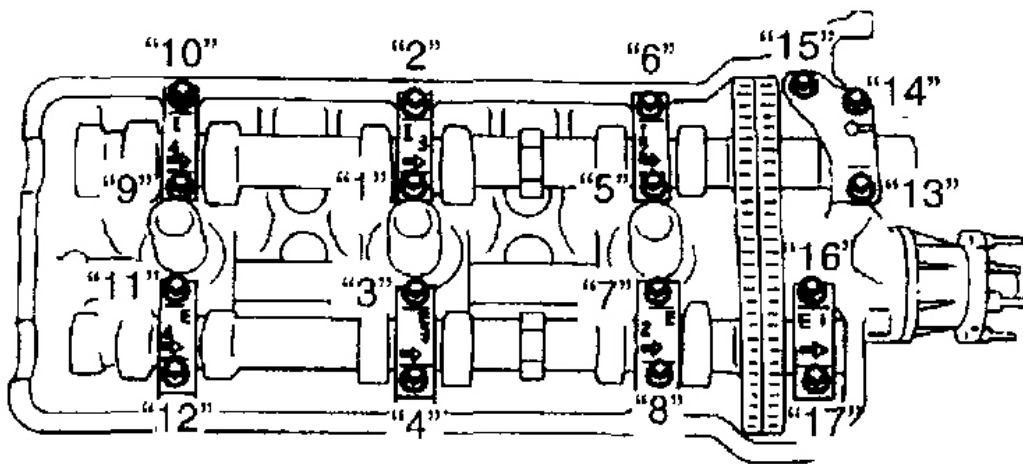
Fig. 111: Checking Position Of Camshaft Housings
Courtesy of SUZUKI OF AMERICA CORP.

8. After applying oil to housing bolts, tighten them temporarily first.

Then tighten them by following sequence ("1" - "17") as indicated in the figure. Tighten a little at a time and evenly among bolts and repeat tightening sequence 2 or 3 times before they are tightened to specified torque below.

Tightening torque

Camshaft housing bolt: Tighten 12 N.m (1.2 kg-m, 9.0 lb-ft) by the specified procedure



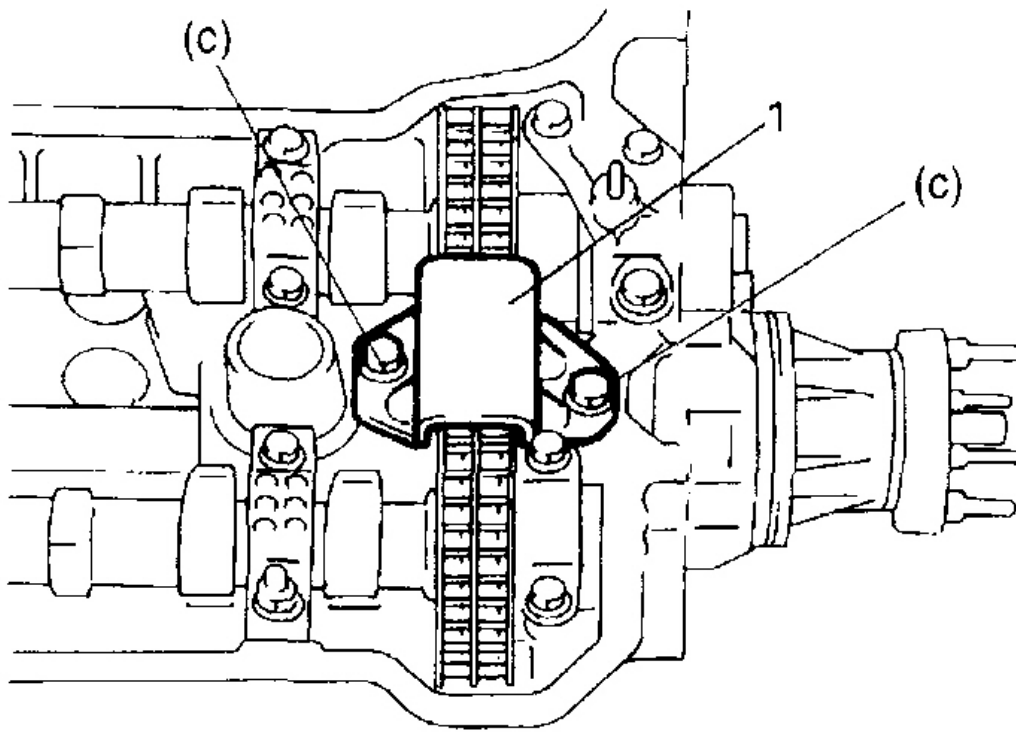
G02263979

Fig. 112: Identifying Camshaft Housing Bolt Torque Sequence
Courtesy of SUZUKI OF AMERICA CORP.

9. Install timing chain guide No. 3 (1).

Tightening torque

Timing chain guide No. 3 bolt (c): 11 N.m (1.1 kg-m, 8.0 lb-ft)



G02263980

Fig. 113: Installing Timing Chain Guide No. 3
Courtesy of SUZUKI OF AMERICA CORP.

10. Install 1st timing chain. Refer to **1ST TIMING CHAIN & CHAIN TENSIONER INSTALLATION**.
11. Install LH bank 2nd timing chain. Refer to **LH (NO. 1) BANK 2ND TIMING CHAIN & CHAIN TENSIONER INSTALLATION**.
12. Install timing chain cover. Refer to **TIMING CHAIN COVER REMOVAL & INSTALLATION**.
13. Install oil pan referring to **OIL PAN & OIL PUMP STRAINER REMOVAL & INSTALLATION**.
14. Install front differential housing referring to **FRONT DIFFERENTIAL DISMOUNTING & REMOUNTING**.
15. Install P/S system referring to **P/S PUMP REMOVAL & INSTALLATION**.
16. Install cooling system referring to **RADIATOR REMOVAL & INSTALLATION**.
17. Install intake manifold with throttle body.

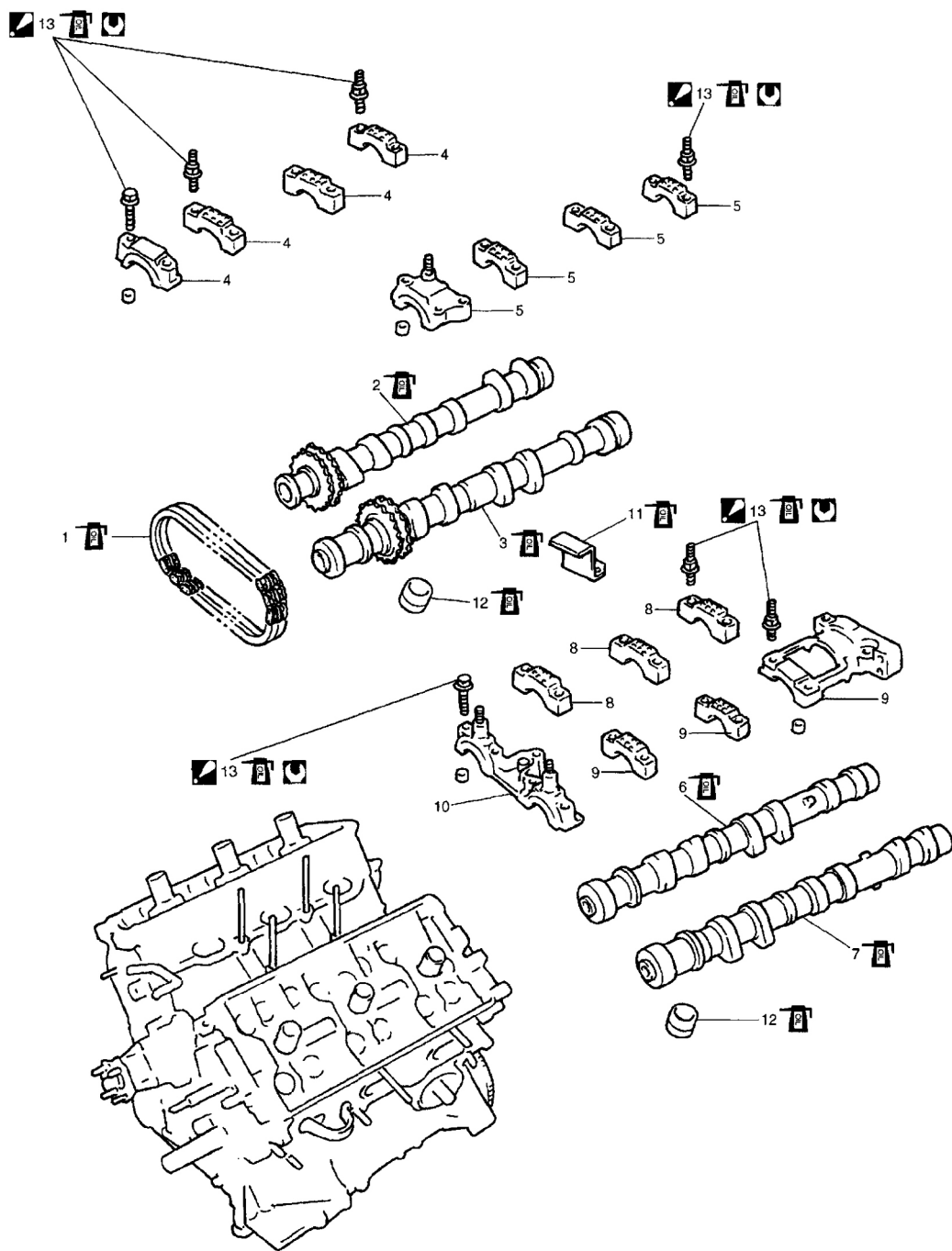
Refer to **THROTTLE BODY & INTAKE MANIFOLD REMOVAL & INSTALLATION (H25 ENGINE)**.

18. Refill cooling system with coolant, front differential with gear oil, P/S system with specified fluid and engine with engine oil.
19. Check wheel alignment referring to **SPECIFICATIONS & PROCEDURES** .
20. Verify that there is no fuel leakage, water leakage and oil leakage at each connection.

CAMSHAFTS & VALVE LASH ADJUSTERS COMPONENTS

2004 Suzuki Grand Vitara EX

2004 ENGINES 2.5L V6



1. RH bank 2nd timing chain	6. LH bank intake camshaft	11. Timing chain guide No.5
2. RH bank exhaust camshaft	7. LH bank exhaust camshaft	12. Valve lash adjuster
3. RH bank intake camshaft	8. LH bank intake camshaft housing	13. Camshaft housing bolt : Tighten 12 N·m (1.2 kg-m, 9.0 lb-ft) by the specified procedure
4. RH bank exhaust camshaft housing	9. LH bank exhaust camshaft housing	: Tightening torque
5. RH bank intake camshaft housing	10. LH bank camshaft housing	: Apply engine oil to sliding surface of each part.

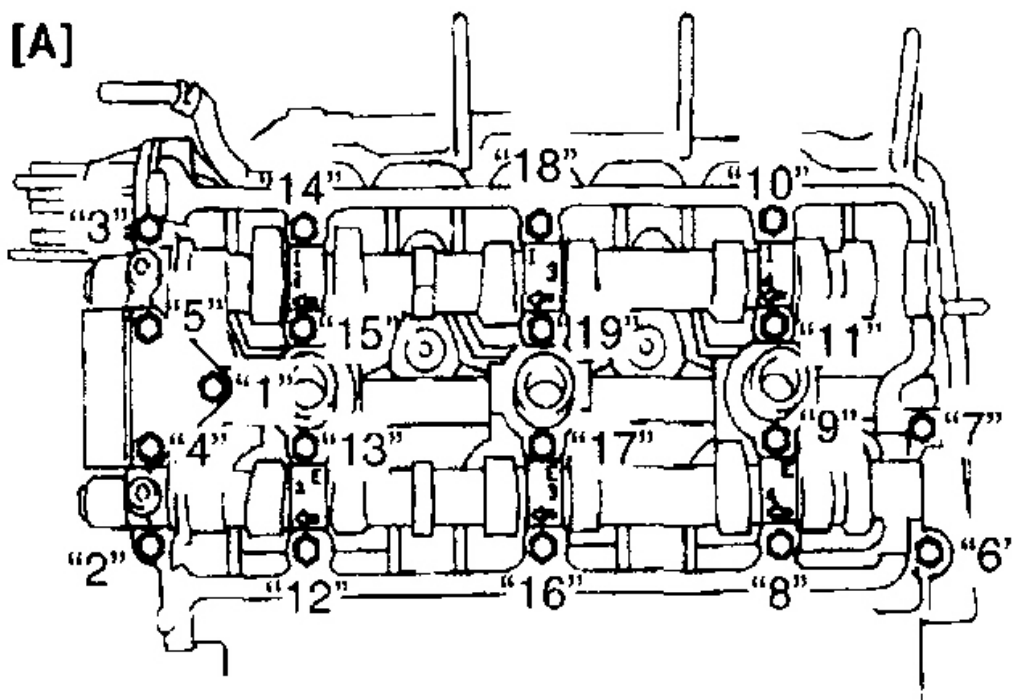
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Fig. 114: Exploded View Of Camshafts & Valve Lash Adjusters Components
Courtesy of SUZUKI OF AMERICA CORP.

CAMSHAFTS & VALVE LASH ADJUSTERS REMOVAL & INSTALLATION

Removal

1. Disconnect negative (-) cable at battery.
2. Drain engine oil.
3. Drain coolant referring to **COOLANT DRAINING** .
4. Remove timing chain cover. Refer to **TIMING CHAIN COVER REMOVAL & INSTALLATION** .
5. Remove LH bank 2nd timing chain. Refer to **LH (NO. 1) BANK 2ND TIMING CHAIN & CHAIN TENSIONER REMOVAL** .
6. Remove 1st timing chain. Refer to **1ST TIMING CHAIN & CHAIN TENSIONER INSTALLATION** .
7. Remove RH bank camshafts. Refer to **RH (NO. 2) BANK 2ND TIMING CHAIN & CHAIN TENSIONER REMOVAL** .
8. Remove CMP sensor. Refer to **CAMSHAFT POSITION (CMP) SENSOR REMOVAL & INSTALLATION**
9. Loosen LH bank camshaft housing bolts in such order ("1" - "19") as indicated in the figure and remove them.



[A]: LH bank

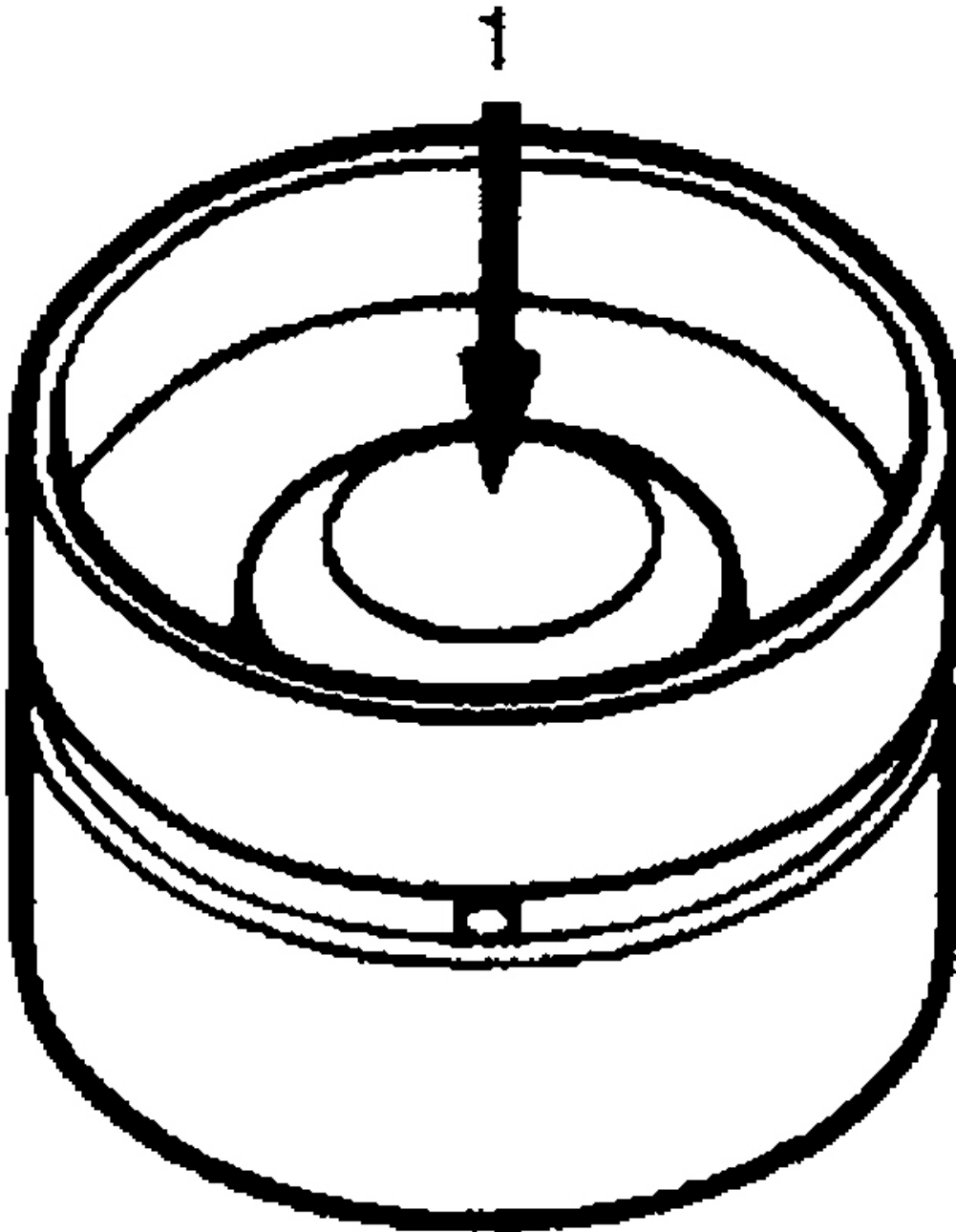
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Fig. 115: Loosening LH Bank Camshaft Housing Bolts In Order
Courtesy of SUZUKI OF AMERICA CORP.

10. Remove LH bank camshaft housings.
11. Remove LH bank camshafts.
12. Remove valve lash adjuster.

CAUTION:

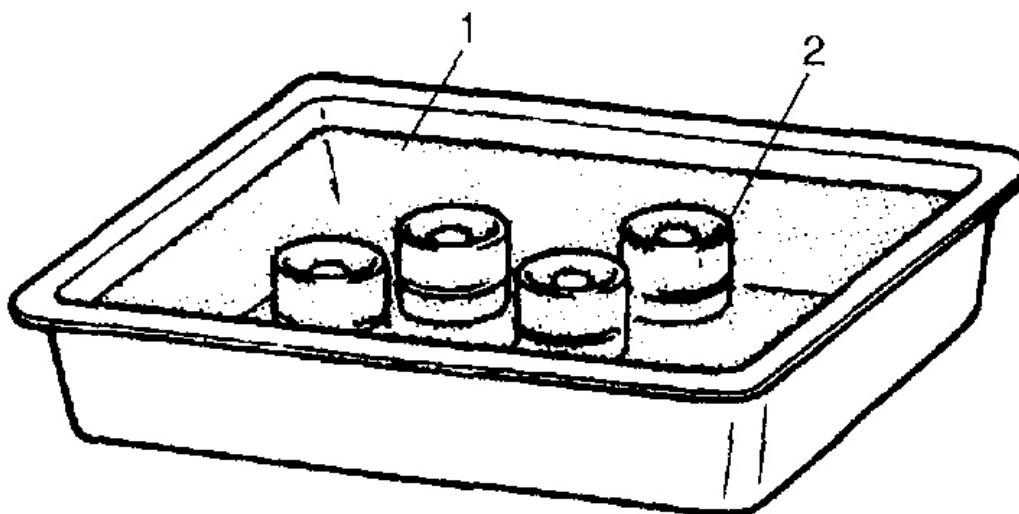
- Never disassemble hydraulic valve lash adjuster.
- Don't apply force (1) to body of adjuster, oil in high pressure chamber in adjuster will leak.



G02263983

Fig. 116: Removing Valve Lash Adjuster
Courtesy of SUZUKI OF AMERICA CORP.

NOTE: Immerse removed adjuster (2) in clean engine oil (1) and keep it there till reinstalling it so as to prevent oil leakage. If it is left in air, place it with its bucket body facing down. Don't place on its side or with bucket body facing up.



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Fig. 117: Immersing Hydraulic Valve Lash Adjusters In Clean Engine Oil
Courtesy of SUZUKI OF AMERICA CORP.

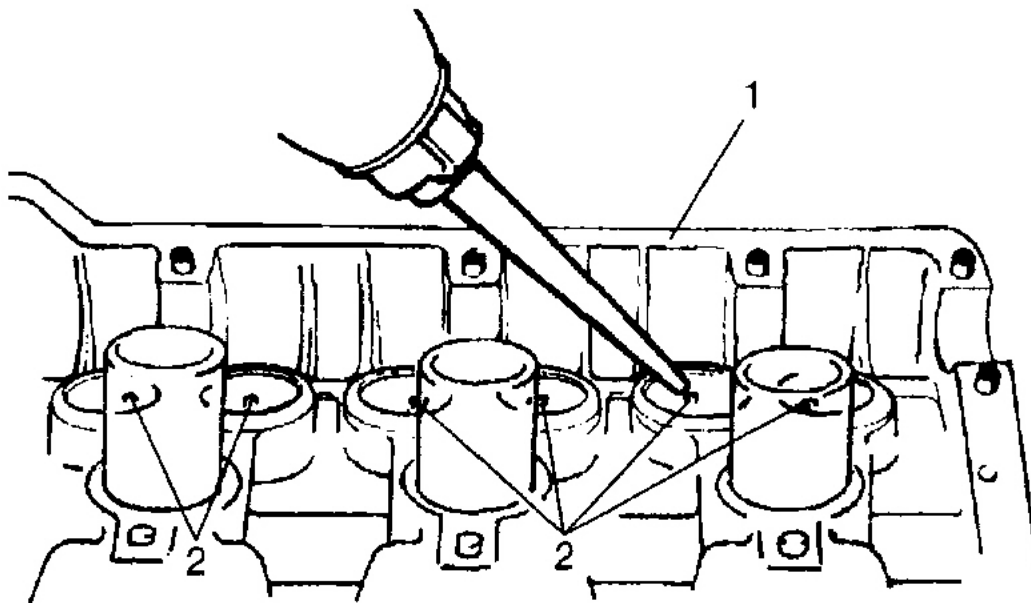
Installation

- CAUTION:**
- Don't turn camshafts or start engine (i.e., valves should not be operated) for about half an hour after reinstalling hydraulic valve lash adjusters and camshafts. As it takes time for valves to settle in place, operating engine within half an hour after their installation may cause interference to occur between valves themselves or valves and piston.
 - If air is trapped in valve lash adjuster, valve may make tapping sound when engine is operated after valve lash adjuster is installed. In such a case, run engine for about half an hour at about 2000 to 3000 rpm, and then air will be purged and tapping sound will cease. Should tapping sound not cease, it is possible that valve lash adjuster is defective. Replace it if defective.
 - If defective adjuster can't be located by hearing among 24 of them, check as follows.

- Stop engine and remove cylinder head cover.
 - Push adjuster downward by hand (with less than 200 N (20 kg, 44 lbs) of force) when cam crest is not on adjuster to be checked and check if clearance exists between cam and adjuster. If it does, adjuster is defective and needs replacement.
1. Before installing valve lash adjuster to cylinder head, fill oil passage of cylinder head (1) with engine oil according to the following procedure.

Pour engine oil through oil holes (2) and check that oil comes out from oil holes (2) in sliding part of valve lash adjuster.

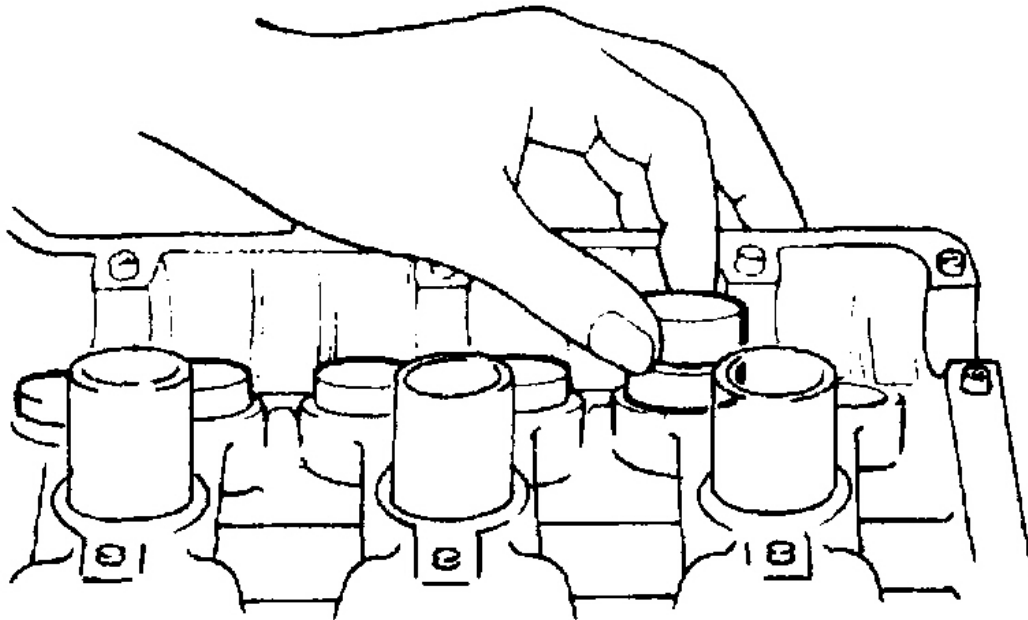
Perform this check on both intake and exhaust sides.



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Fig. 118: Filling Oil Passage Of Cylinder Head With Engine Oil
Courtesy of SUZUKI OF AMERICA CORP.

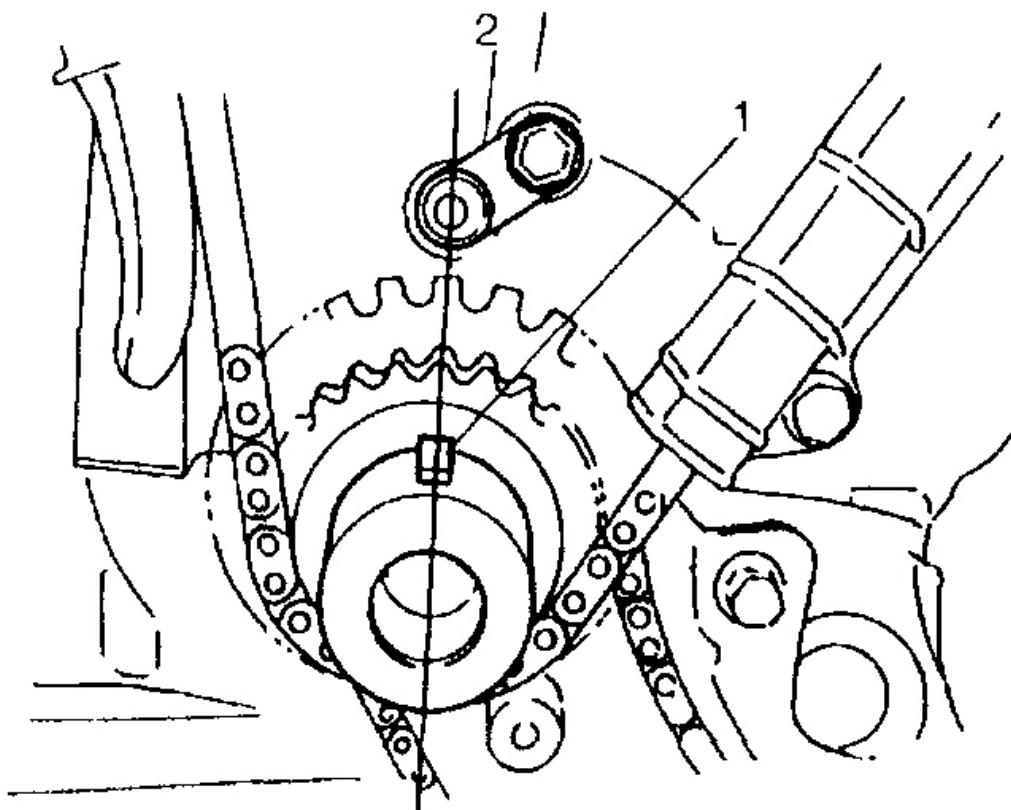
2. Apply engine oil around valve lash adjuster and then install it to cylinder head.



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Fig. 119: Installing Valve Lash Adjuster
Courtesy of SUZUKI OF AMERICA CORP.

3. Check timing mark on crankshaft as shown in the figure.



1. Crank timing pulley key

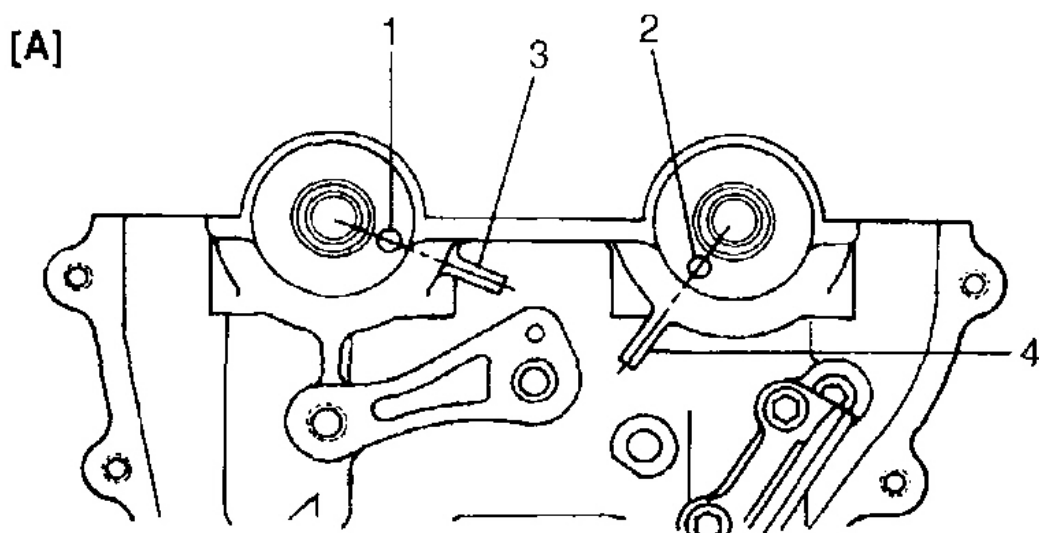
2. Oil jet

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Fig. 120: Checking Timing Mark On Crankshaft
Courtesy of SUZUKI OF AMERICA CORP.

4. Install RH bank camshafts referring to **RH (NO. 2) BANK 2ND TIMING CHAIN & CHAIN TENSIONER INSTALLATION**.
5. Install LH bank camshafts.

Apply oil to sliding surface of each camshaft and camshaft journal then install them by aligning match marks (4) on cylinder head (3) and LH bank camshafts as shown in the figure.



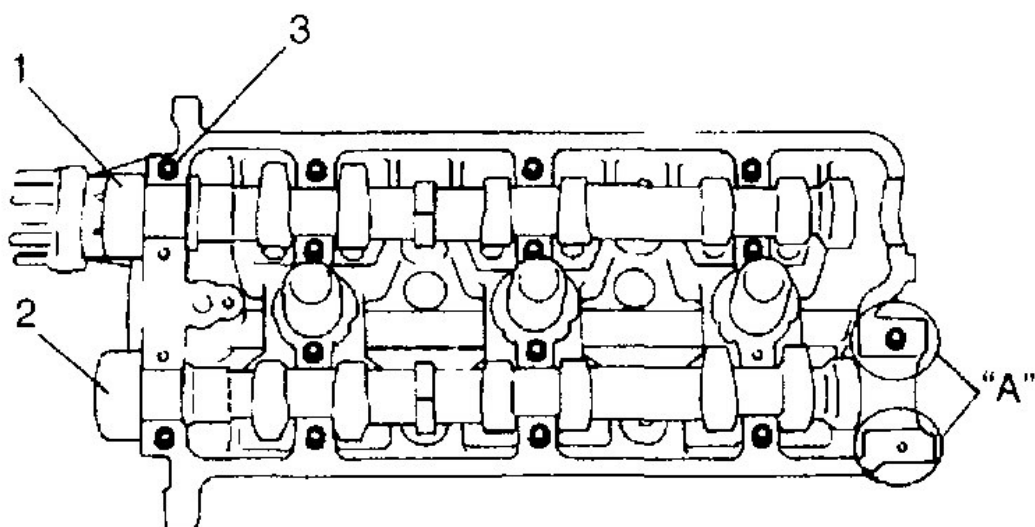
[A]: LH bank
1. LH bank intake camshaft
2. LH bank exhaust camshaft

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Fig. 121: Installing LH Bank Camshafts
Courtesy of SUZUKI OF AMERICA CORP.

6. Install LH bank camshaft housing pins as shown in the figure.
7. Apply sealant "A" to LH bank exhaust camshaft housing No. 5 sealing surface area as shown.

"A": Water tight sealant 99000-31250



1. LH bank intake camshaft

2. LH bank exhaust camshaft

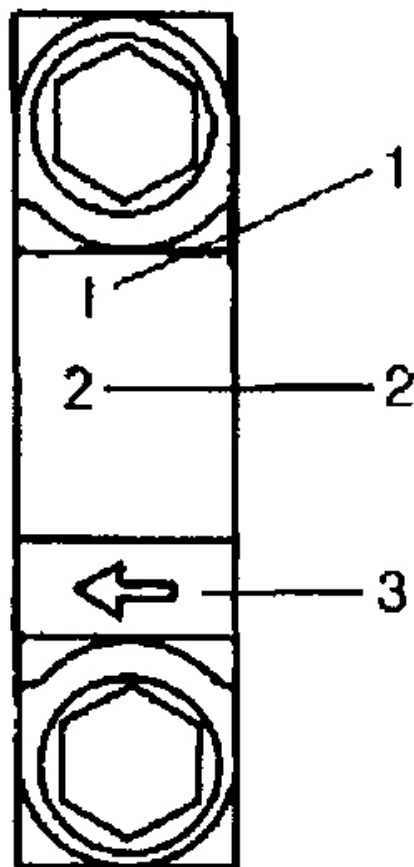
3. Pin installation position

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Fig. 122: Applying Sealant To LH Bank Exhaust Camshaft Housing No. 5 Sealing Surface Area
Courtesy of SUZUKI OF AMERICA CORP.

8. Check position of LH bank camshaft housings.

Embossed marks are provided on each camshaft housing, indicating position and direction for installation. Install housings as indicated by these marks.



1. I: Intake side, E: Exhaust side

2. Position from timing chain side

3. Timing chain side

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Fig. 123: Identifying Embossed Marks On LH Bank Camshaft Housings
Courtesy of SUZUKI OF AMERICA CORP.

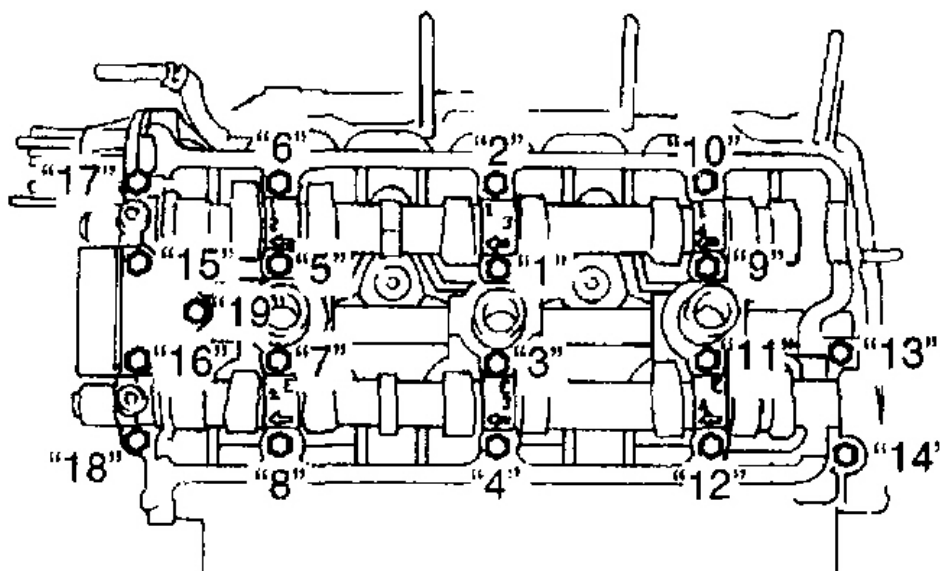
9. After applying oil to housing bolts, tighten them temporarily first.

Then tighten them by following sequence ("1" - "19") as indicated in the figure. Tighten a little at a time and evenly among bolts and repeat tightening sequence 2 or 3 times before they are tightened to specified torque below.

Tightening torque

Camshaft housing bolt: Tighten 12 N m (1.2 kg-m, 9.0 lb-ft) by the specified procedure

[A]



[A]: LH bank

G02263991

Fig. 124: Identifying Camshaft Housing Bolts Torque Sequence
Courtesy of SUZUKI OF AMERICA CORP.

10. Install 1st timing chain. Refer to 1ST TIMING CHAIN & CHAIN TENSIONER INSPECTION.
11. Install LH bank 2nd timing chain. Refer to LH (NO. 1) BANK 2ND TIMING CHAIN & CHAIN TENSIONER INSTALLATION.
12. Install timing chain cover. Refer to TIMING CHAIN COVER REMOVAL & INSTALLATION.

13. Install oil pan referring to **OIL PAN & OIL PUMP STRAINER REMOVAL & INSTALLATION** .
14. Install front differential housing referring to **FRONT DIFFERENTIAL DISMOUNTING & REMOUNTING** .
15. Install P/S system referring to **P/S PUMP REMOVAL & INSTALLATION** .
16. Install cooling system referring to **COOLING FAN & FAN CLUTCH REMOVAL & INSTALLATION** and **RADIATOR REMOVAL & INSTALLATION** .
17. Install intake manifold with throttle body.

Refer to **THROTTLE BODY & INTAKE MANIFOLD REMOVAL & INSTALLATION (H25 ENGINE)** .

18. Install CMP sensor. Refer to **CAMSHAFT POSITION (CMP) SENSOR REMOVAL & INSTALLATION**
19. Refill cooling system with coolant, front differential with gear oil, P/S system with specified fluid and engine with engine oil.
20. Check wheel alignment referring to **SPECIFICATIONS & PROCEDURES** .
21. Verify that there is no fuel leakage, water leakage and oil leakage at each connection.
22. Check ignition timing, referring to **IGNITION TIMING CHECK & ADJUSTMENT** .

CAMSHAFTS & CAMSHAFT HOUSINGS INSPECTION

Cam Wear

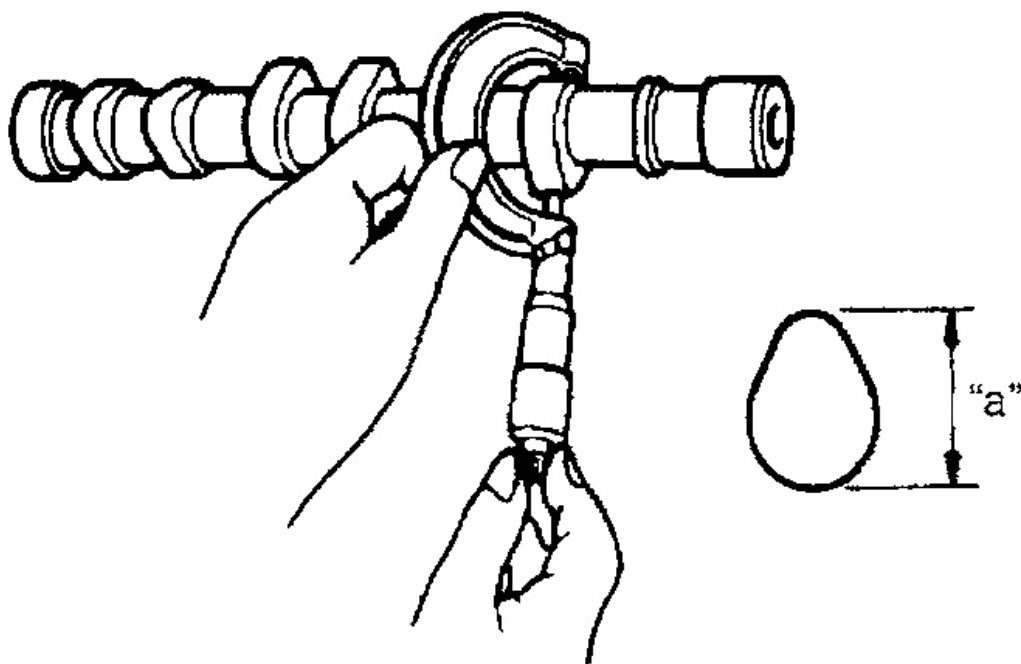
Using a micrometer, measure cam height "a". If measured height is below its limit, replace camshaft.

Cam height specifications

		Intake cam	Exhaust cam
H25 engine model	Standard	39.445 – 39.605 mm (1.5530 – 1.5593 in.)	39.428 – 39.588 mm (1.5523 – 1.586 in.)
	Limit	39.400 mm (1.5512 in.)	39.400 mm (1.5512 in.)
H27 engine model	Standard	40.402 – 40.562 mm (1.5906 – 1.5969 in.)	39.428 – 39.588 mm (1.5523 – 1.586 in.)
	Limit	40.300 mm (1.3581 in.)	39.400 mm (1.5512 in.)

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Fig. 125: Cam Height Specifications Table
Courtesy of SUZUKI OF AMERICA CORP.



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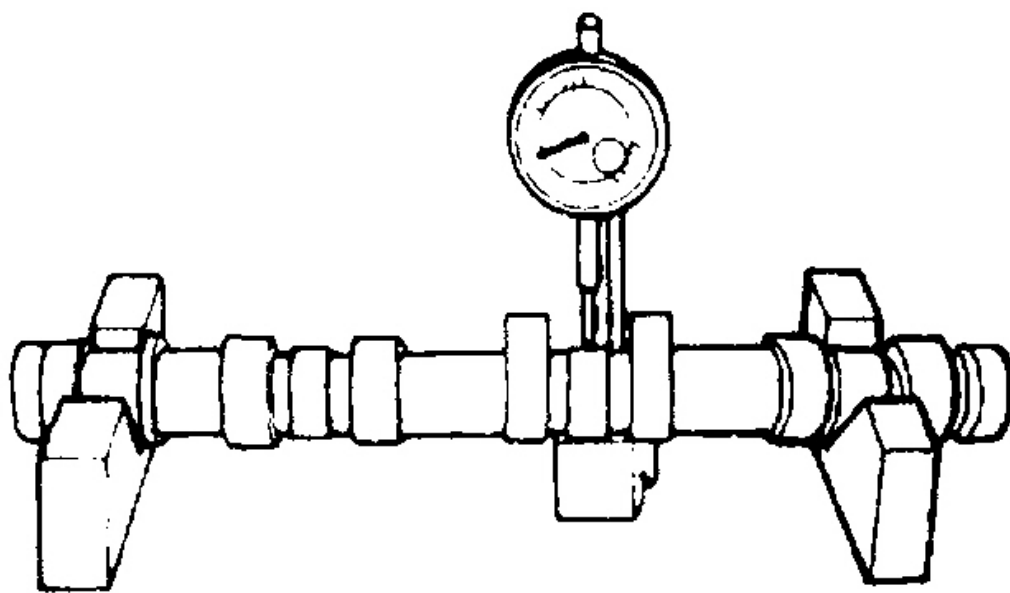
Fig. 126: Using A Micrometer To Measure Cam Height
Courtesy of SUZUKI OF AMERICA CORP.

Camshaft Runout

Set camshaft between two "V" blocks, and measure its runout by using a dial gauge.

If measured runout exceeds specified limit, replace camshaft.

Camshaft runout limit: 0.10 mm (0.004 in.)



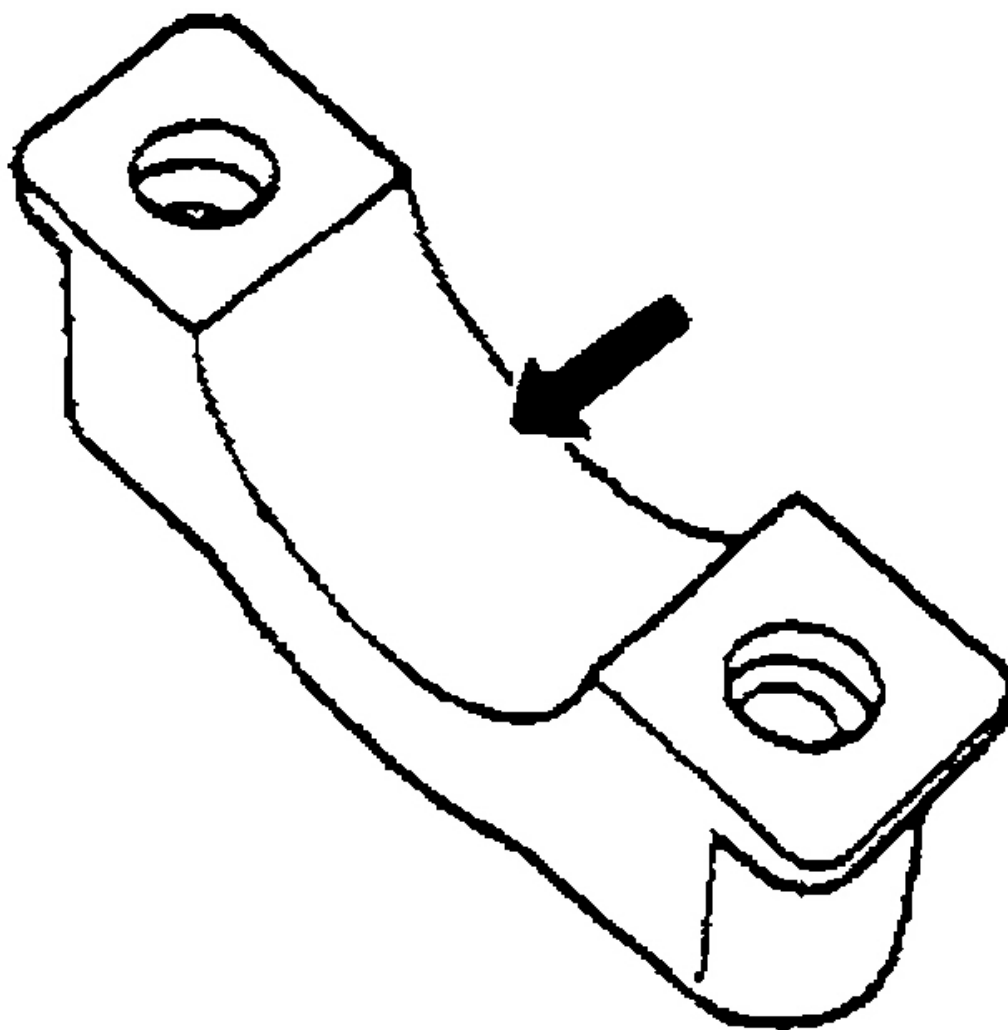
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Fig. 127: Measuring Camshaft Runout
Courtesy of SUZUKI OF AMERICA CORP.

Camshaft Journal Wear

Check camshaft journals and camshaft housings for pitting, scratches, wear or damage.

If any malfunction is found, replace camshaft or cylinder head with housing. Never replace cylinder head without replacing housings.



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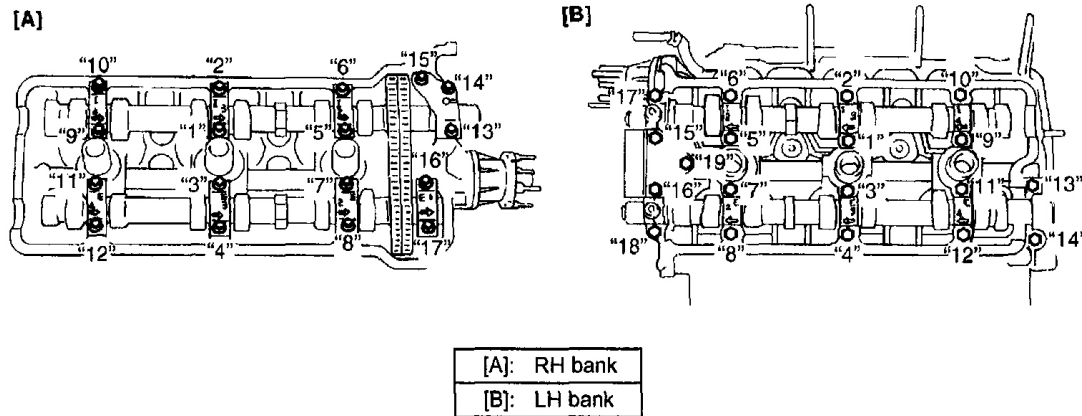
Fig. 128: Checking Camshaft Housings
Courtesy of SUZUKI OF AMERICA CORP.

Check clearance by using gauging plastic. The procedure is as follows.

1. Clean housings and camshaft journals.
2. Make sure that all valve lash adjusters are removed and install camshaft to cylinder head.
3. Place a piece of gauging plastic the full width of journal of camshaft (parallel to camshaft).
4. Install camshaft housing.

5. Tighten camshaft housing bolts in such order ([A]: "1" -->"17", [B]: "1" -->"19") as shown in the figure a little at a time till they are tightened to specified torque.

NOTE: Do not rotate camshaft while gauging plastic is installed.



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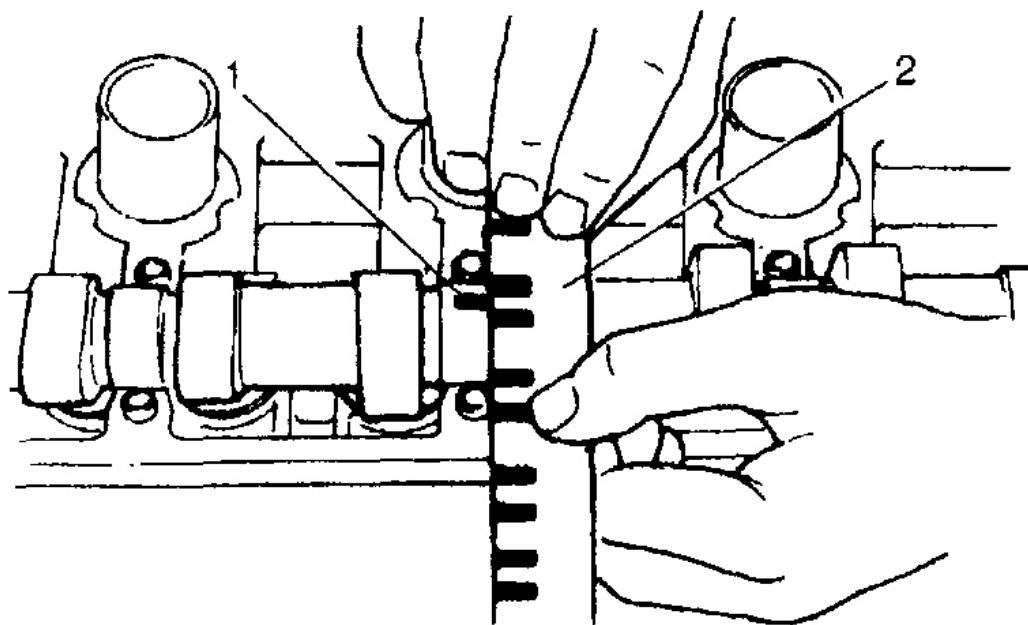
Fig. 129: Identifying Camshaft Housing Bolts Torque Sequence
 Courtesy of SUZUKI OF AMERICA CORP.

6. Remove housing, and using scale (2) on gauging plastic (1) envelop, measure gauging plastic (1) width at its widest point.

Camshaft journal clearance

Standard: 0.020 - 0.074 mm (0.0008 - 0.0029 in.)

Limit: 0.12 mm (0.0047 in.)



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Fig. 130: Measuring Gauging Plastic
Courtesy of SUZUKI OF AMERICA CORP.

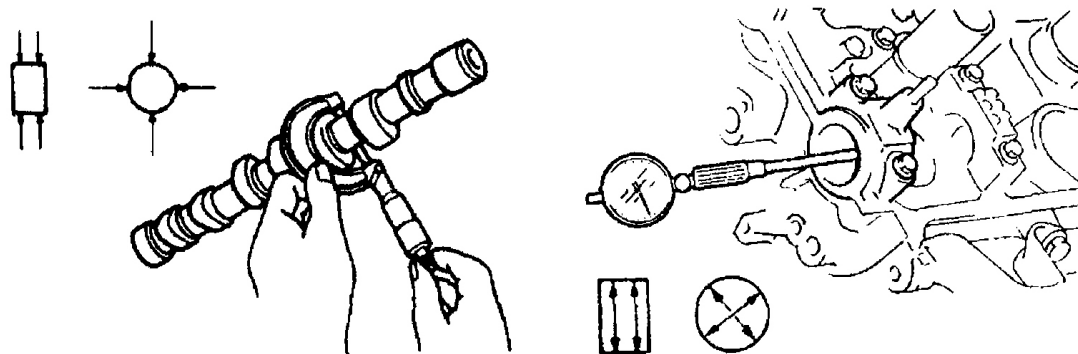
If measured camshaft journal clearance exceeds limit, measure journal (housing) bore and outside diameter of camshaft journal. Replace camshaft or cylinder head assembly whichever the difference from specification is greater.

Camshaft journal bore via. (IN and EX)

Standard: 26.000 - 26.033 mm (1.0236 - 1.0249 in.)

Camshaft journal O.D. (IN and EX)

Standard: 25.959 - 25.980 mm (1.0220 - 1.0228 in.)

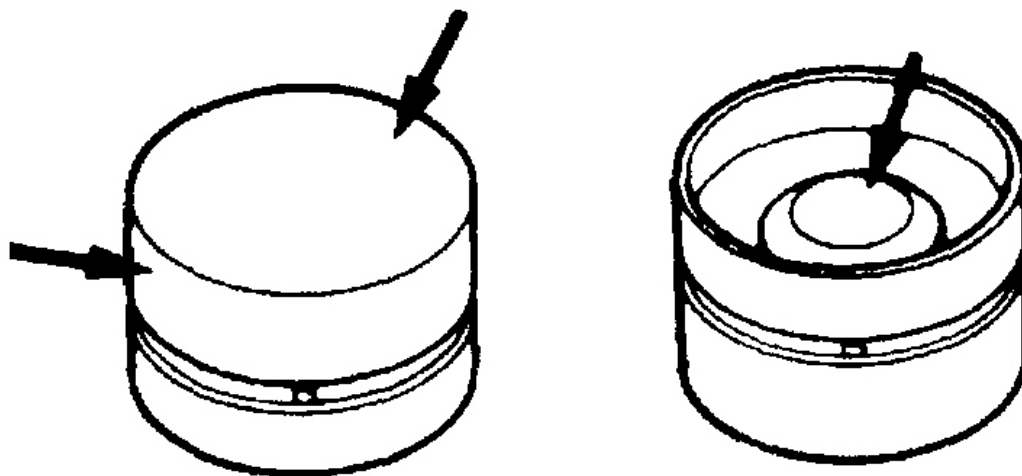


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Fig. 131: Measuring Journal (Housing) Bore & Outside Diameter Of Camshaft Journal
 Courtesy of SUZUKI OF AMERICA CORP.

VALVE LASH ADJUSTERS INSPECTION

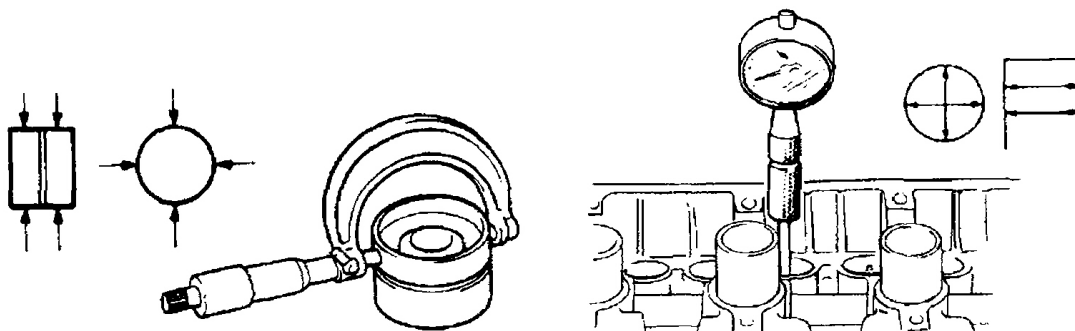
Check adjuster for pitting, scratches, or damage. If any malcondition is found, replace.



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Fig. 132: Checking Valve Lash Adjusters
 Courtesy of SUZUKI OF AMERICA CORP.

Measure cylinder head bore and adjuster outside diameter to determine cylinder head-to-adjuster clearance. If clearance exceeds limit, replace adjuster or cylinder head.

Hydraulic valve lash adjuster O.D.**Standard:** 30.959 - 30.975 mm (1.2188 - 1.2194 in.)**Cylinder head bore****Standard:** 31.000 - 31.025 mm (1.2205 - 1.2214 in.)**Cylinder head to adjuster clearance****Standard:** 0.025 - 0.066 mm (0.0010 - 0.0025 in.)**Limit:** 0.15 mm (0.0059 in.)

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Fig. 133: Measuring Cylinder Head Bore & Adjuster Outside Diameter
 Courtesy of SUZUKI OF AMERICA CORP.

VALVE LASH ADJUSTERS NOISE INSPECTION

In case of the followings, valve lash adjuster noise may be caused by air trapped into valve lash adjusters.

- Vehicle is left for 24 hours or more.
- Engine oil is changed.
- Hydraulic lash adjuster is replaced or reinstalled.
- Engine is overhauled.

If noise from valve lash adjusters is suspected, perform the following checks.

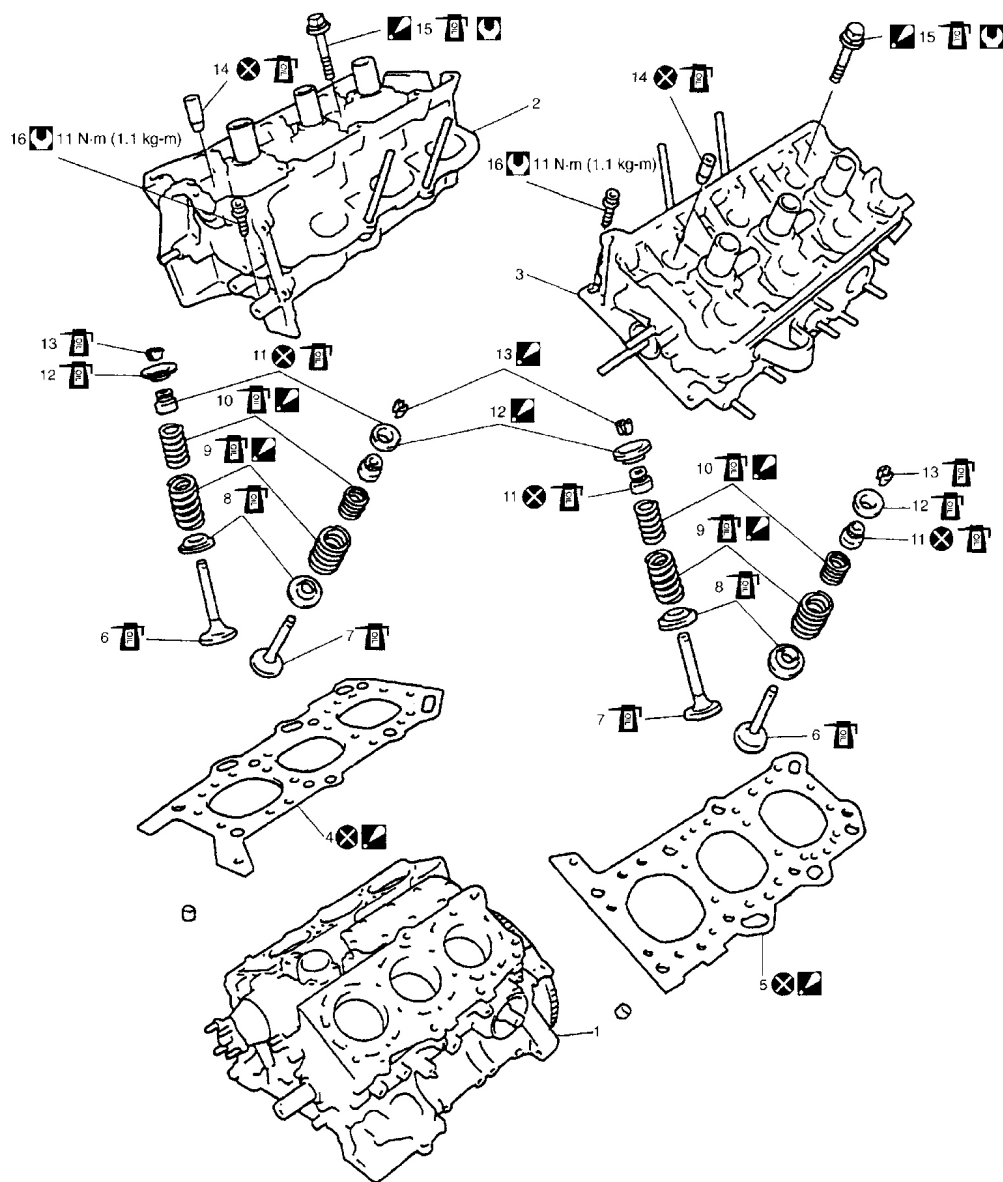
1. Check engine oil for the followings.
 - Oil level in oil pan - If oil level is low, add oil up to full level hole on oil level gauge.
 - Oil quality - If oil is discolored, or deteriorated, change it.
 - Oil leaks - If leak is found, repair it.

- Oil pressure (refer to **OIL PRESSURE CHECK**) - If defective pressure is found, repair it.
- 2. Run engine for about half an hour at about 2000 to 3000 rpm, and then air will be purge and tapping sound will cease.
- 3. Should tapping sound not cease, it is possible that hydraulic valve lash adjuster is defective.

Replace it if defective. If defective adjuster can't be located by hearing among 16 of them, check as follows.

- A. Stop engine and remove cylinder head cover.
- B. Push adjuster downward by hard (with less than 200 N (20 kg, 44 lbs) of force) when cam crest is not on adjuster to be check if clearance exists between cam and adjuster. If it does, adjuster is defective and needs replacement.

VALVES & CYLINDER HEADS COMPONENTS



1. Cylinder block	8. Valve spring seat	15. Cylinder head bolt : Tighten 53 N·m (5.3 kg-m, 38.5 lb-ft), 84 N·m (8.4 kg-m, 61.0 lb-ft), 0 N·m (0 kg-m, 0 lb-ft), 53 N·m (5.3 kg-m, 38.5 lb-ft) and 105 N·m (10.5 kg-m, 76.0 lb-ft) by the specified procedure.
2. RH bank cylinder head	9. Outer valve spring: Be sure to position spring in place with its bottom end (small-pitch end) facing the bottom (valve spring seat side).	16. Cylinder head bolt (hex hole bolt)
3. LH bank cylinder head	10. Inner valve spring: Be sure to position spring in place with its bottom end (small-pitch end) facing the bottom (valve spring seat side).	: Tightening torque
4. RH bank cylinder head gasket: Carved lot number on cylinder head gasket should face up (toward cylinder head side).	11. Valve stem oil seal	: Do not reuse.
5. LH bank cylinder head gasket: Carved lot number on cylinder head gasket should face up (toward cylinder head side).	12. Valve spring retainer	: Apply engine oil.
6. Exhaust valve	13. Valve cotter	
7. Intake valve	14. Valve guide	

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Fig. 134: Exploded View Of Valves & Cylinder Heads Components
 Courtesy of SUZUKI OF AMERICA CORP.

VALVES & CYLINDER HEADS REMOVAL & INSTALLATION

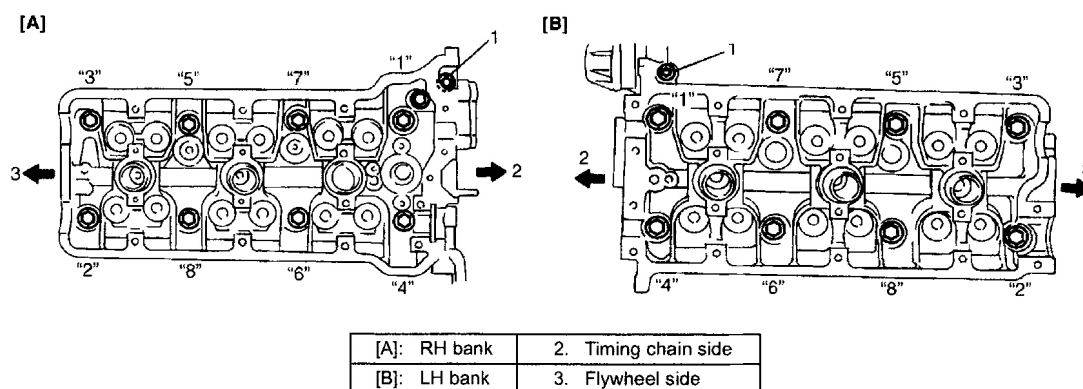
Removal

1. Relieve fuel pressure according to **FUEL PRESSURE RELIEF PROCEDURE** .
2. Disconnect negative (-) cable at battery.
3. Drain engine oil.
4. Drain coolant referring to **COOLANT DRAINING** .
5. Remove CMP sensor, camshaft and valve lash adjuster. Refer to **CAMSHAFT POSITION (CMP) SENSOR REMOVAL & INSTALLATION** for CMP sensor removal and **CAMSHAFTS & VALVE LASH ADJUSTERS REMOVAL & INSTALLATION** for camshaft and valve lash adjuster removal.

Install CMP sensor. Refer to **CAMSHAFT POSITION (CMP) SENSOR REMOVAL & INSTALLATION**

6. Remove exhaust manifold referring to **EXHAUST MANIFOLD REMOVAL & INSTALLATION** .
7. Remove water outlet cap.
8. Loosen cylinder head bolts in such order ("1" "8") as shown in the figure and remove them.

NOTE: Be sure to remove 2 hex bolts (1) shown in the figure.



G02264002

Fig. 135: Loosening Cylinder Head Bolts In Order
 Courtesy of SUZUKI OF AMERICA CORP.

9. Remove cylinder heads.

Installation

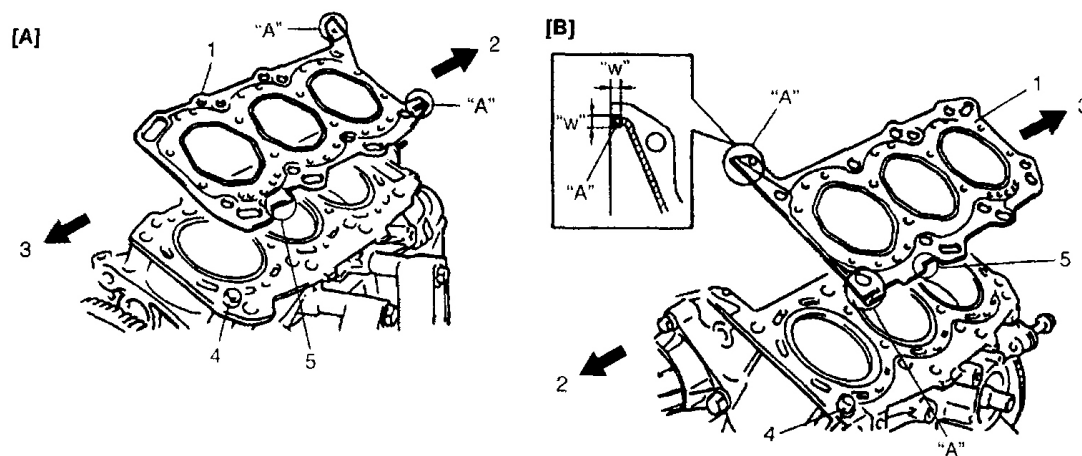
1. Clean mating surface on cylinder head and cylinder block. Remove oil, old gasket and dust from mating surface.
2. Install knock pin (4) to cylinder block.
3. Apply sealant "A" to cylinder head gasket (1) as shown in the figure.

"A": Water tight sealant 99000-31250

Sealant amount

Width "w": 4 mm (0.158 in.)

4. Install new cylinder head gasket (1) to cylinder block as shown in the figure. Carved lot number (5) on cylinder head gasket (1) should face up (toward cylinder head side).



[A]: RH (No.2) bank	2. Crankshaft pulley side
[B]: LH (No.1) bank	3. Flywheel side

G02264003

Fig. 136: Installing Cylinder Head Gasket
Courtesy of SUZUKI OF AMERICA CORP.

5. Install cylinder head to block.

After applying oil to cylinder head bolts, tighten them gradually as follows.

- A. Tighten cylinder head bolts (except hex hole bolt) to 53 N.m (5.3 kg-m, 38.5 lb-ft) according to numerical order in the figure.
- B. In the same manner as Step A , tighten them to 84 N.m (8.4 kg-m, 61.0 lb-ft).
- C. Loosen all bolts until tightening torque is reduced to 0 in reverse order of tightening.
- D. In the same manner as Step A , tighten them to 53 N.m (5.3 kg-m, 38.5 lb-ft).

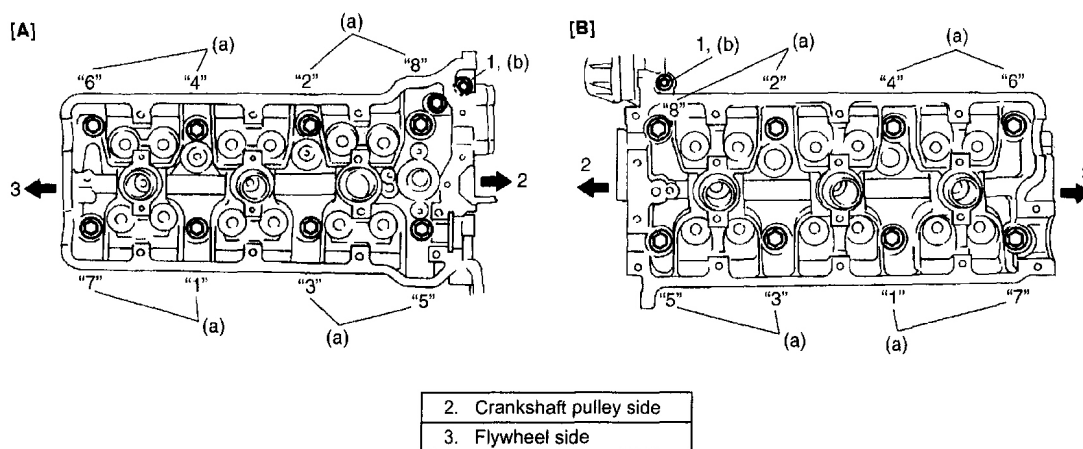
- E. In the same manner as Step A again, tighten them to specified torque.
- F. Tighten cylinder head bolts (hex hole bolt) to specified torque.

Tightening torque

Cylinder head bolt (a): Tighten 53 N.m (5.3 kg-m, 38.5 lb-ft), 84 N.m (8.4 kg-m, 61.0 lb-ft), 0 N.m (0 kg-m, 0 lb-ft), 53 N.m (5.3 kg-m, 38.5 lb-ft) and 105 N.m (10.5 kg-m, 76.0 lb-ft) by the specified procedure

Cylinder head bolt (hex hole bolt) (b): Tighten 11 N.m (1.1 kg-m, 7.5 lb-ft) by the specified procedure

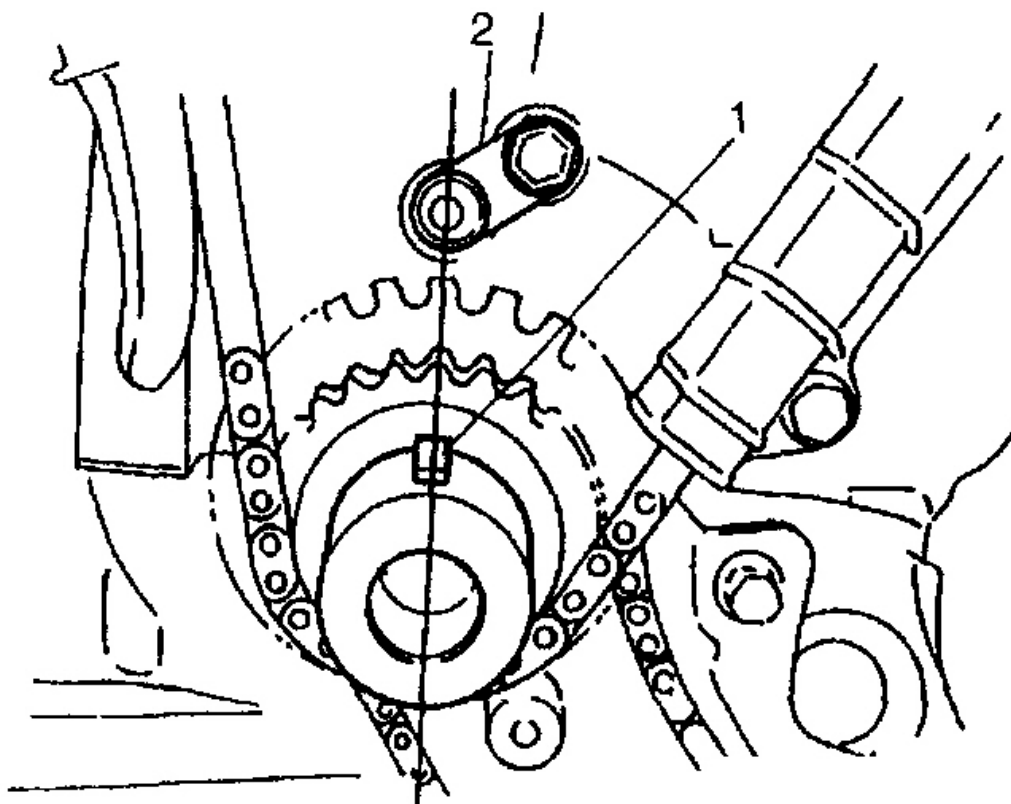
NOTE: Be sure to install hex hole bolts (1) as shown in the figure.



G02264004

Fig. 137: Installing Hex Hole Bolts
Courtesy of SUZUKI OF AMERICA CORP.

- 6. Install water outlet cap.
- 7. Check timing mark on crankshaft as shown in the figure.



1. Crank timing pulley key

2. Oil jet

G02264005

Fig. 138: Checking Timing Mark On Crankshaft
Courtesy of SUZUKI OF AMERICA CORP.

8. Install valve lash adjuster, camshaft, CMP sensor and RH bank 2nd timing chain.

Refer to **CAMSHAFTS & VALVE LASH ADJUSTERS REMOVAL & INSTALLATION** and **RH (NO. 2) BANK 2ND TIMING CHAIN & CHAIN TENSIONER INSTALLATION** . For CMP sensor, refer to **CAMSHAFT POSITION (CMP) SENSOR REMOVAL & INSTALLATION** .

9. Install 1st timing chain referring to **1ST TIMING CHAIN & CHAIN TENSIONER**

INSTALLATION .

10. Install LH bank 2nd timing chain referring to **LH (NO. 1) BANK 2ND TIMING CHAIN & CHAIN TENSIONER INSTALLATION** .
11. Install timing chain cover referring to **TIMING CHAIN COVER REMOVAL & INSTALLATION** .
12. Install oil pan and oil pump strainer referring to **OIL PAN & OIL PUMP STRAINER REMOVAL & INSTALLATION** .
13. Install cylinder head cover referring to **CYLINDER HEAD COVERS REMOVAL & INSTALLATION** .
14. Install exhaust manifold referring to **EXHAUST MANIFOLD REMOVAL & INSTALLATION** .
15. Install radiator outlet pipe, radiator, cooling fan and water hose.

Refer to **COOLING WATER PIPES OR HOSES REMOVAL & INSTALLATION** , **RADIATOR REMOVAL & INSTALLATION** and **COOLING FAN & FAN CLUTCH REMOVAL & INSTALLATION** .

16. Install intake manifold with throttle body.

Refer to **THROTTLE BODY & INTAKE MANIFOLD REMOVAL & INSTALLATION (H25 ENGINE)** .

17. Adjust water pump drive belt tension.

Refer to **COOLING FAN/GENERATOR BELT TENSION CHECK & ADJUSTMENT** .

18. Adjust power steering pump drive belt tension referring to **P/S PUMP DRIVE BELT INSPECTION & ADJUSTMENT** .
19. Adjust accelerator cable play and A/T throttle cable play. Refer to **ACCELERATOR CABLE ADJUSTMENT** and **A/T THROTTLE CABLE ADJUSTMENT (H25 ENGINE WITH A/T ONLY)** .
20. Check to ensure that all removed parts are back in place. Reinstall any necessary parts which have not been reinstalled.
21. Refill engine with engine oil .
22. Refill cooling system referring to **COOLING SYSTEM FLUSH & REFILL** .
23. Refill front differential housing with gear oil if drained.

Refer to **MANUAL TRANSMISSION GEAR OIL INSPECTION & CHANGE** .

24. Connect negative (-) cable at battery.
25. Check ignition timing and adjust as necessary referring to **IGNITION TIMING CHECK & ADJUSTMENT** .
26. Verify that there is no fuel leakage, water leakage, oil leakage and exhaust gas leakage at each connection.
27. Check wheel alignment referring to **SPECIFICATIONS & PROCEDURES** .

VALVES & CYLINDER HEADS DISASSEMBLY & ASSEMBLY**Disassembly**

1. Using special tools (A), (B) and (C), compress valve springs and then remove valve cotters (1) by using special tool (D).
2. Release special tool, and remove spring retainer and valve spring.

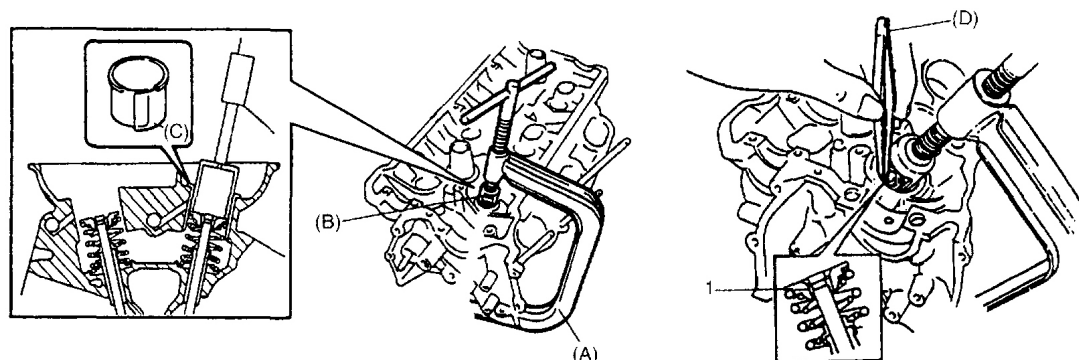
Special tool

(A): 09916-14510

(B): 09916-14910

(C): 09919-28610

(D): 09916-84511

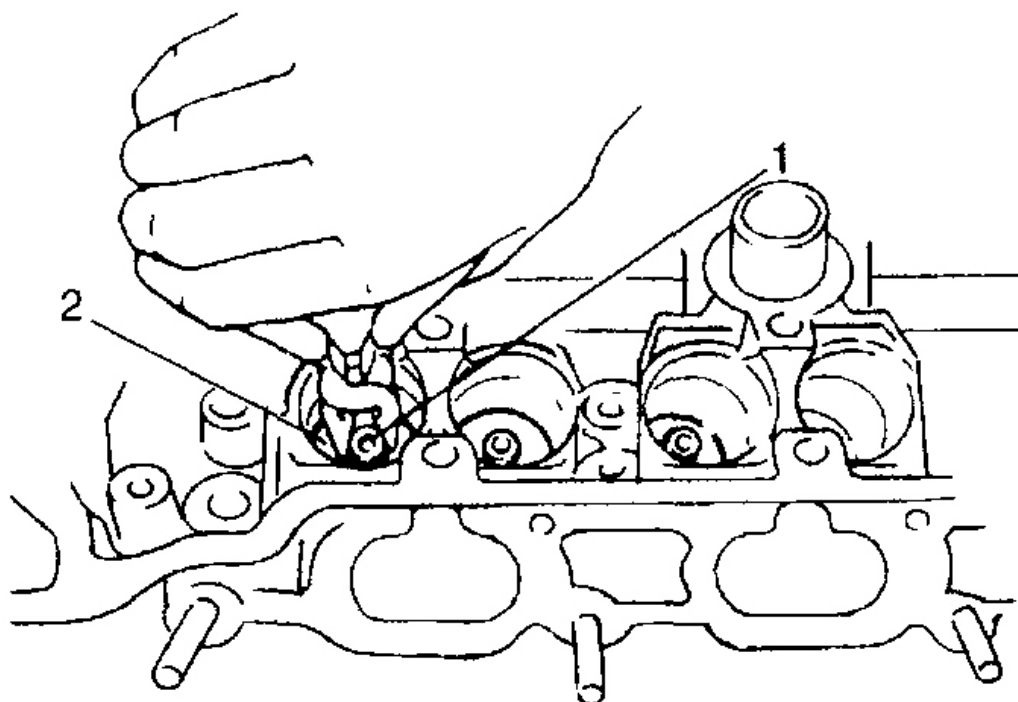


G02264006

Fig. 139: Compressing Valve Springs & Removing Valve Cotters
Courtesy of SUZUKI OF AMERICA CORP.

3. Remove valve from combustion chamber side.
4. Remove valve stem seal (1) from valve guide, and then valve spring seat (2).

NOTE: Do not reuse seal once disassembled. Be sure to use new seal when assembling.



G02264007

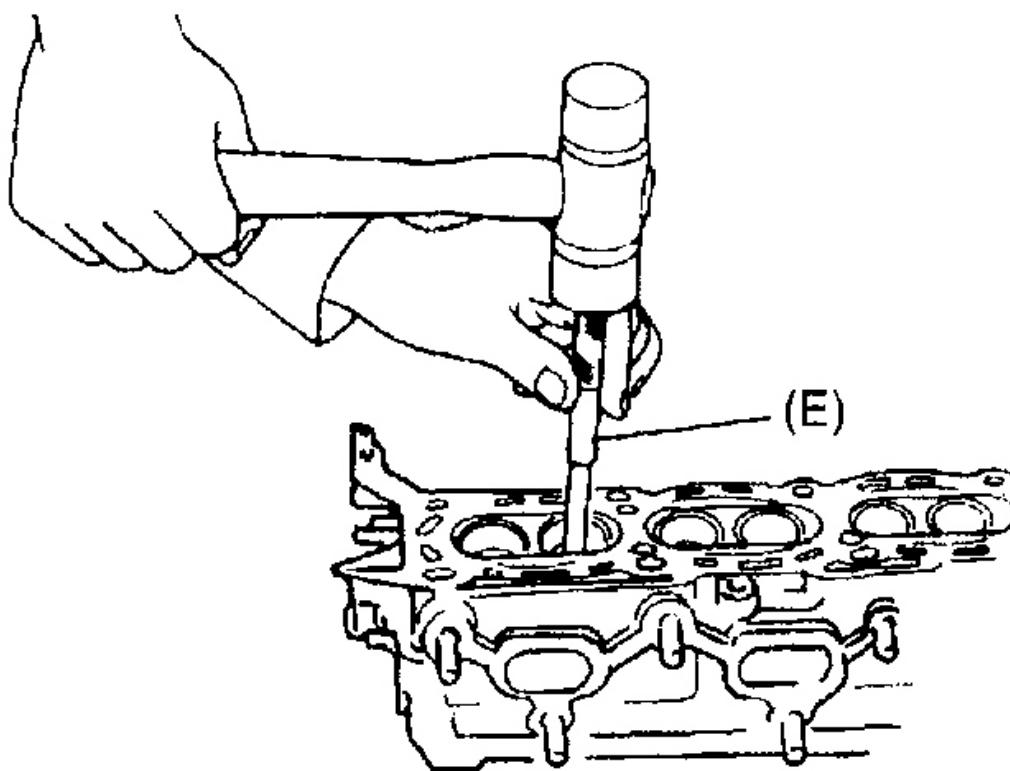
Fig. 140: Removing Valve Stem Seal & Valve Spring Seat
Courtesy of SUZUKI OF AMERICA CORP.

5. Using special tool (E) (Valve guide remover), drive valve guide out from combustion chamber side to valve spring side.

Special tool

(E): 09916-44910

NOTE: Do not reuse valve guide once disassembled. Be sure to use new valve guide (Oversize) when assembling.



G02264008

Fig. 141: Driving Valve Guide Out From Combustion Chamber Side
Courtesy of SUZUKI OF AMERICA CORP.

6. Place disassembled parts except valve stem seal and valve guide in order so that they can be installed in their original positions.

Assembly

1. Before installing valve guide into cylinder head, ream guide hole with special tool (11 mm reamer) so as to remove burrs and make it truly round.

Special tool

(E): 09916-34542

(F): 09916-38210

2. Install valve guide to cylinder head.

Heat cylinder head uniformly at a temperature of 80 to 100 °C (176 to 212° F) so that head will not be distorted, and drive new valve guide into hole with special tools. Drive in new valve guide until special tool (Valve guide installer) contacts cylinder head.

After installing, make sure that valve guide protrusions (1) by specified height from cylinder head.

Special tool

(G): 09916-58210

(H): 09917-87810

NOTE:

- Do not reuse valve guide once disassembled. Install new valve guide (Oversize).
- Intake and exhaust valve guides are identical.

Width of oversized valve guide: 11.088 - 11.103 mm (0.4365 - 0.4371 in.)

Valve guide protrusion (In and Ex): 13.5 mm (0.53 in.)

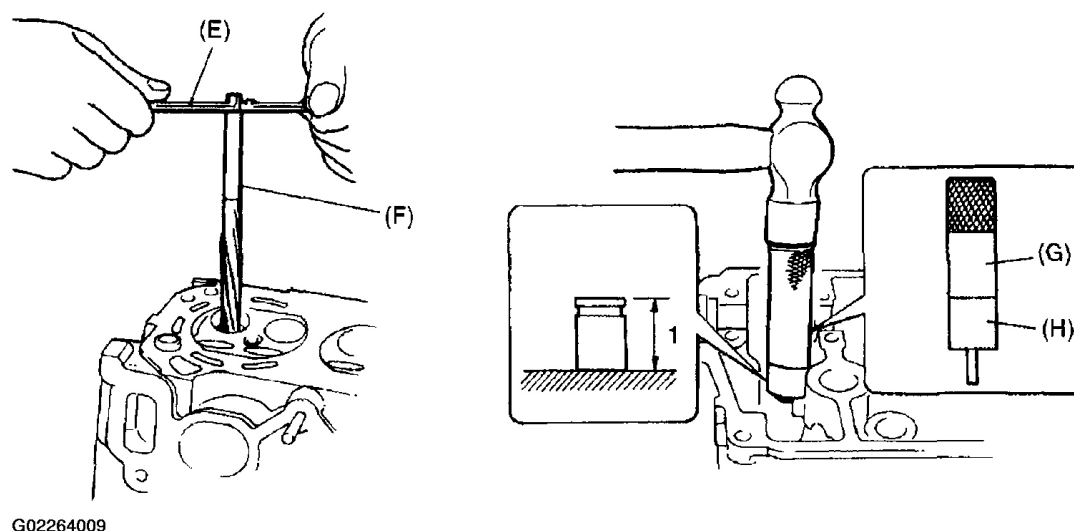


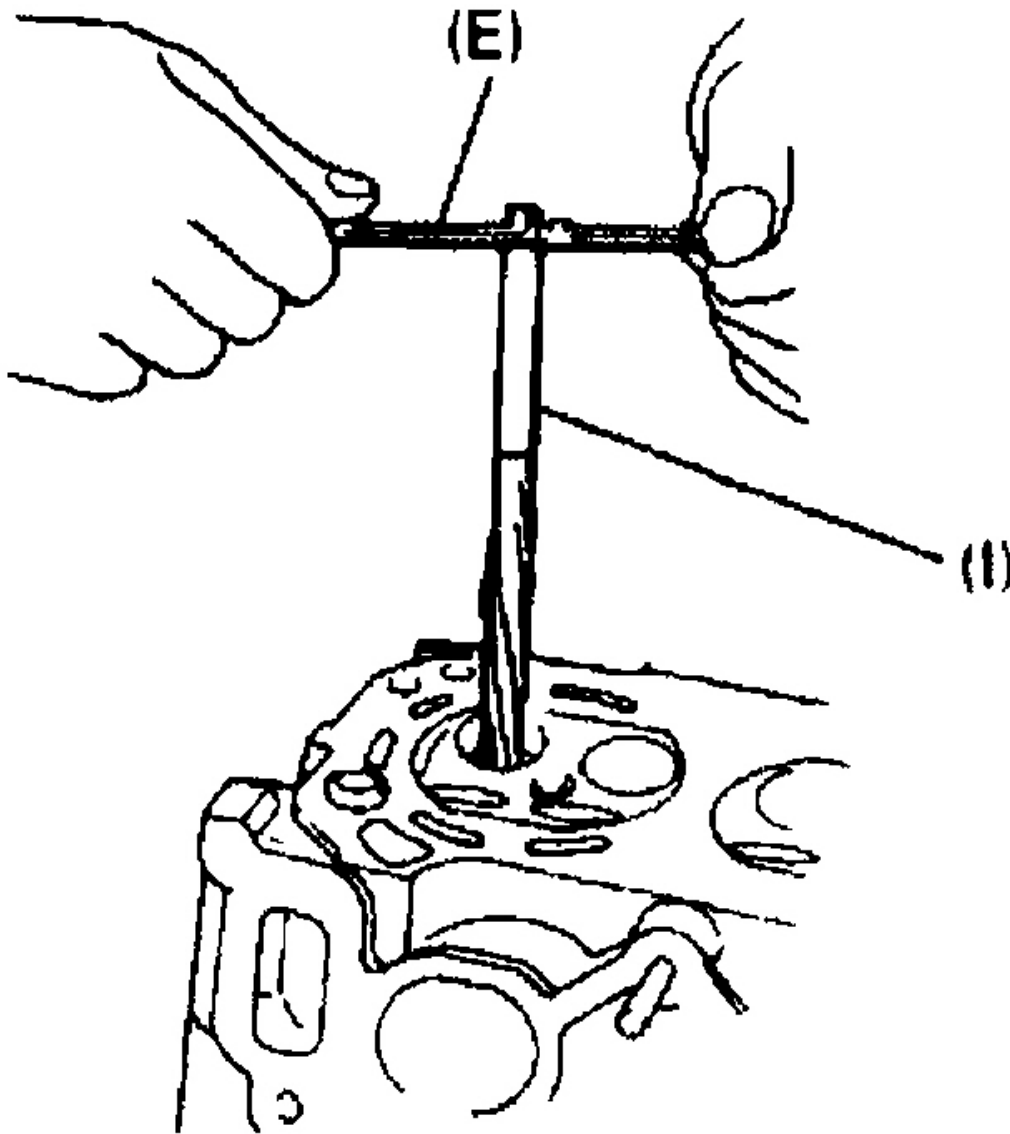
Fig. 142: Reaming Valve Guide & Checking Installed Height
Courtesy of SUZUKI OF AMERICA CORP.

3. Ream valve guide bore with special tool (6.0 mm reamer). After reaming, clean bore.

Special tool

(E): 09916-34542

(I): 09916-37810



G02264010

Fig. 143: Reaming Valve Guide
Courtesy of SUZUKI OF AMERICA CORP.

4. Install valve spring seat to cylinder head.
5. Install new valve stem seal (1) to valve guide.

After applying engine oil to seal and spindle of special tool (Valve guide installer handle), fit oil seal to spindle, and then install seal to valve guide by pushing special tool by hand.

After installing, check to be sure that seal is properly fixed to valve guide.

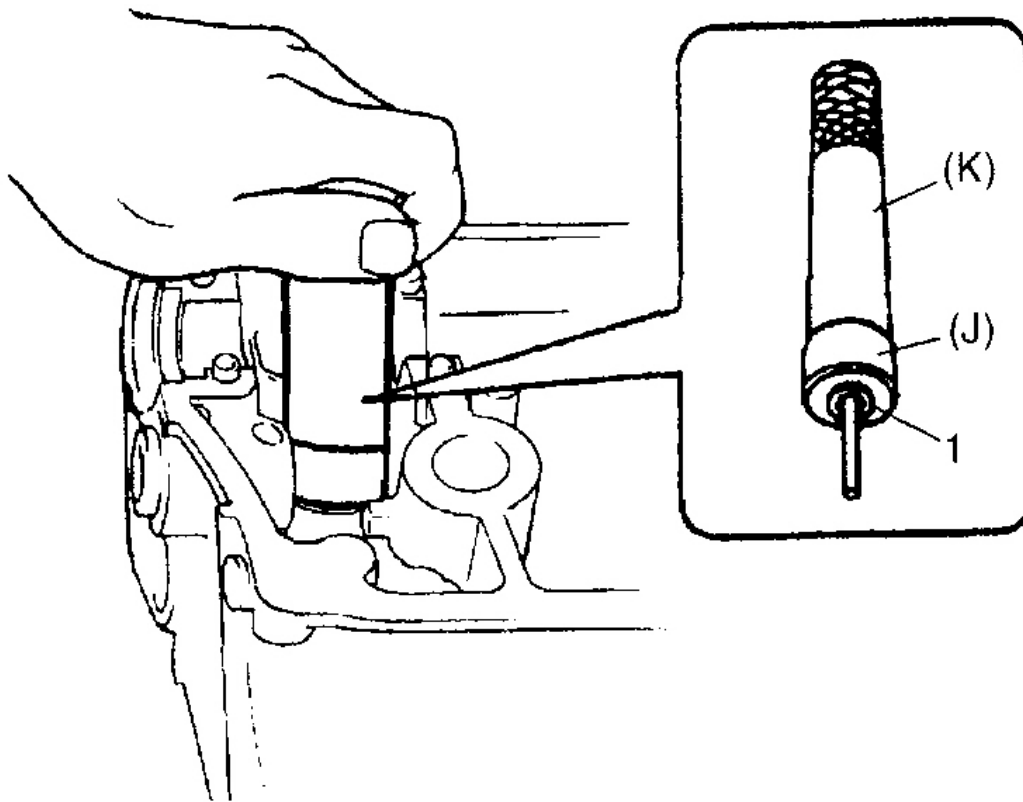
Special tool

(J): 09917-98221

(K): 09916-58210

NOTE:

- **Do not reuse seal once disassembled. Be sure to install new seal.**
- **When installing, never tap or hit special tool with a hammer or else. Install seal to guide only by pushing special tool by hand. Tapping or hitting special tool may cause damage to seal.**

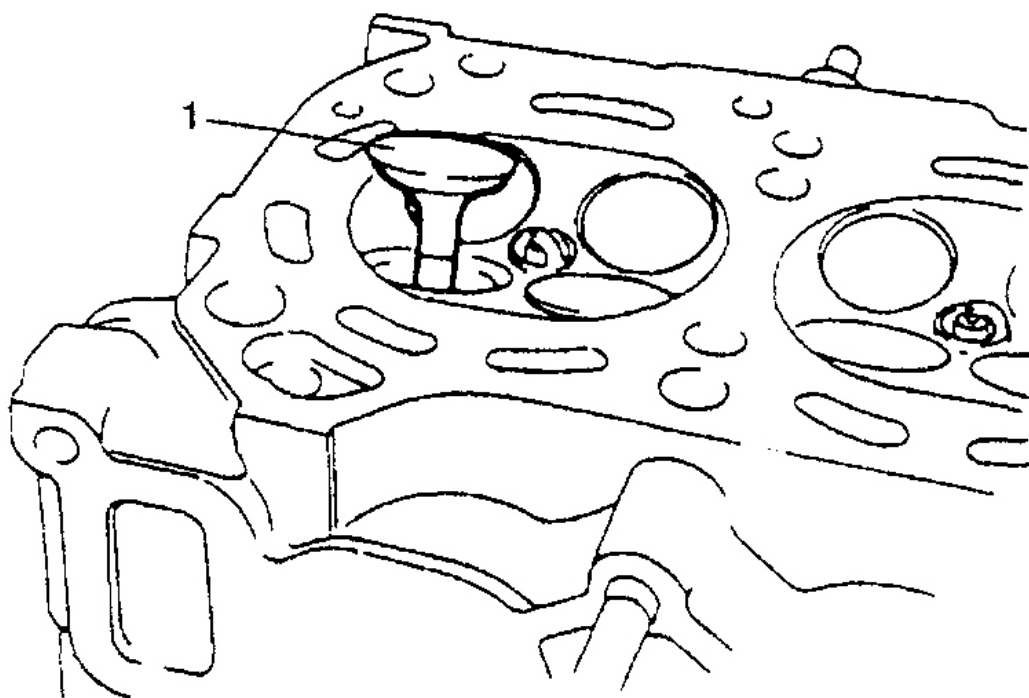


G02264011

Fig. 144: Installing New Valve Stem Seal
Courtesy of SUZUKI OF AMERICA CORP.

6. Install valve (1) to valve guide.

Before installing valve to valve guide, apply engine oil to stem seal, valve guide bore, and valve stem.

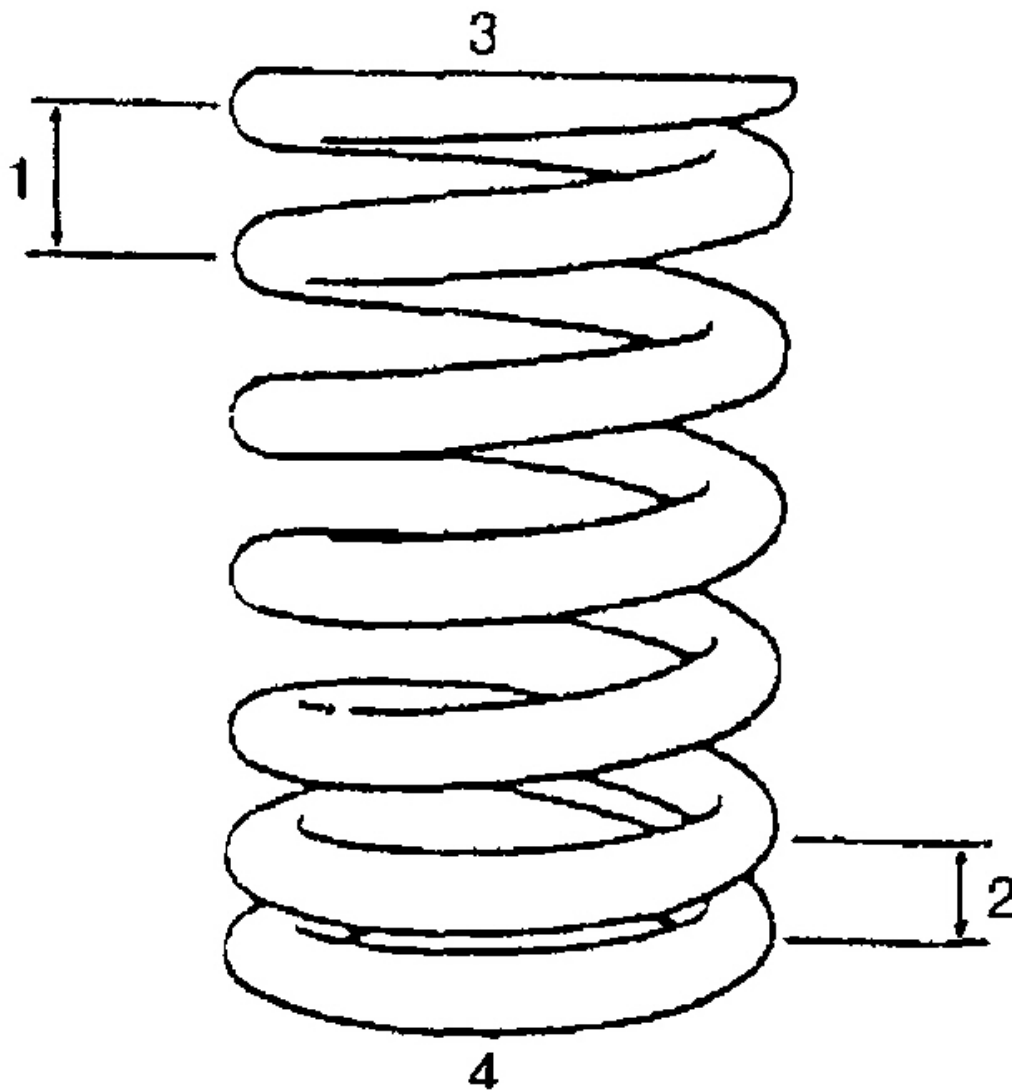


G02264012

Fig. 145: Installing Valve**Courtesy of SUZUKI OF AMERICA CORP.**

7. Install valve springs (inner and outer) and spring retainer.

Each valve spring has top end (large-pitch end (1)) and bottom end (small-pitch end (2)). Be sure to position spring in place with its bottom end (valve spring retainer side (3)) facing the bottom (valve spring seat side (4)).



G02264013

Fig. 146: Identifying Valve Spring Ends
Courtesy of SUZUKI OF AMERICA CORP.

8. Using special tool (Valve lifter), compress valve spring and fit 2 valve cotters (1) into groove in valve stem.

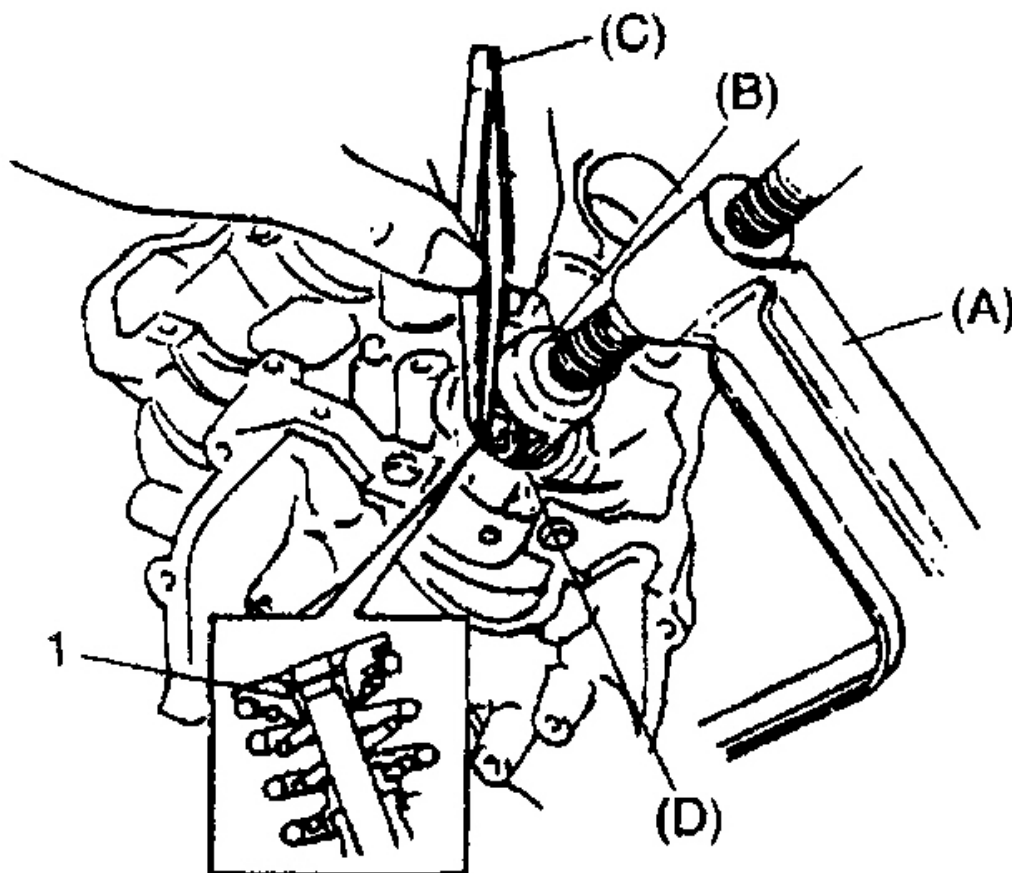
Special tool

(A): 09916-14510

(B): 09916-14910

(C): 09916-84511

(D): 09919-28610



G02264014

Fig. 147: Compressing Valve Spring & Fitting Valve Cotters
Courtesy of SUZUKI OF AMERICA CORP.

VALVES & VALVE GUIDES INSPECTION

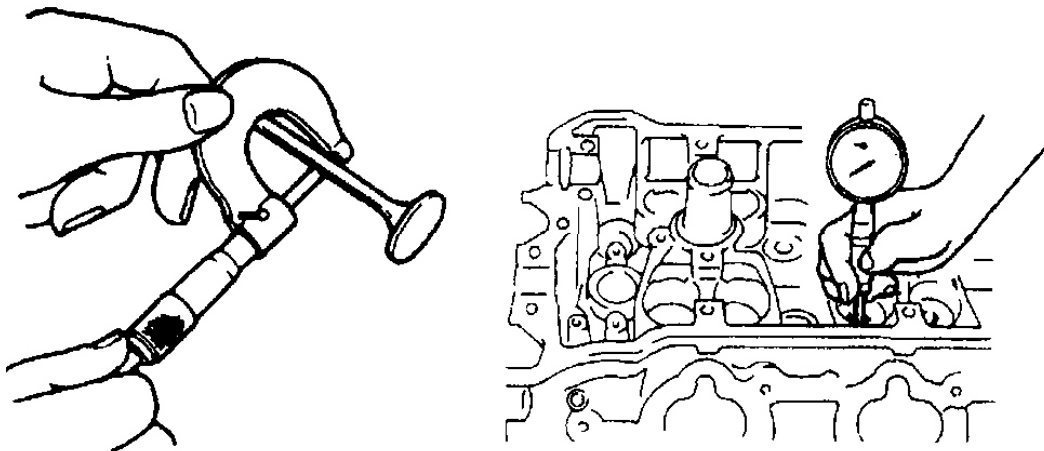
Valve Guides

Using a micrometer and bore gauge, take diameter readings on valve stems and guides to check stem-to-guide clearance. Be sure to take reading at more than one place along the length of each stem and guide. If clearance exceeds limit, replace valve and valve guide.

Item		Standard	Limit
Valve stem diameter	Intake	5.965 – 5.980 mm (0.2348 – 0.2354 in.)	—
	Exhaust	5.940 – 5.955 mm (0.2339 – 0.2344 in.)	—
Valve guide I.D.	In and Ex	6.000 – 6.012 mm (0.2362 – 0.2367 in.)	—
Stem-to-guide clearance	Intake	0.020 – 0.047 mm (0.0008 – 0.0019 in.)	0.07 mm (0.0028 in.)
	Exhaust	0.045 – 0.072 mm (0.0018 – 0.0028 in.)	0.09 mm (0.0035 in.)

G02264015

Fig. 148: Valve Stem-To-Guide Clearance Chart
Courtesy of SUZUKI OF AMERICA CORP.



G02264016

Fig. 149: Measuring Valve Stems & Guides
Courtesy of SUZUKI OF AMERICA CORP.

Valves

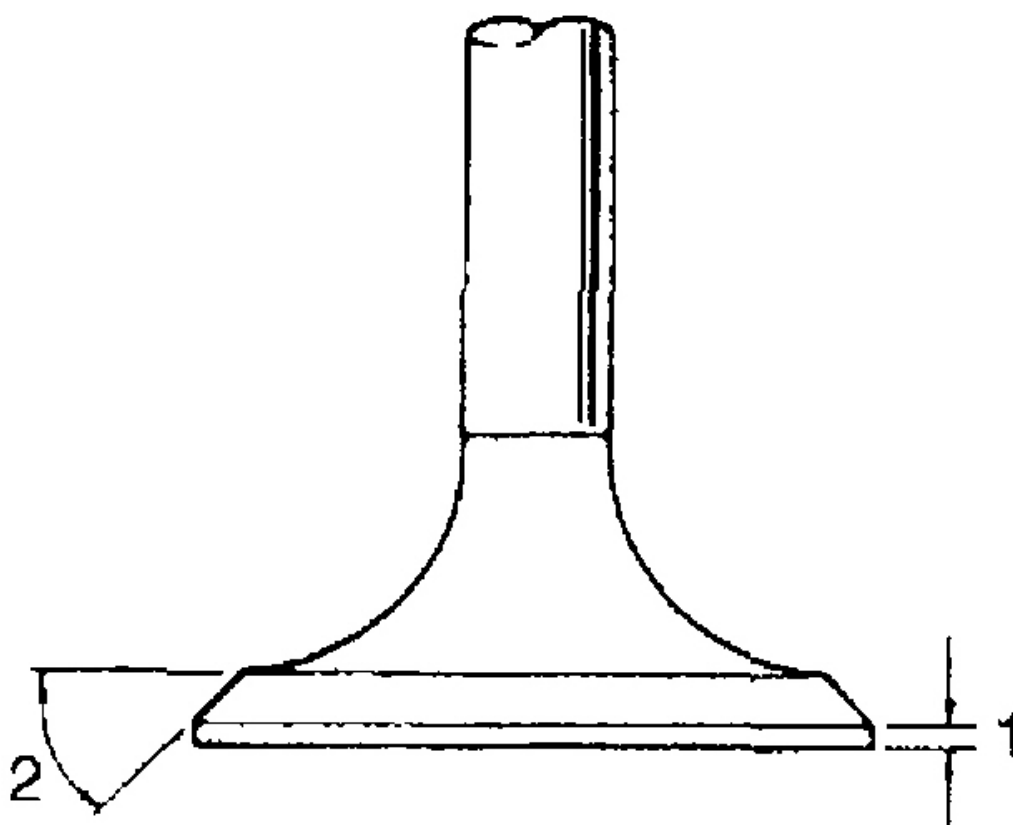
- Remove all carbon from valves.
- Inspect each valve for wear, burn or distortion at its face and stem and, as necessary, replace it.
- Measure thickness of valve head. If measured thickness exceeds limit, replace valve.

Valve specifications

Item	Standard	Limit
Intake	1.0 mm (0.039 in.)	0.6 mm (0.024 in.)
Exhaust	1.2 mm (0.047 in.)	0.7 mm (0.028 in.)

G02264017

Fig. 150: Valve Specifications Chart
Courtesy of SUZUKI OF AMERICA CORP.

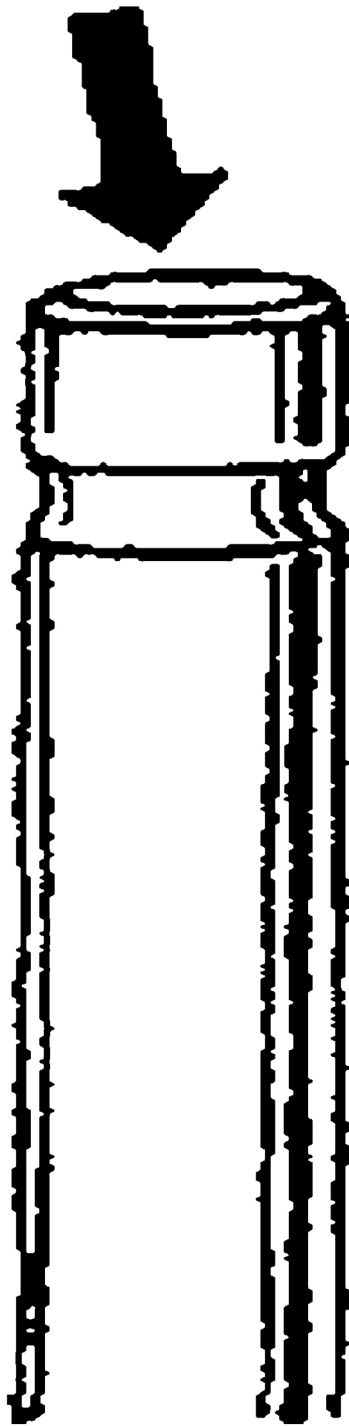


1. Valve head thickness
2. 45°

G02264018

Fig. 151: Measuring Thickness Of Valve Head
Courtesy of SUZUKI OF AMERICA CORP.

- Inspect valve stem end face for pitting and wear. If pitting or wear is found, valve stem end may be resurfaced. But do not grind its taper excessively. When valve is excessively worn out too much or its taper is gone, replace it.



G02264019

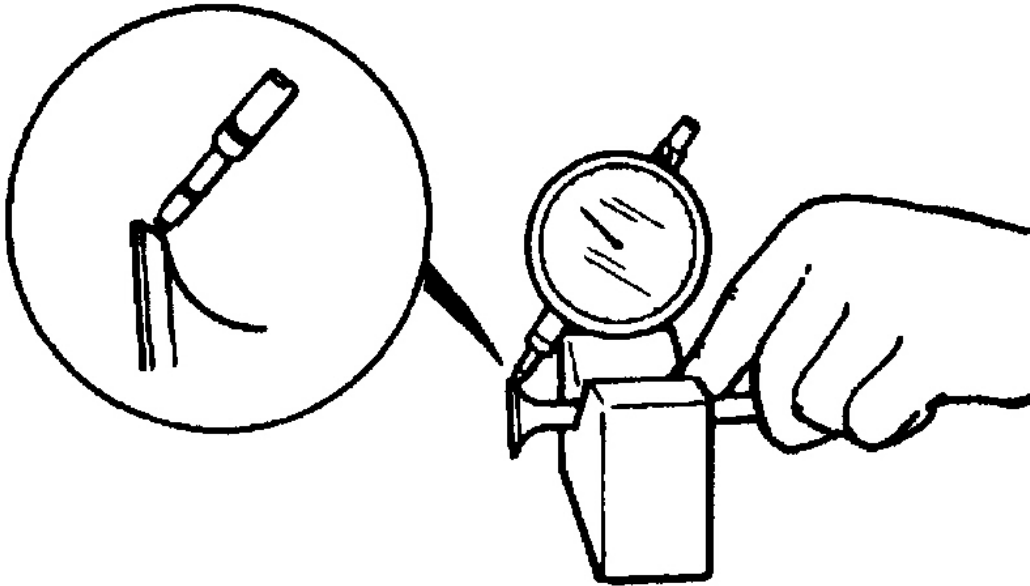
Fig. 152: Inspecting Valve Stem End Face
Courtesy of SUZUKI OF AMERICA CORP.

- Check each valve for radial runout with a dial gauge and "V" block.

To check runout, rotate valve slowly. If runout exceeds its limit, replace valve.

Valve head radial runout

Limit: 0.08 mm (0.003 in.)



G02264020

Fig. 153: Checking Valve For Radial Runout
Courtesy of SUZUKI OF AMERICA CORP.

- Seating contact width

Create contact pattern on each valve in the usual manner, i.e., by giving uniform coat of marking compound to valve seat and by rotatingly tapping seat with valve head. Valve lapper (tool used in valve lapping) must be used. Pattern produced on seating face of valve must be a continuous ring without any break, and the width of pattern must be within specified range.

Standard seating width revealed by contact pattern on valve face

Intake and Exhaust: 1.1 - 1.3 mm (0.0433 - 0.0512 in.)

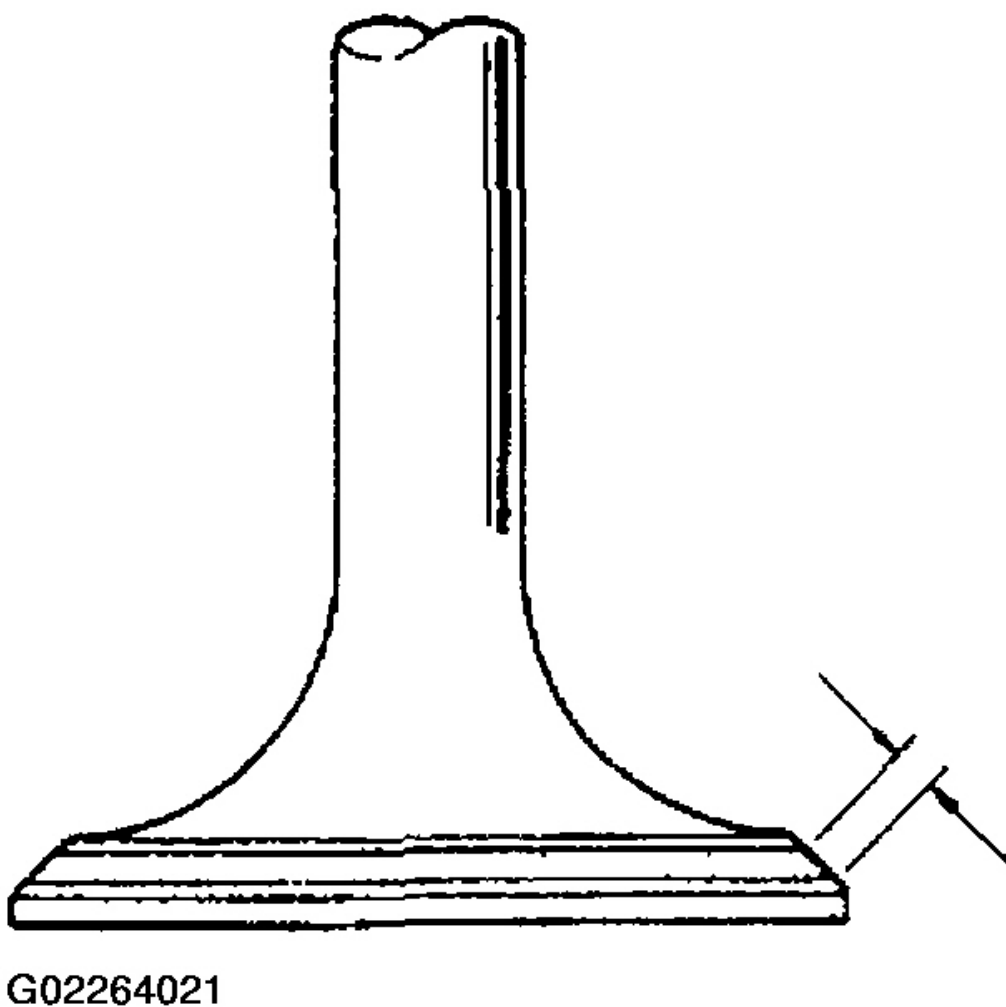


Fig. 154: Identifying Valve Seat Contact Width
Courtesy of SUZUKI OF AMERICA CORP.

- Valve seat repair

A valve seat not producing a uniform contact with its valve or showing width of seating contact that is out of specified range must be repaired by regrinding or by cutting and regrinding and finished by lapping.

A. Exhaust valve seat

Use valve seat cutters (1) to make two cuts as illustrated in the figure. Two cutters must be used: the 1st for making 15° angle, and the 2nd for making 45° angle. The 2nd cut must be made to produce desired seat width.

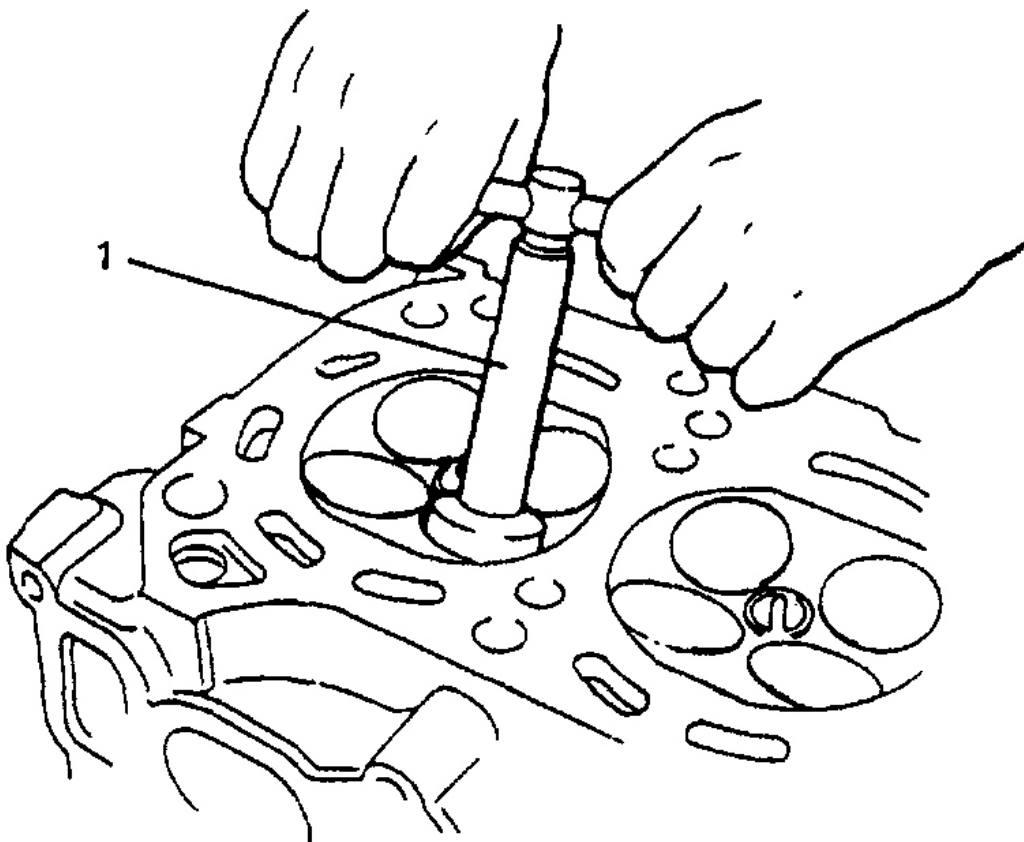
Seat width for exhaust valve seat

Seat width for exhaust valve seat: 1.1 - 1.3 mm (0.0433 - 0.0512 in.)

B. Intake valve seat

Use valve seat cutters (1) to make three cuts as illustrated in figure. Three cutters must be used: the 1st for making 15° angle, the 2nd for making 60° angle, and the 3rd for making 45° angle. The 3rd cut (45°) must be made to produce desired seat width.

Seat width for intake valve seat: 1.1 - 1.3 mm (0.0433 - 0.0512 in.)

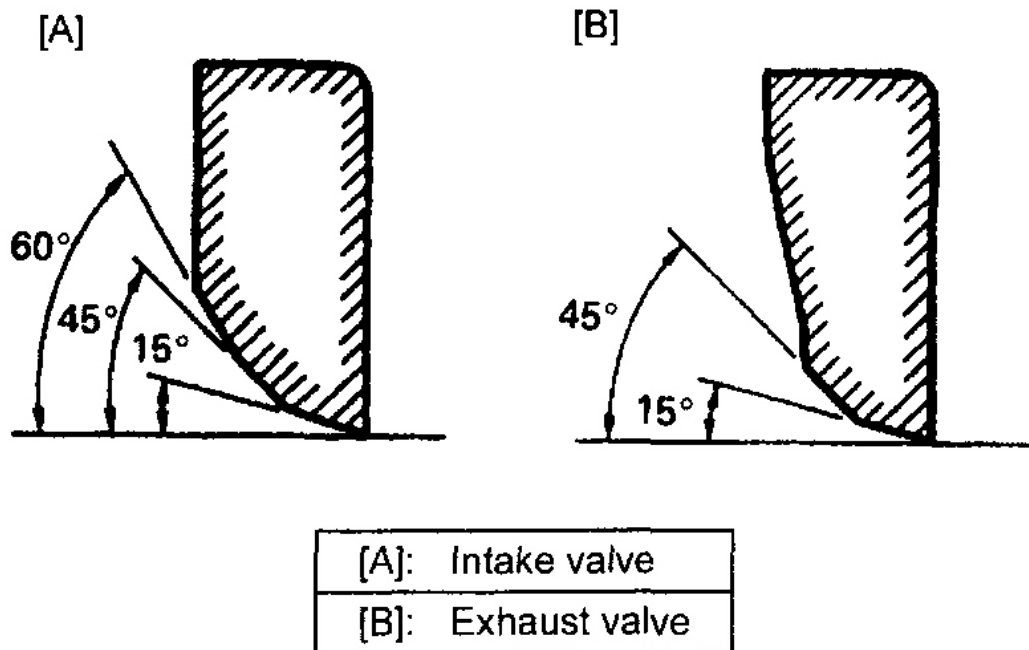


G02264022

Fig. 155: Using Valve Seat Cutters
Courtesy of SUZUKI OF AMERICA CORP.

C. Valve lapping

Lap valve on seat in two steps, first with coarse size lapping compound applied to face and the second with fine-size compound, each time using valve lapper according to usual lapping method.



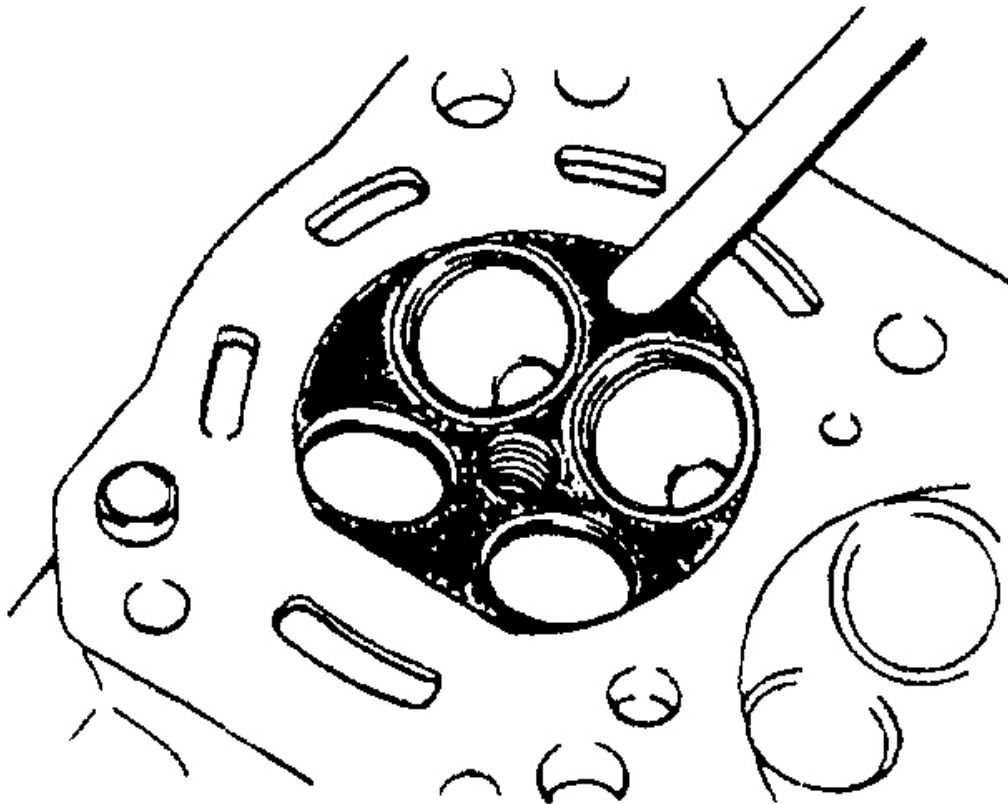
G02264023

Fig. 156: Identifying Valve Seat Angles
Courtesy of SUZUKI OF AMERICA CORP.

CYLINDER HEAD INSPECTION

- Remove all carbon from combustion chambers.

NOTE: Do not use any sharp-edged tool to scrape off carbon. Be careful not to scuff or nick metal surfaces when decarboning. The same applies to valves and valve seats, too.



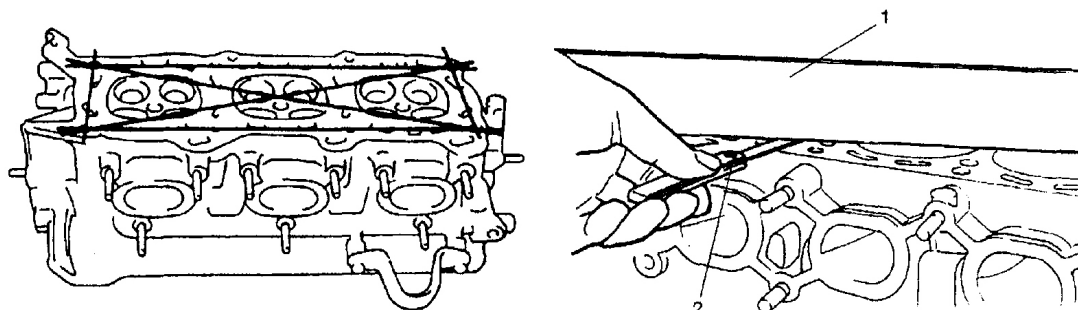
G02264024

Fig. 157: Removing Carbon From Combustion Chambers**Courtesy of SUZUKI OF AMERICA CORP.**

- Check cylinder head for cracks on intake and exhaust ports, combustion chambers, and head surface. Using straightedge (1) and thickness gauge (2), check flatness of gasketed surface at a total of 6 locations. If distortion limit, given below, is exceeded, correct gasketed surface with a surface plate and abrasive paper of about #400 (Waterproof silicon carbide abrasive paper): Place abrasive paper on and over surface plate, and rub gasketed surface against paper to grind off high spots. Should this fail to reduce thickness gauge readings to within limit, replace cylinder head.

Leakage of combustion gases from this gasketed joint is often due to warped gasketed surface: such leakage results in reduced power output.

Cylinder head gasketed surface distortion**Limit:** 0.05 mm (0.002 in.)



G02264025

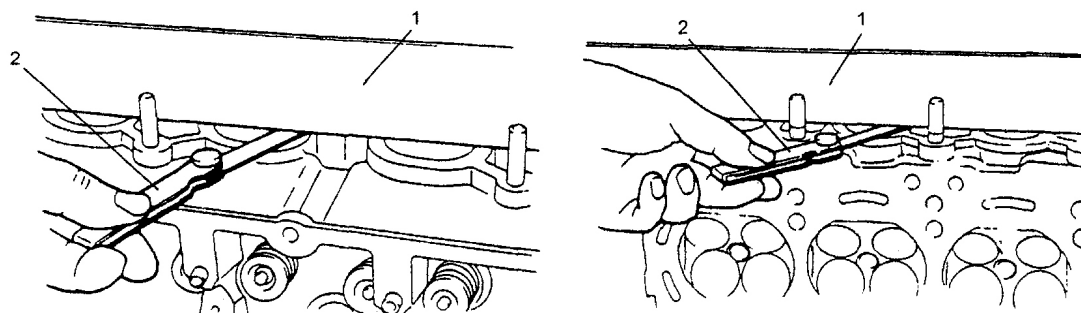
Fig. 158: Checking Cylinder Head Gasketed Surface
Courtesy of SUZUKI OF AMERICA CORP.

- Distortion of manifold seating faces

Check seating faces of cylinder head for manifolds, using a straightedge (1) and thickness gauge (2), in order to determine whether these faces should be corrected or cylinder head replaced.

Manifold seating surface distortion

Limit: 0.10 mm (0.004 in.)

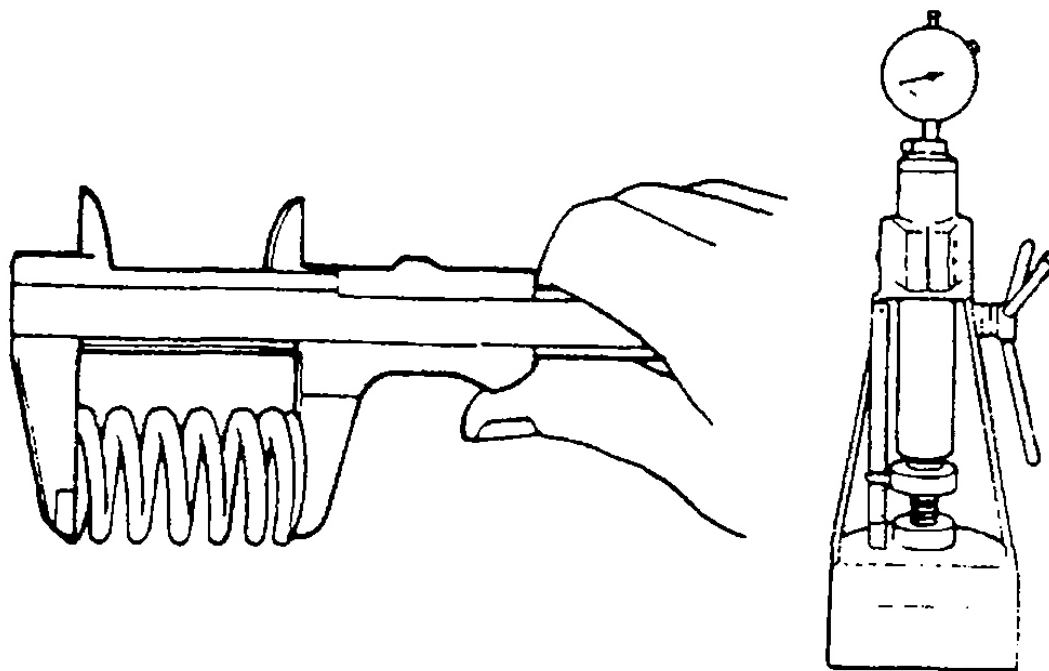


G02264026

Fig. 159: Checking Cylinder Head Manifold Seating Surface
Courtesy of SUZUKI OF AMERICA CORP.

VALVE SPRINGS INSPECTION

- Referring to data given below, check to be sure that each spring is in sound condition, free of any evidence of breakage or weakening. Remember, weakened valve springs can cause chatter, not to mention possibility of reducing power output due to gas leakage caused by decreased seating pressure.



G02264027

Fig. 160: Checking Valve Spring Free Length & Valve Spring Preload
Courtesy of SUZUKI OF AMERICA CORP.

Item	Standard	Limit
Inner	36.08 mm (1.4205 in.)	35.00 mm (1.3780 in.)
Outer	40.44 mm (1.5921 in.)	39.22 mm (1.5441 in.)

G02264028

Fig. 161: Valve Spring Free Length Specification Chart
Courtesy of SUZUKI OF AMERICA CORP.

Item	Standard	Limit
Inner	6.9 – 7.9 kg for 27.5 mm (15.2 – 17.4 lb/1.08 in.)	5.9 kg for 27.5 mm (13.0 lb/1.08 in.)
Outer	15.4 – 17.8 kg for 31.7 mm (34.0 – 39.2 lb/1.25 in.)	13.3 kg for 31.7 mm (29.3 lb/1.25 in.)

G02264029

Fig. 162: Valve Spring Preload Specification Chart
Courtesy of SUZUKI OF AMERICA CORP.

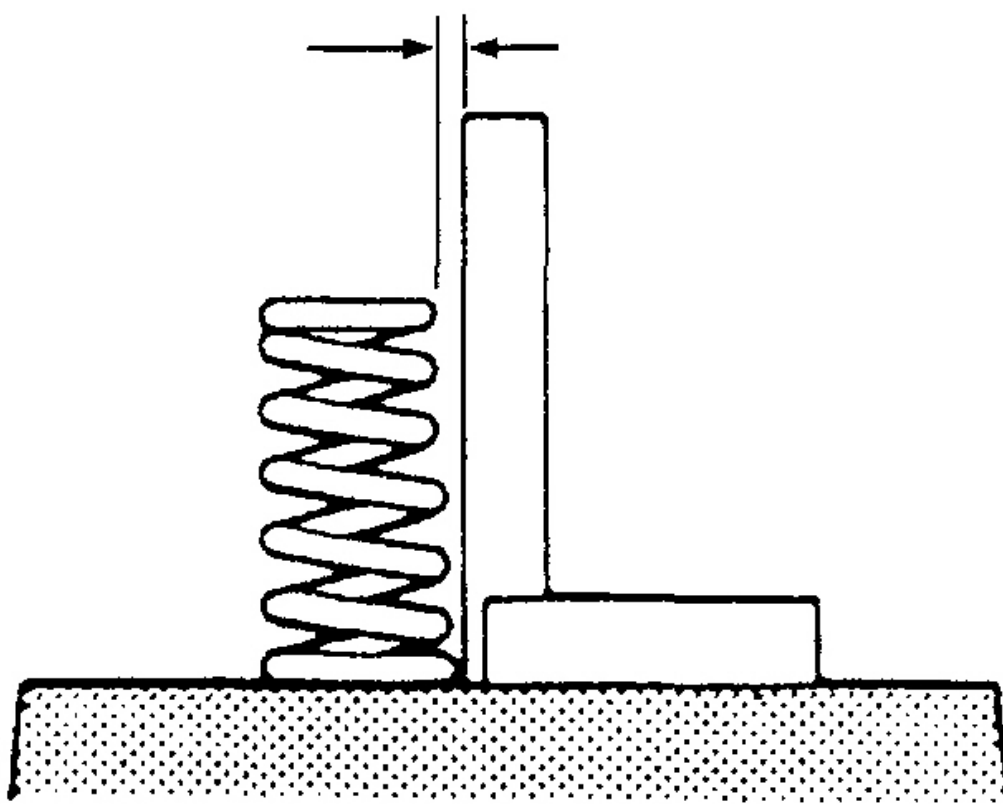
- Spring squareness

Use a square and surface plate to check each spring for squareness in terms of clearance between end of valve spring and square. Valve springs found to exhibit a larger clearance than limit given below must be replaced.

Valve spring squareness limit

Inner spring: 1.6 mm (0.063 in.)

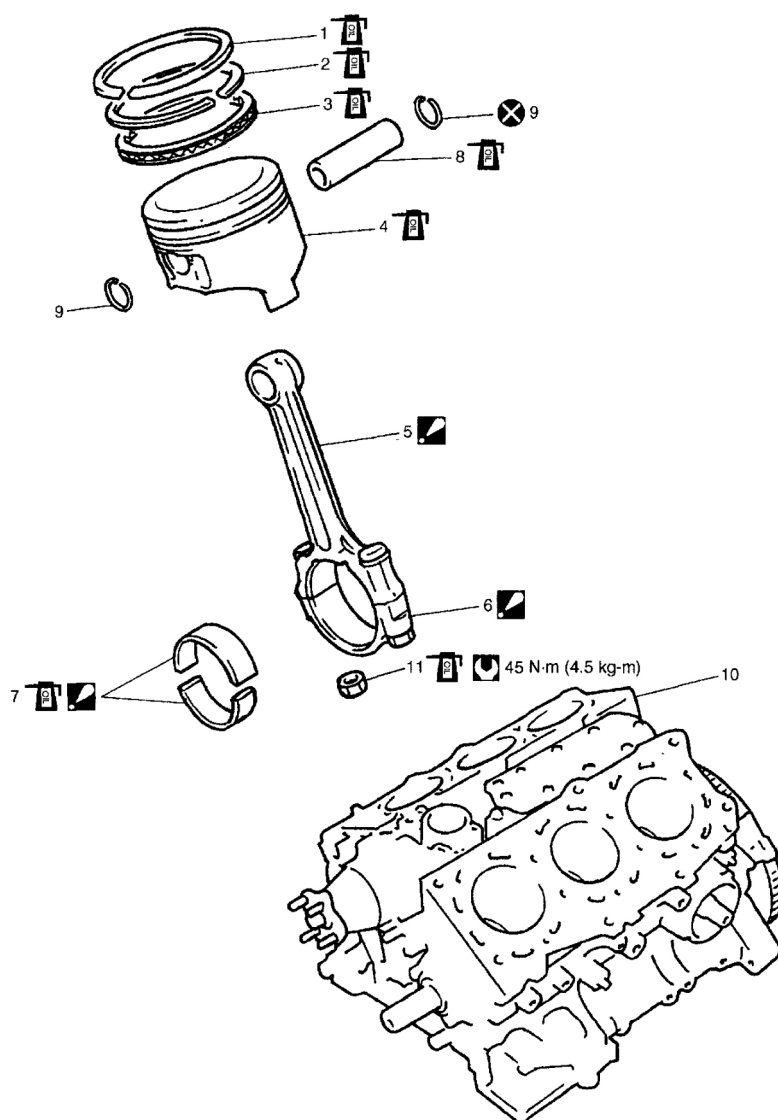
Outer spring: 1.8 mm (0.071 in.)



G02264030

Fig. 163: Checking Spring Squareness
Courtesy of SUZUKI OF AMERICA CORP.

PISTONS, PISTON RINGS, CONNECTING RODS & CYLINDERS COMPONENTS



1. Top ring	6. Connecting rod bearing cap: Clean bearing installing surface when install.	11. Bearing cap nut
2. 2nd ring	7. Connecting rod bearing: Apply engine oil to inner surface. Clean outer surface when install.	: Tightening torque
3. Oil ring	8. Piston pin	: Do not reuse.
4. Piston	9. Piston pin circlip	: Apply engine oil.
5. Connecting rod: Clean bearing installing surface when install.	10. Cylinder block	

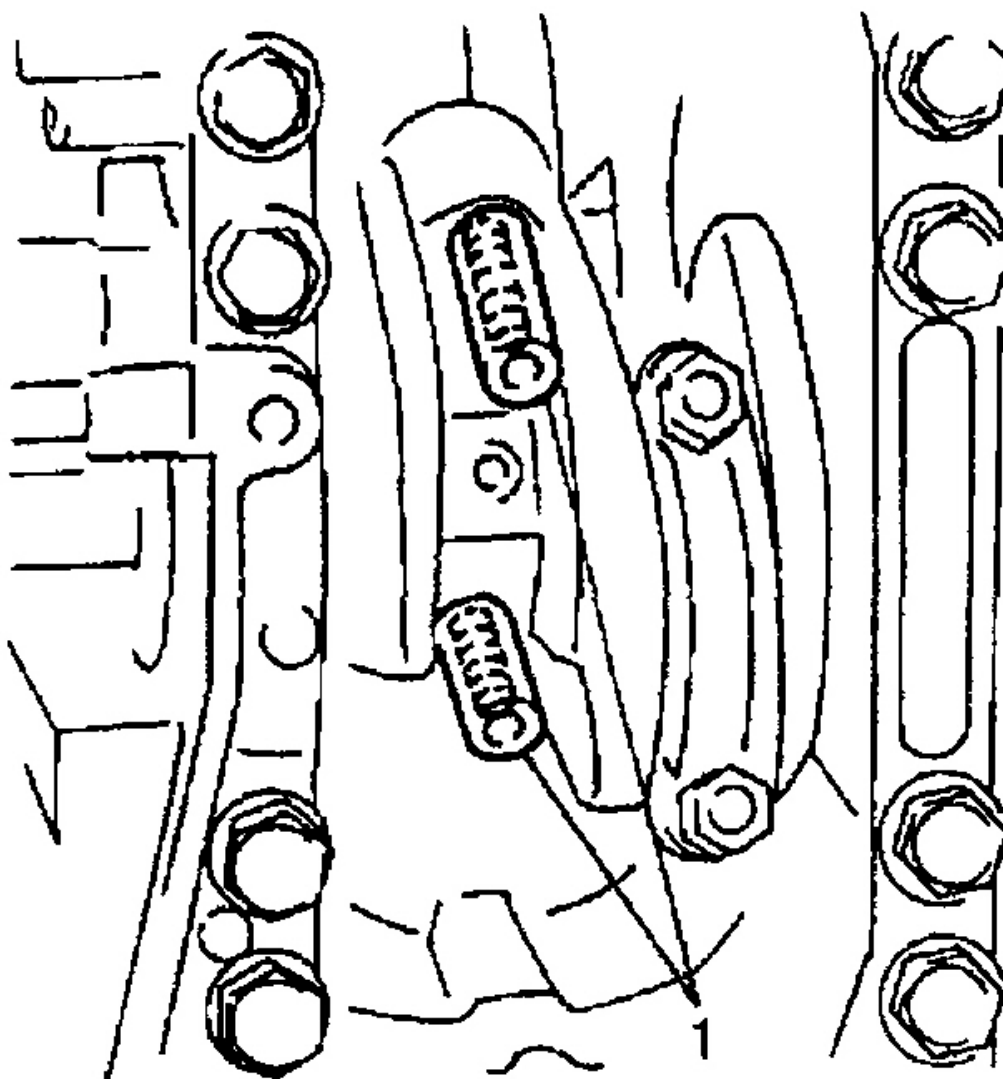
G02264031

Fig. 164: Exploded View Of Pistons, Piston Rings, Connecting Rods & Cylinders Components
 Courtesy of SUZUKI OF AMERICA CORP.

PISTONS, PISTON RINGS, CONNECTING RODS & CYLINDERS REMOVAL & INSTALLATION

Removal

1. Disconnect negative (-) cable at battery.
2. Drain engine oil.
3. Drain coolant referring to **COOLANT DRAINING** .
4. Remove cylinder heads. Refer to **VALVES & CYLINDER HEADS REMOVAL & INSTALLATION** .
5. Remove oil pump. Refer to **OIL PUMP REMOVAL & INSTALLATION** .
6. Mark cylinder number on all pistons, connecting rods and connecting rod caps.
7. Remove rod bearing caps.
8. Install guide hose (1) over threads of rod bolts. This prevents damage to bearing journal and rod bolt threads when removing connecting rod.



G02264032

Fig. 165: Installing Guide Hose Over Threads Of Rod Bolts
Courtesy of SUZUKI OF AMERICA CORP.

9. Clean carbon from top of cylinder bore before removing piston from cylinder.
10. Push piston and connecting rod assembly out through the top of cylinder bore.

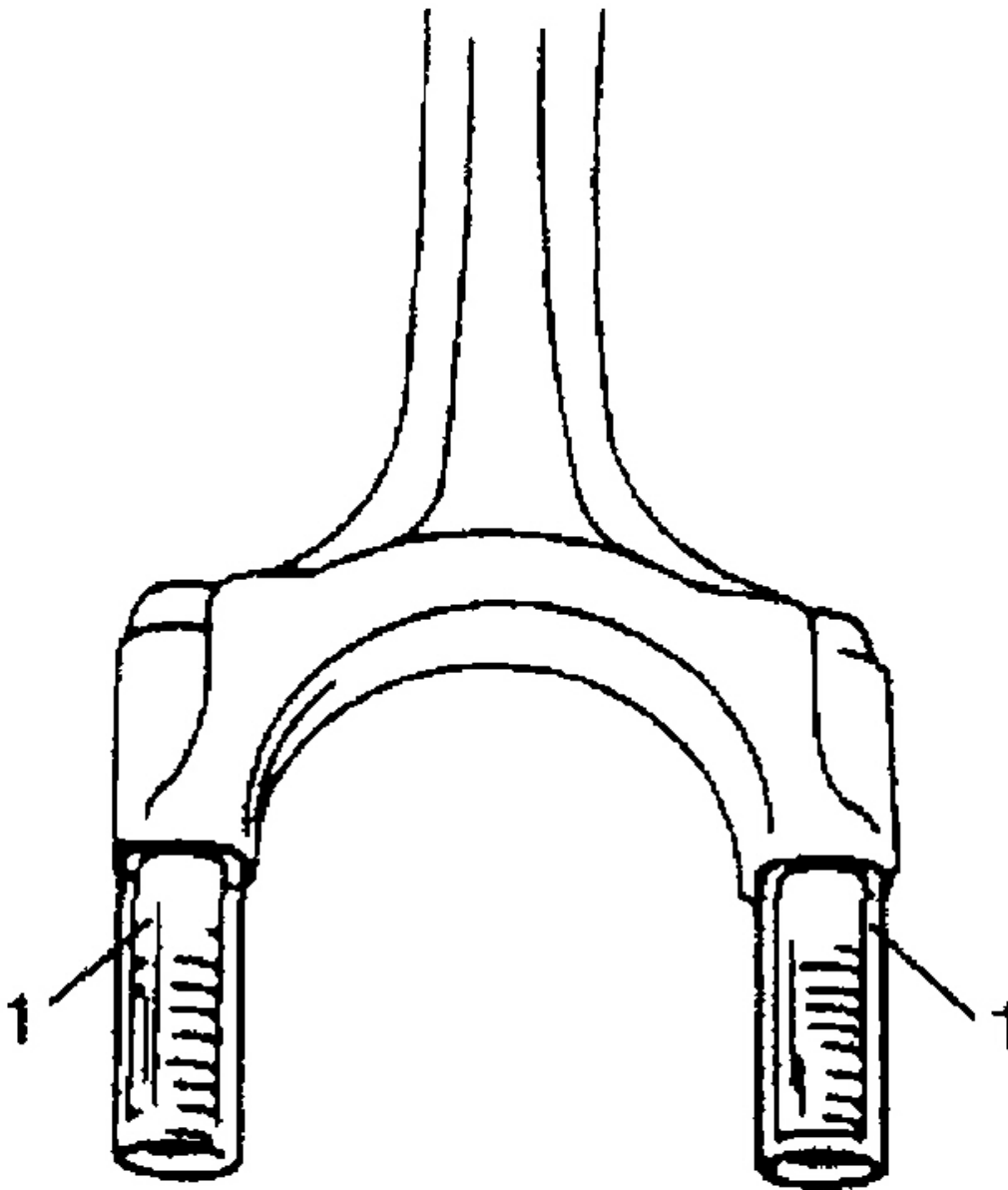
Installation

1. Apply engine oil to pistons, rings, cylinder walls, connecting rod bearings and crank pins.

NOTE: **Do not apply oil between connecting rod and bearing or between bearing cap and bearing.**

2. Install guide hoses (1) over connecting rod bolts.

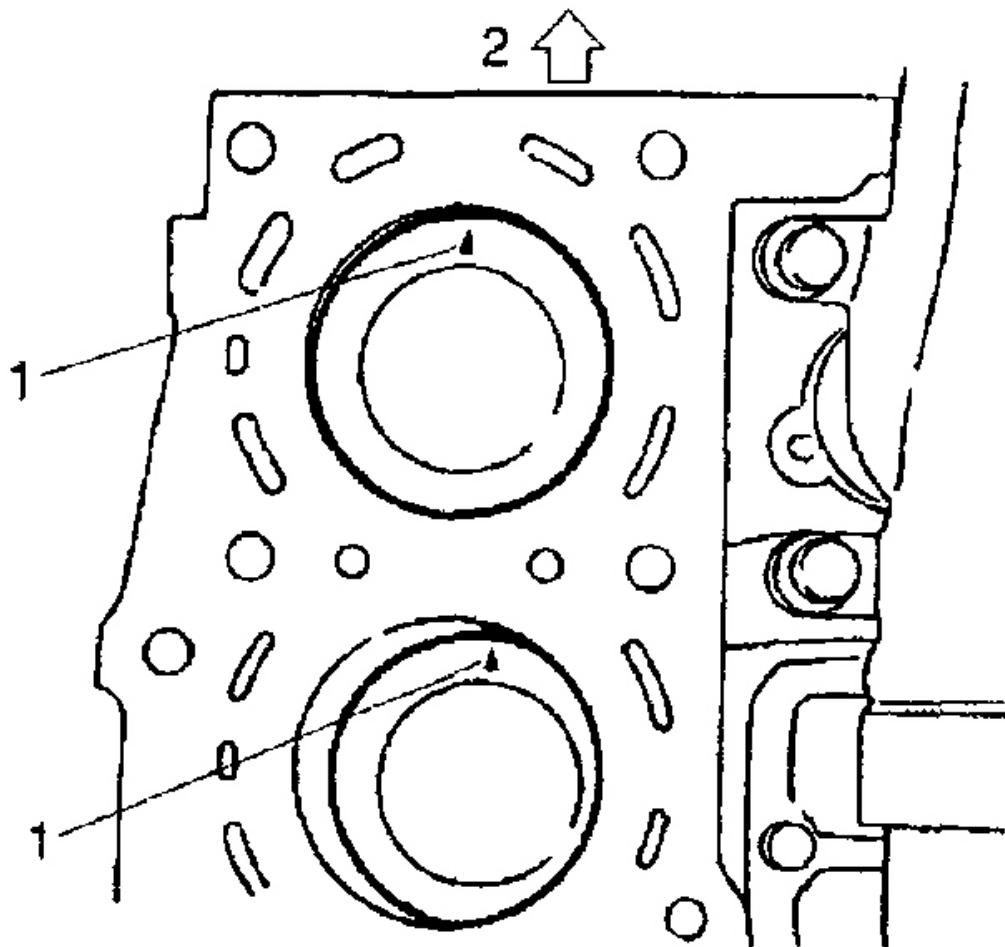
These guide hoses (1) protect crank pin and threads of rod bolt from damage during installation of connecting rod and piston assembly.



G02264033

Fig. 166: Installing Guide Hoses Over Connecting Rod Bolts
Courtesy of SUZUKI OF AMERICA CORP.

3. When installing piston and connecting rod assembly into cylinder bore, point mark (1) on piston head to crankshaft pulley side (2).



G02264034

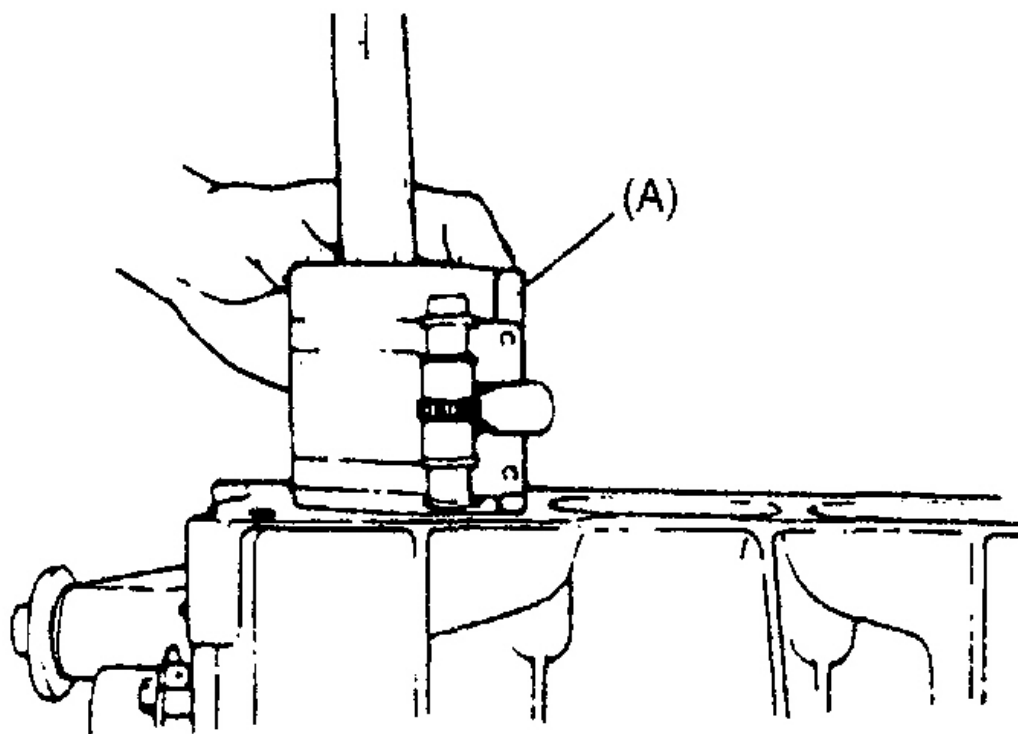
Fig. 167: Installing Piston With Mark On Piston Head To Crankshaft Pulley Side
Courtesy of SUZUKI OF AMERICA CORP.

4. Install piston and connecting rod assembly into cylinder bore. Use special tool (Piston ring compressor) to compress rings. Guide connecting rod into place on crankshaft.

Using a hammer handle, tap piston head to install piston into bore. Hold ring compressor firmly against cylinder block until all piston rings have entered cylinder bore.

Special tool

(A): 09916-77310



G02264035

Fig. 168: Installing Piston

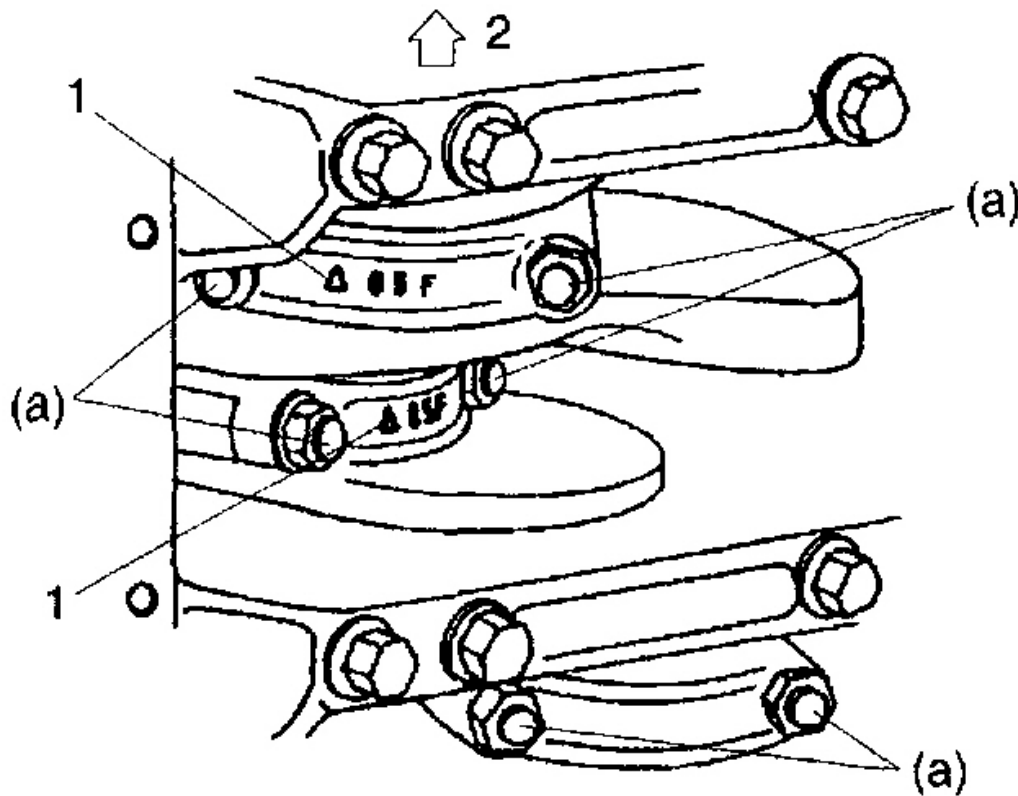
Courtesy of SUZUKI OF AMERICA CORP.

5. Install bearing cap

Point mark (1) on cap to crankshaft pulley side (2). Tighten cap nuts to specification.

Tightening torque

Connecting rod bearing cap nut (a): 45 N.m (4.5 kg-m, 32.5 lb-ft)



G02264036

Fig. 169: Installing Bearing Cap With Mark On Cap To Crankshaft Pulley Side
 Courtesy of SUZUKI OF AMERICA CORP.

6. Install cylinder heads to cylinder block referring to VALVES & CYLINDER HEADS REMOVAL & INSTALLATION .
7. Install oil pump to cylinder block referring to OIL PUMP REMOVAL & INSTALLATION .
8. Install valve lash adjusters and camshafts referring to CAMSHAFTS & VALVE LASH ADJUSTERS REMOVAL & INSTALLATION .
9. Install RH bank 2nd timing chain referring to RH (NO. 2) BANK 2ND TIMING CHAIN & CHAIN TENSIONER INSTALLATION .
10. Install 1st timing chain. Refer to 1ST TIMING CHAIN & CHAIN TENSIONER INSTALLATION .
11. Install LH bank 2nd timing chain. Refer to LH (NO. 1) BANK 2ND TIMING CHAIN & CHAIN TENSIONER INSTALLATION .
12. Install timing chain cover. Refer to TIMING CHAIN COVER REMOVAL & INSTALLATION .
13. Install oil pan and pump strainer. Refer to OIL PAN & OIL PUMP STRAINER REMOVAL &

INSTALLATION .

14. Install cylinder head cover. Refer to **CYLINDER HEAD COVERS REMOVAL & INSTALLATION** .
15. Install exhaust manifold. Refer to **EXHAUST MANIFOLD REMOVAL & INSTALLATION** .
16. Install radiator outlet pipe, radiator, cooling fan and water hose.

Refer to **COOLING WATER PIPES OR HOSES REMOVAL & INSTALLATION** , **RADIATOR REMOVAL & INSTALLATION** and **COOLING FAN & FAN CLUTCH REMOVAL & INSTALLATION** .

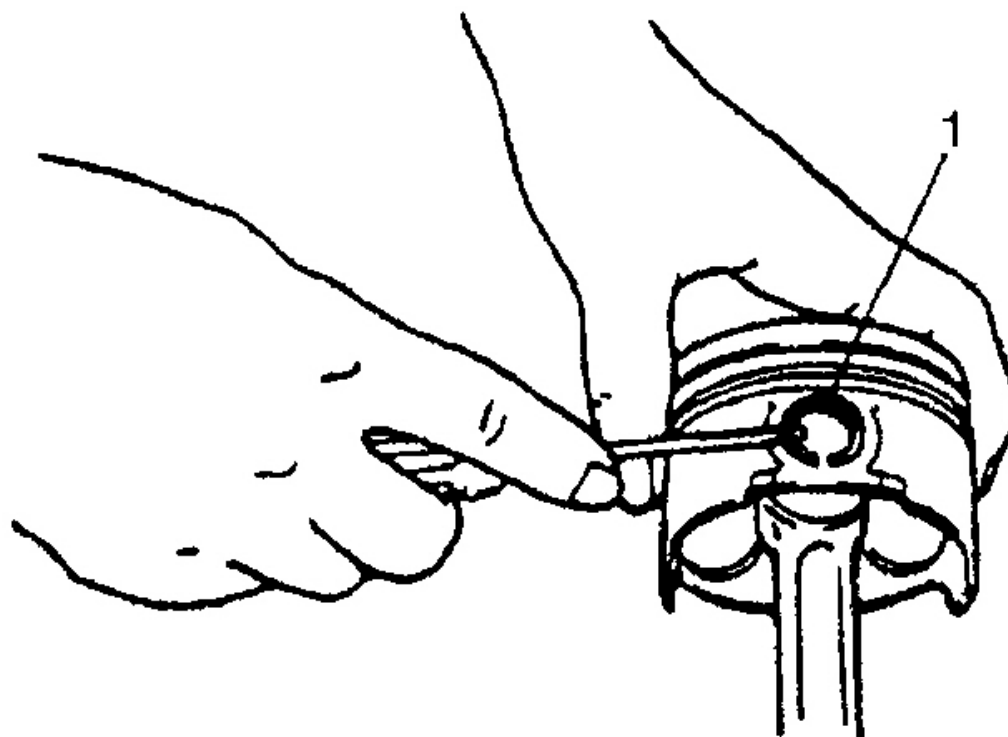
17. Install intake manifold with throttle body.

Refer to **THROTTLE BODY & INTAKE MANIFOLD REMOVAL & INSTALLATION (H25 ENGINE)** .

18. Adjust water pump drive belt tension. Refer to **COOLING FAN/GENERATOR BELT TENSION CHECK & ADJUSTMENT** .
19. Adjust power steering pump drive belt tension. Refer to **P/S PUMP DRIVE BELT INSPECTION & ADJUSTMENT** .
20. Adjust accelerator cable play and A/T throttle cable play. Refer to **ACCELERATOR CABLE ADJUSTMENT** and **A/T THROTTLE CABLE ADJUSTMENT (H25 ENGINE WITH A/T ONLY)** .
21. Check to ensure that all removed parts are back in place. Reinstall any necessary parts which have not been reinstalled.
22. Refill engine with engine oil .
23. Refill cooling system referring to **COOLING SYSTEM FLUSH & REFILL** .
24. Refill front differential housing with gear oil if drained, referring to **FRONT DIFFERENTIAL GEAR OIL INSPECTION & CHANGE** .
25. Connect negative cable at battery.
26. Check ignition timing and adjust as necessary, referring to **IGNITION TIMING CHECK & ADJUSTMENT** .
27. Verify that there is no fuel leakage, water leakage, oil leakage and exhaust gas leakage at each connection.
28. Check wheel alignment referring to **SPECIFICATIONS & PROCEDURES** .

PISTONS, PISTON RINGS, CONNECTING RODS & CYLINDERS DISASSEMBLY & ASSEMBLY**Disassembly**

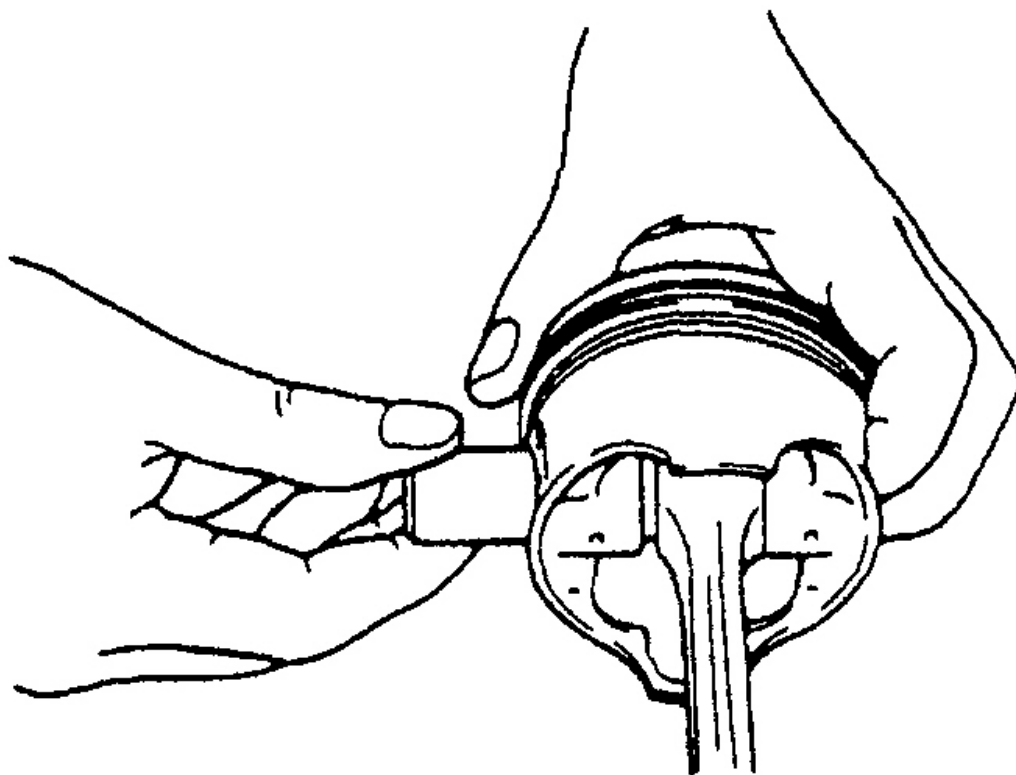
1. Using piston ring expander, remove two compression rings (Top and 2nd) and oil ring from piston.
2. Remove piston pin from connecting rod.
 - A. Ease out piston pin circlips (1) as shown in the figure.



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Fig. 170: Removing Piston Pin Circlips
Courtesy of SUZUKI OF AMERICA CORP.

- B. Force piston pin out.



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Fig. 171: Removing Piston Pin
Courtesy of SUZUKI OF AMERICA CORP.

Assembly

1. Two sizes of piston are available as standard size spare part so as to ensure proper piston-to-cylinder clearance. When installing a standard size piston, make sure to match piston with cylinder as follows.
 - A. Each piston has stamped number (1 or 2) on its piston head. It represents outer diameter of piston.
 - B. There are also stamped numbers of 1 and 2 on the cylinder block as shown in the figure.
 - C. Stamped number on piston and cylinder block must correspond. That is, install number "2" stamped piston to cylinder which is stamped also number "2" and a number "1" piston to cylinder with number "1".

A letter "A" or "B" is stamped on piston head but ordinarily it is not necessary to distinguish each piston by this letter.

Piston outer diameter

	Number at the top (mark)	Outer diameter
For H27 engine model	1	87.98 – 87.99 mm (3.4638 – 3.4642 in.)
	2	87.97 – 87.98 mm (3.4634 – 3.4638 in.)
For H25 engine model	1	83.98 – 83.99 mm (3.3063 – 3.3067 in.)
	2	83.97 – 83.98 mm (3.3059 – 3.3063 in.)

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Fig. 172: Piston Outer Diameter Chart
Courtesy of SUZUKI OF AMERICA CORP.

Cylinder outer diameter

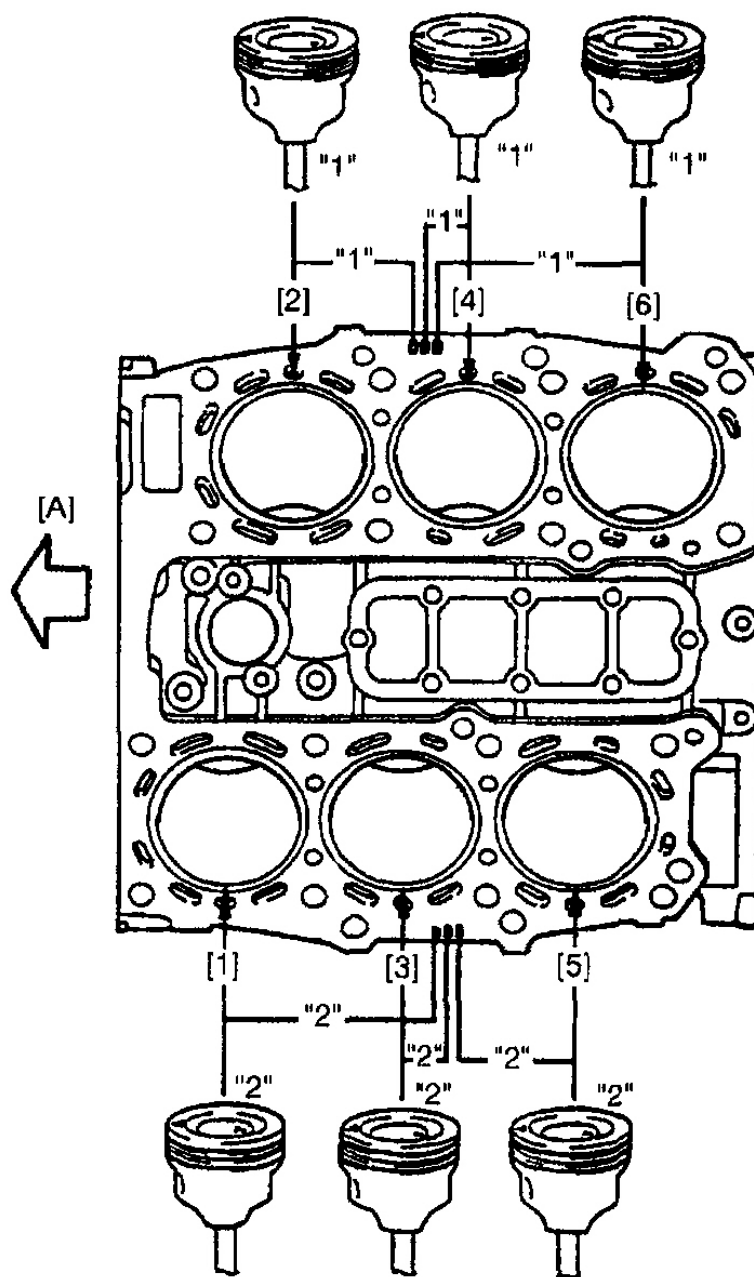
	Number on cylinder block (mark)	Outer diameter
For H27 engine model	1	88.01 – 88.02 mm (3.4650 – 3.4653 in.)
	2	88.00 – 88.01 mm (3.4646 – 3.4650 in.)
For H25 engine model	1	84.01 – 84.02 mm (3.3075 – 3.3079 in.)
	2	84.00 – 84.01 mm (3.3071 – 3.3075 in.)

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Fig. 173: Piston Outer Diameter Chart
Courtesy of SUZUKI OF AMERICA CORP.

Piston-to-cylinder clearance

Piston-to-cylinder clearance: 0.02 - 0.04 mm (0.0008 - 0.0016 in.)



[1]: No.1 cylinder	[4]: No.4 cylinder	[A]: Crankshaft pulley side
[2]: No.2 cylinder	[5]: No.5 cylinder	
[3]: No.3 cylinder	[6]: No.6 cylinder	

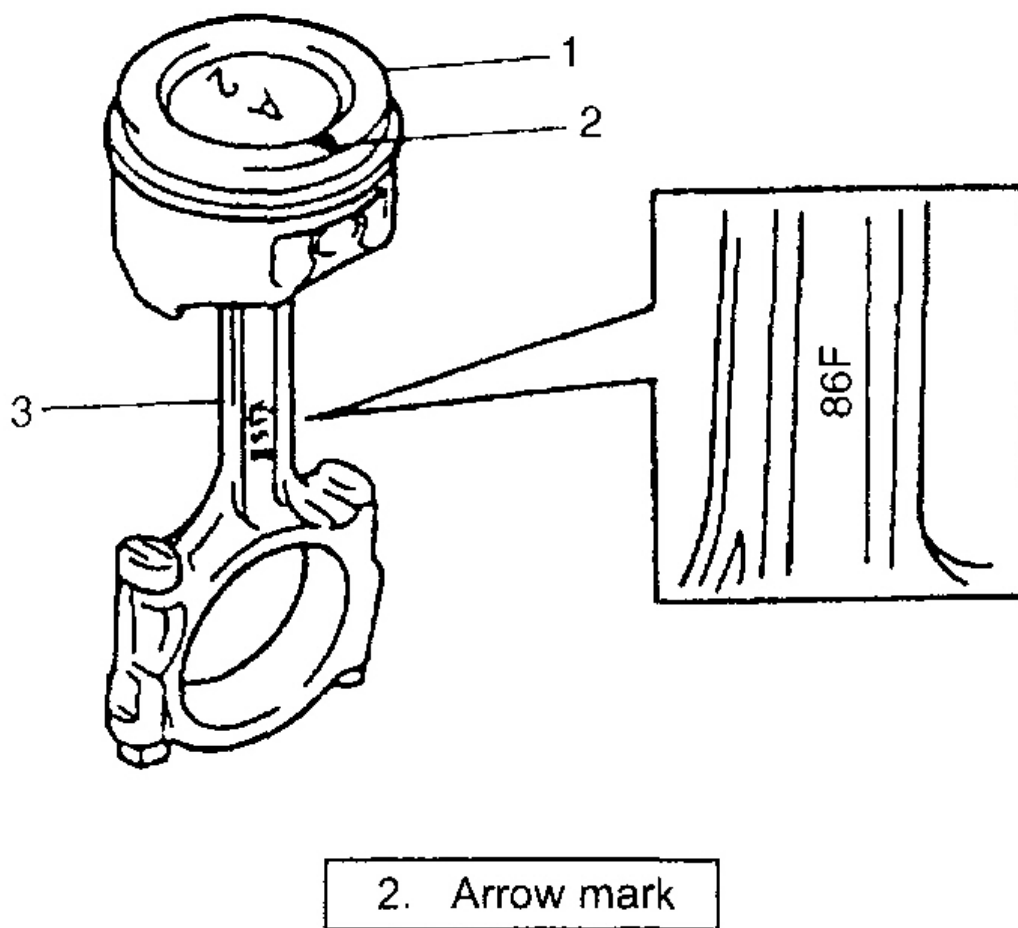
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Fig. 174: Identifying Stamped Information Locations
Courtesy of SUZUKI OF AMERICA CORP.

2. Install piston pin to piston and connecting rod:

After applying engine oil to piston pin and piston pin holes in piston (1) and connecting rod (3), fit connecting rod to piston as shown in the figure and insert piston pin to piston and connecting rod, and install piston pin circlips.

NOTE: "86F" mark on connecting rod must face toward crankshaft pulley side.

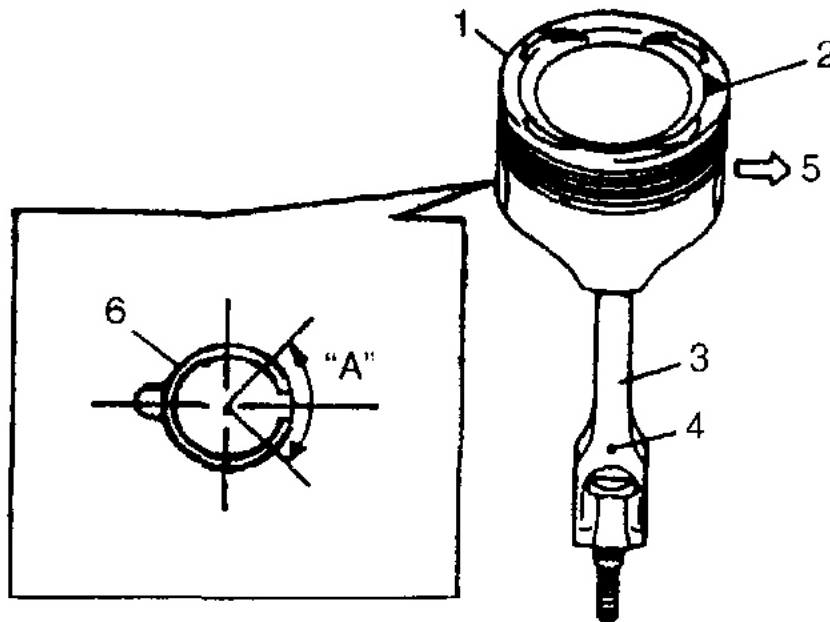


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Fig. 175: Assembling Piston, Pin & Connecting Rod
Courtesy of SUZUKI OF AMERICA CORP.

NOTE:

- Install circlip with its cut part facing as shown in the figure.
- Install so that circlip end gap comes within such range as indicated by arrow "A".



1. Piston	4. Oil hole
2. Arrow mark	5. Crankshaft pulley side
3. Connecting rod	6. Circlip

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Fig. 176: Installing Circlips

Courtesy of SUZUKI OF AMERICA CORP.

3. Install piston rings to piston:

- As shown in the figure, 1st (1) and 2nd rings (2) have "RN" or "R" mark respectively. When installing these piston rings to piston, direct marked side of each ring toward top of piston.
- 1st rings differs from 2nd ring in thickness, shape and color of surface contacting cylinder wall. Distinguish 1st ring from 2nd ring by referring to the figure.
- When installing oil ring (3), install spacer first and then 2 rails.

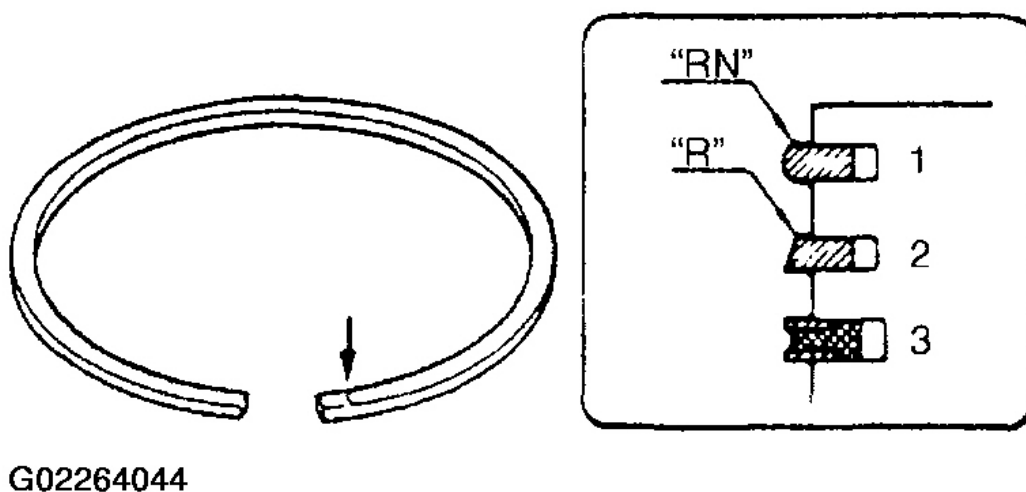
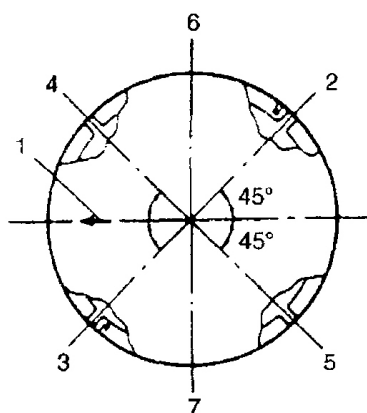


Fig. 177: Identifying Piston Rings
Courtesy of SUZUKI OF AMERICA CORP.

4. After installing three rings (1st, 2nd and oil rings), distribute their end gaps as shown in the figure.



1. Mark	4. Oil ring upper rail gap	7. Exhaust side
2. 1st ring end gap	5. Oil ring lower rail gap	
3. 2nd ring end gap and oil ring spacer gap	6. Intake side	

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Fig. 178: Identifying Ring Gap Locations
Courtesy of SUZUKI OF AMERICA CORP.

CYLINDERS, PISTONS & PISTON RINGS INSPECTION

NOTE: Before the following inspection, clean carbon from piston head and ring grooves, using a suitable tool.

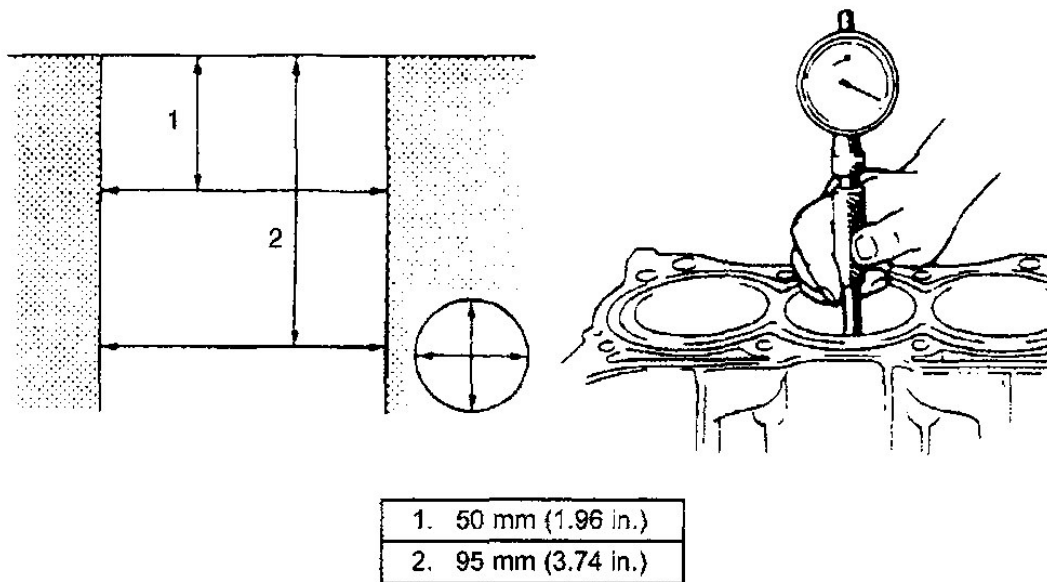
Cylinders

- Inspect cylinder walls for scratches, roughness, or ridges which indicate excessive wear. If cylinder bore is very rough or deeply scratched, or ridged, rebore cylinder and use over size piston.
- Using a cylinder gauge, measure cylinder bore in thrust and axial directions at 2 positions (1, 2) as shown in the figure. If any of the following condition is noted, rebore cylinder.
 - Cylinder bore via. exceeds limit.
 - Difference of measurements at 2 positions exceeds taper limit.
 - Difference between thrust and axial measurements exceeds out-of-round limit.

Cylinder bore dia. limit: 84.050 mm (3.3091 in.)

Limit: 0.10 mm (0.004 in.)

NOTE: If any one of six cylinders has to be rebored, rebore all six to the same oversize. This is necessary for the sake of uniformity and balance.



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Fig. 179: Measuring Cylinder Bore
Courtesy of SUZUKI OF AMERICA CORP.

Pistons

- Inspect piston for faults, cracks or other damages.

Damaged or faulty piston should be replaced.

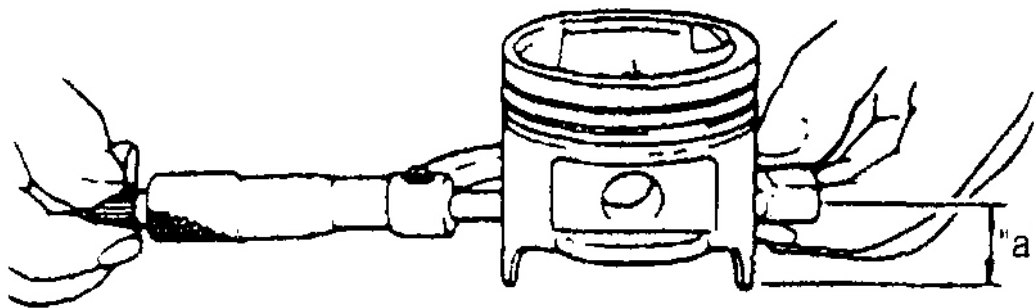
- Piston diameter:

As shown in the figure, piston diameter should be measured at a position 26.5 mm (1.04 in.) ("a") from piston skirt end in the direction perpendicular to piston pin.

	Standard	Oversize 0.50 mm (0.0196 in.)
For H25 engine	83.970 – 83.990 mm (3.3059 – 3.3067 in.)	84.470 – 84.490 mm (3.3256 – 3.3264 in.)
For H27 engine	87.970 – 87.990 mm (3.4634 – 3.4642 in.)	88.470 – 88.490 mm (3.4831 – 3.4839 in.)

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Fig. 180: Piston Diameter Chart
Courtesy of SUZUKI OF AMERICA CORP.



"a": 26.5 mm (1.04 in.)

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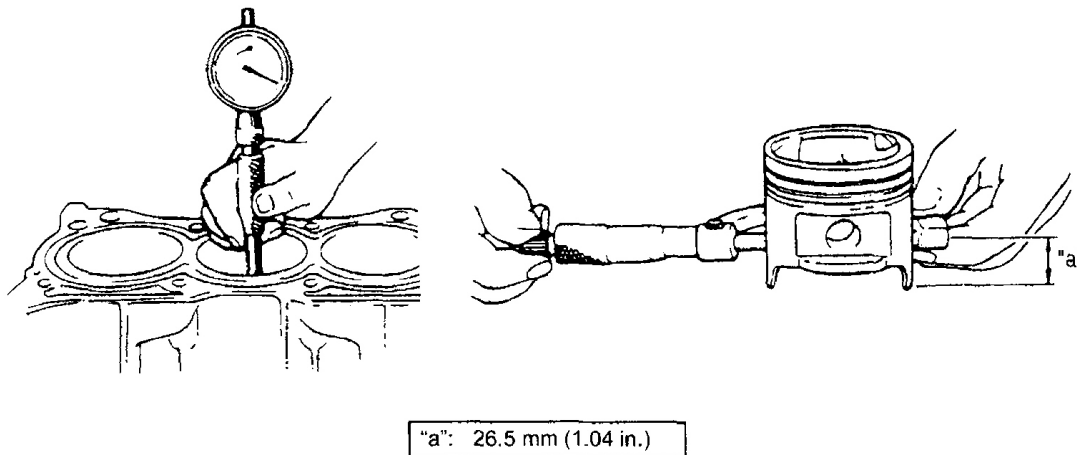
Fig. 181: Measuring Piston Diameter
Courtesy of SUZUKI OF AMERICA CORP.

- Piston clearance:

Measure cylinder bore diameter and piston diameter to find their difference which is piston clearance. Piston clearance should be within specification as given below. If it is out of specification, rebore cylinder and use oversize piston.

Piston-to-cylinder clearance: 0.02 - 0.04 mm (0.0008 - 0.0015 in.)

NOTE: Cylinder bore diameter should be measured in 2 places 90 degrees apart.



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Fig. 182: Measuring Cylinder Bore Diameter & Piston Diameter
Courtesy of SUZUKI OF AMERICA CORP.

- Ring groove clearance:

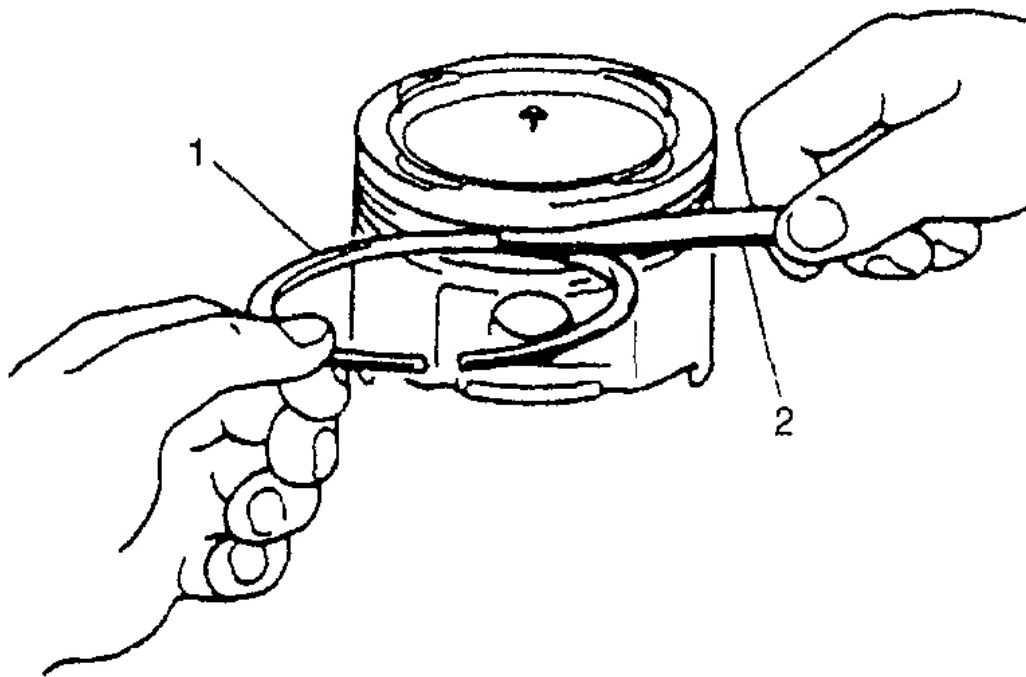
Before checking, piston grooves must be clean, dry and free of carbon.

Fit new piston ring (1) into piston groove, and measure clearance between ring and ring land by using thickness gauge (2). If clearance is out of specification, replace piston.

Ring groove clearance

Top: 0.03 - 0.07 mm (0.0012 - 0.0027 in.)

2nd: 0.02 - 0.06 mm (0.0008 - 0.0023 in.)



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Fig. 183: Measuring Clearance Between Ring & Ring Land
 Courtesy of SUZUKI OF AMERICA CORP.

Piston Rings

To measure end gap, insert piston ring into cylinder bore and then measure the gap by using thickness gauge. If measure gap is out of specification, replace ring.

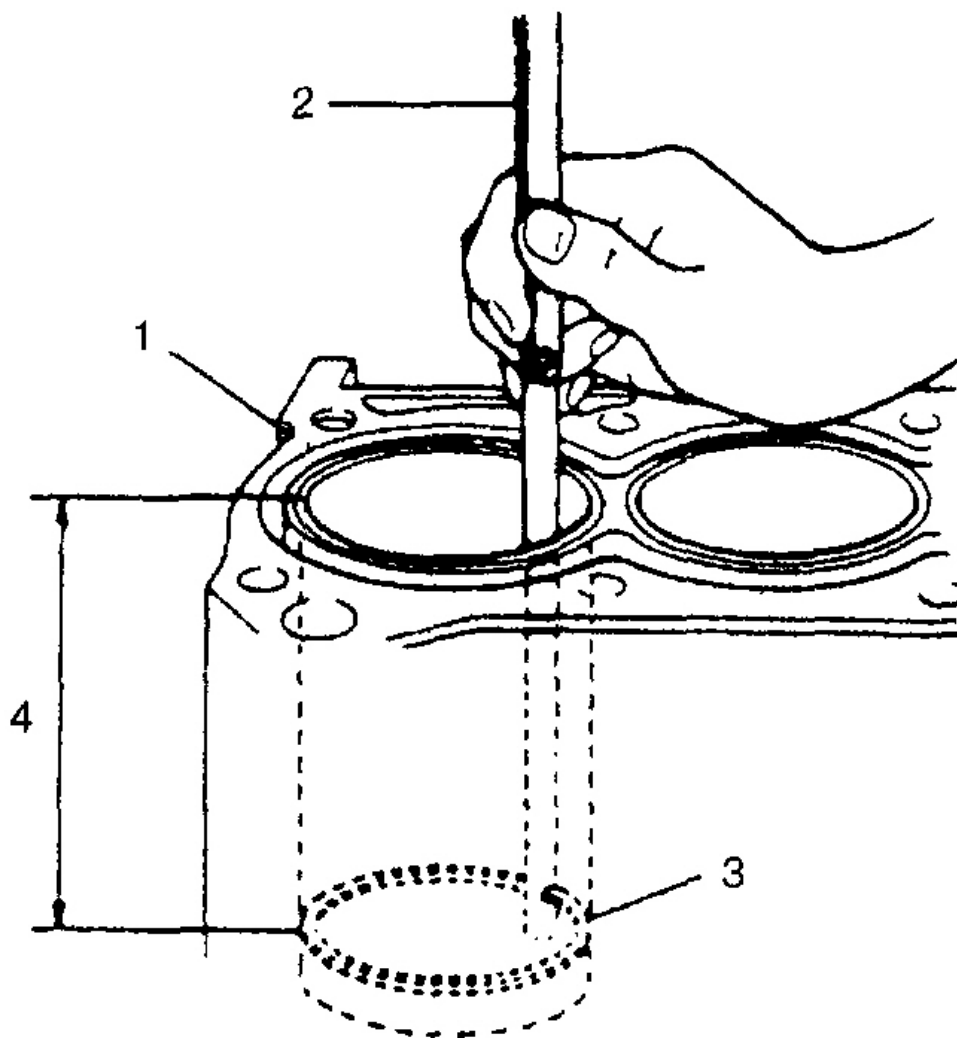
NOTE: Clean carbon and any other dirt from top of cylinder bore before inserting piston ring.

Engine Type	Item	Standard	Limit
H27 engine	Top ring	0.20 – 0.35 mm (0.0079 – 0.0138 in.)	0.7 mm (0.0276 in.)
	2nd ring	0.35 – 0.47 mm (0.0138 – 0.0197 in.)	0.7 mm (0.0276 in.)
	Oil ring	0.20 – 0.70 mm (0.0079 – 0.0276 in.)	1.8 mm (0.0709 in.)
H25 engine	Top ring	0.20 – 0.35 mm (0.0079 – 0.0138 in.)	0.7 mm (0.0276 in.)
	2nd ring	0.35 – 0.50 mm (0.0138 – 0.0197 in.)	0.7 mm (0.0276 in.)
	Oil ring	0.20 – 0.70 mm (0.0079 – 0.0276 in.)	1.8 mm (0.0709 in.)

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Fig. 184: Piston Ring End Gap Chart

Courtesy of SUZUKI OF AMERICA CORP.



1. Cylinder block	3. Piston ring
2. Feeler gauge	4. 120 mm (4.72 in.)

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Fig. 185: Measuring Piston Ring End Gap
Courtesy of SUZUKI OF AMERICA CORP.

PISTON PINS & CONNECTING RODS INSPECTION

Piston Pins

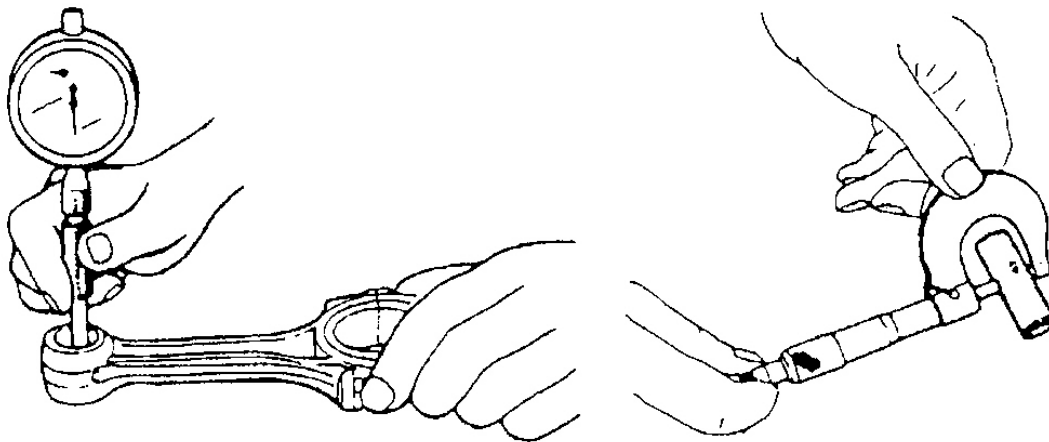
- Check piston pin, connecting rod small end bore and piston bore for wear or damage, paying particular attention to condition of small end bore bush. If pin, connecting rod small end bore or piston bore is badly worn or damaged, replace pin, connecting rod or piston.
- Piston pin clearance:

Check piston pin clearance in small end. Replace connecting rod if its small end is badly worn or damaged or if measured clearance exceeds limit.

Piston pin clearance in small end: 0.003 - 0.014 mm (0.0001 - 0.0006 in.)

Small-end bore: 21.003 - 21.011 mm (0.8269 - 0.8272 in.)

Piston pin diameter: 20.997 - 21.000 mm (0.8267 - 0.8268 in.)



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Fig. 186: Measuring Piston Pin & Connecting Rod Small End
Courtesy of SUZUKI OF AMERICA CORP.

Connecting Rods

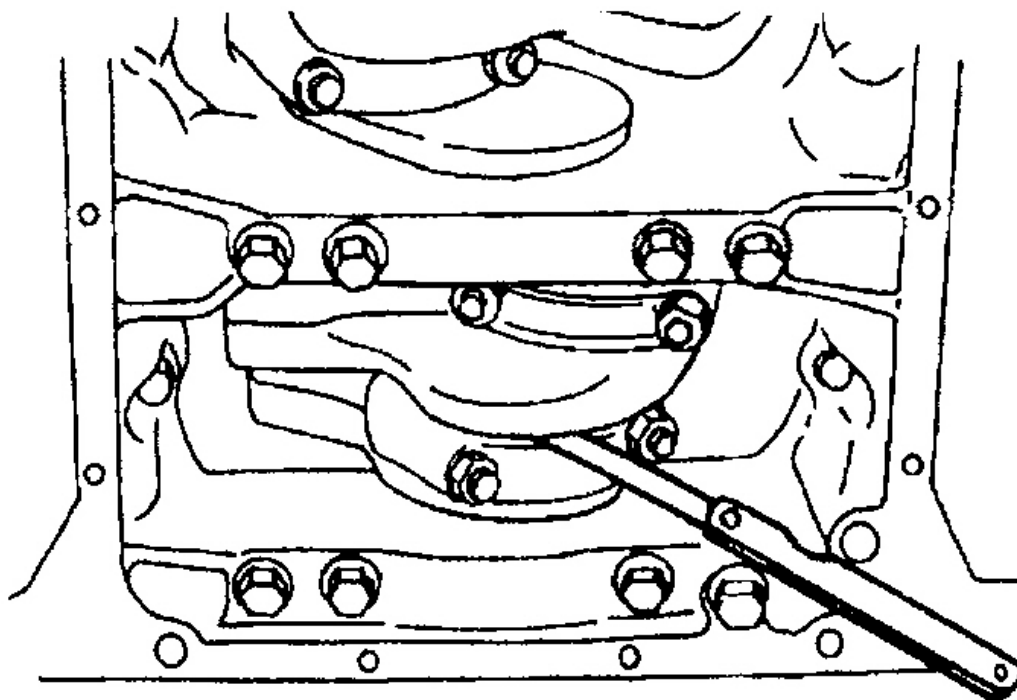
- Big-end side clearance:

Check big-end of connecting rod for side clearance, with rod fitted and connected to its crank pin in the normal manner. If measured clearance is found to exceed its limit, replace connecting rod.

Big-end side clearance

Standard: 0.25 - 0.35 mm (0.0098 - 0.0138 in.)

Limit: 0.45 mm (0.0177 in.)



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Fig. 187: Measuring Connecting Rod Side Clearance
Courtesy of SUZUKI OF AMERICA CORP.

- Connecting rod alignment:

Mount connecting rod on aligner to check it for bow and twist. If limit is exceeded, replace it.

Connecting rod alignment

Limit on bow: 0.05 mm (0.0020 in.)

Limit on twist: 0.10 mm (0.0039 in.)

Crank Pins & Connecting Rod Bearings Inspection

Inspect crank pin for uneven wear or damage. Measure crank pin for out-of-round or taper with a micrometer. If

crank pin is damaged, or out-of-round or taper is out of limit, replace crankshaft or regrind crank pin then inspect rod bearing clearance referring to **CONNECTING ROD BEARING CLEARANCE** .

Connecting rod bearing size	Crank pin diameter
Standard	49.982 – 50.000 mm (1.9678 – 1.9685 in.)
0.25 mm (0.0098 in.) undersize	49.732 – 49.750 mm (1.9580 – 1.9587 in.)

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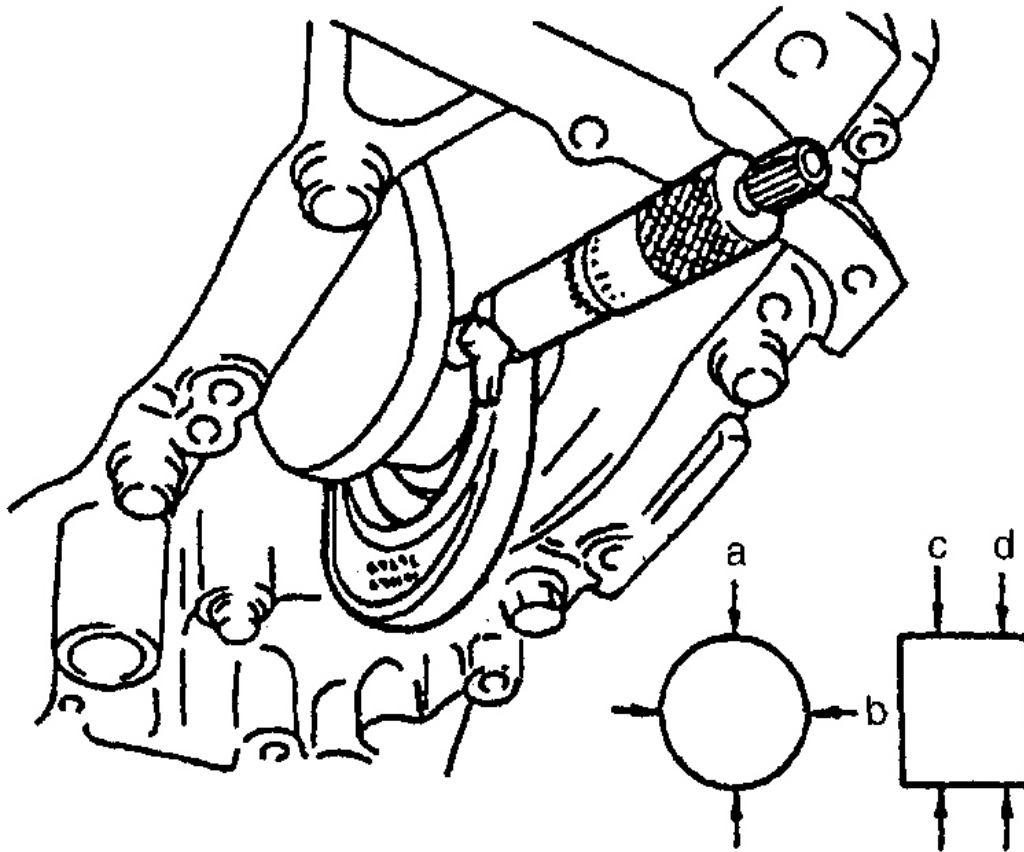
Fig. 188: Connecting Rod Bearing & Crank Pin Diameter Chart
 Courtesy of SUZUKI OF AMERICA CORP.

Crank pin out-of-round (a - b)

Limit: 0.01 mm (0.0004 in.)

Crank pin taper (c - d)

Limit: 0.01 mm (0.0004 in.)

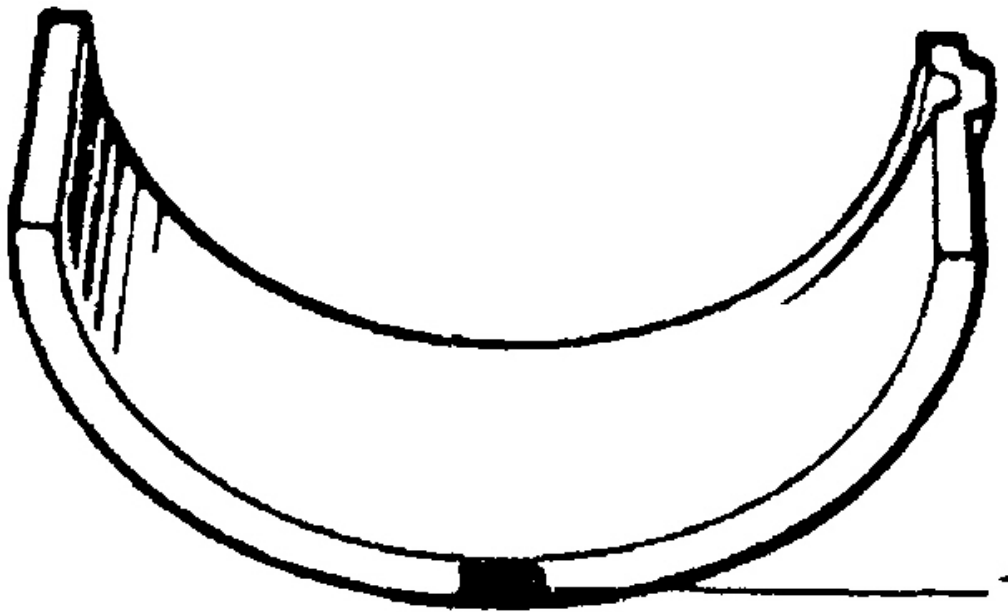


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Fig. 189: Measuring Crank Pin For Out-Of-Round Or Taper
 Courtesy of SUZUKI OF AMERICA CORP.

Connecting rod bearing general information

Service connecting rod bearings are available in standard size and 0.25 mm (0.0098 in.) undersize, and standard size bearing has 5 kinds of bearings differing in tolerance. For identification of undersize bearing, it is painted red at the position as indicated in figure, undersize bearing thickness is 1.605 - 1.615 mm (0.0632 - 0.0635 in.) at the center of it.



1. Painting

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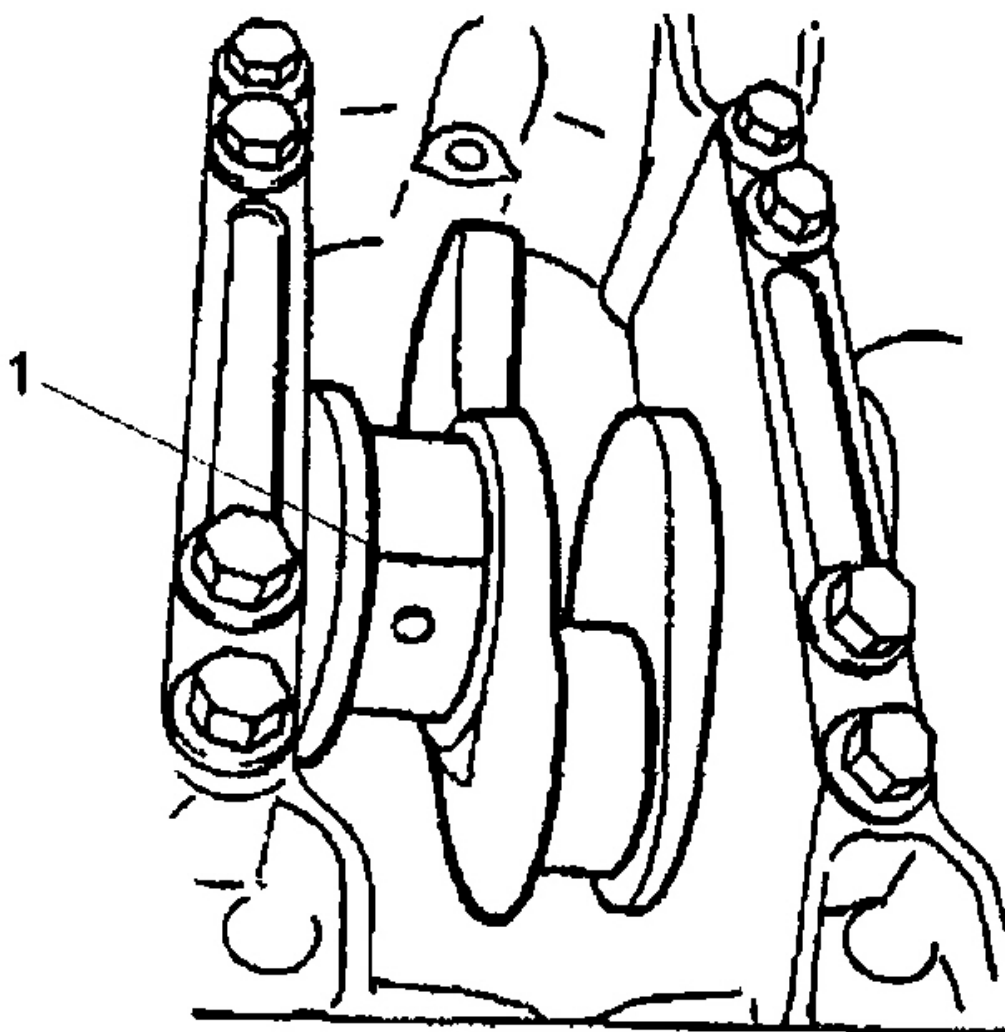
Fig. 190: Identifying Undersize Bearing
Courtesy of SUZUKI OF AMERICA CORP.

Connecting rod bearing visual inspection

Inspect bearing shells for signs of fusion, pitting, burn or flaking and observe contact pattern. Bearing shells found in defective condition must be replaced.

Connecting rod bearing clearance

- A. Before checking bearing clearance, clean bearing and crank pin.
- B. Install bearing in connecting rod and bearing cap.
- C. Place a piece of gaging plastic (1) to full width of crank pin as contacted by bearing (parallel to crankshaft), avoiding oil hole.



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Fig. 191: Placing A Piece Of Gaging Plastic On Crank Pin
Courtesy of SUZUKI OF AMERICA CORP.

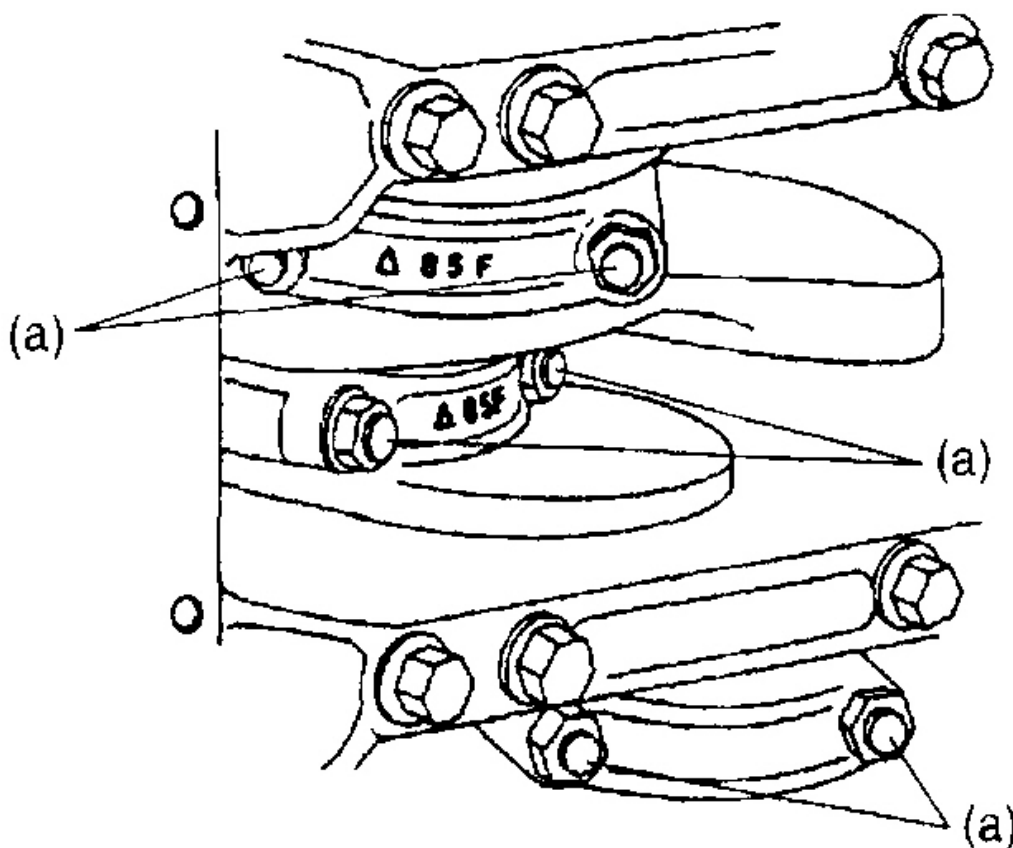
- D. Install rod bearing cap to connecting rod.

When installing cap, be sure to point arrow mark on cap to crankshaft pulley side, as shown in the figure. After applying engine oil to rod bolts, tighten cap nuts to specified torque.

Tightening torque

Connecting rod bearing cap nut (a): 45 N.m (4.5 kg-m, 32.5 lb-ft)

NOTE: DO NOT turn crankshaft with gaging plastic installed.



G02264059

Fig. 192: Installing Rod Cap

Courtesy of SUZUKI OF AMERICA CORP.

- E. Remove cap and using a scale (2) on gaging plastic (1) envelope, measure gaging plastic (1) width at the widest point (clearance).

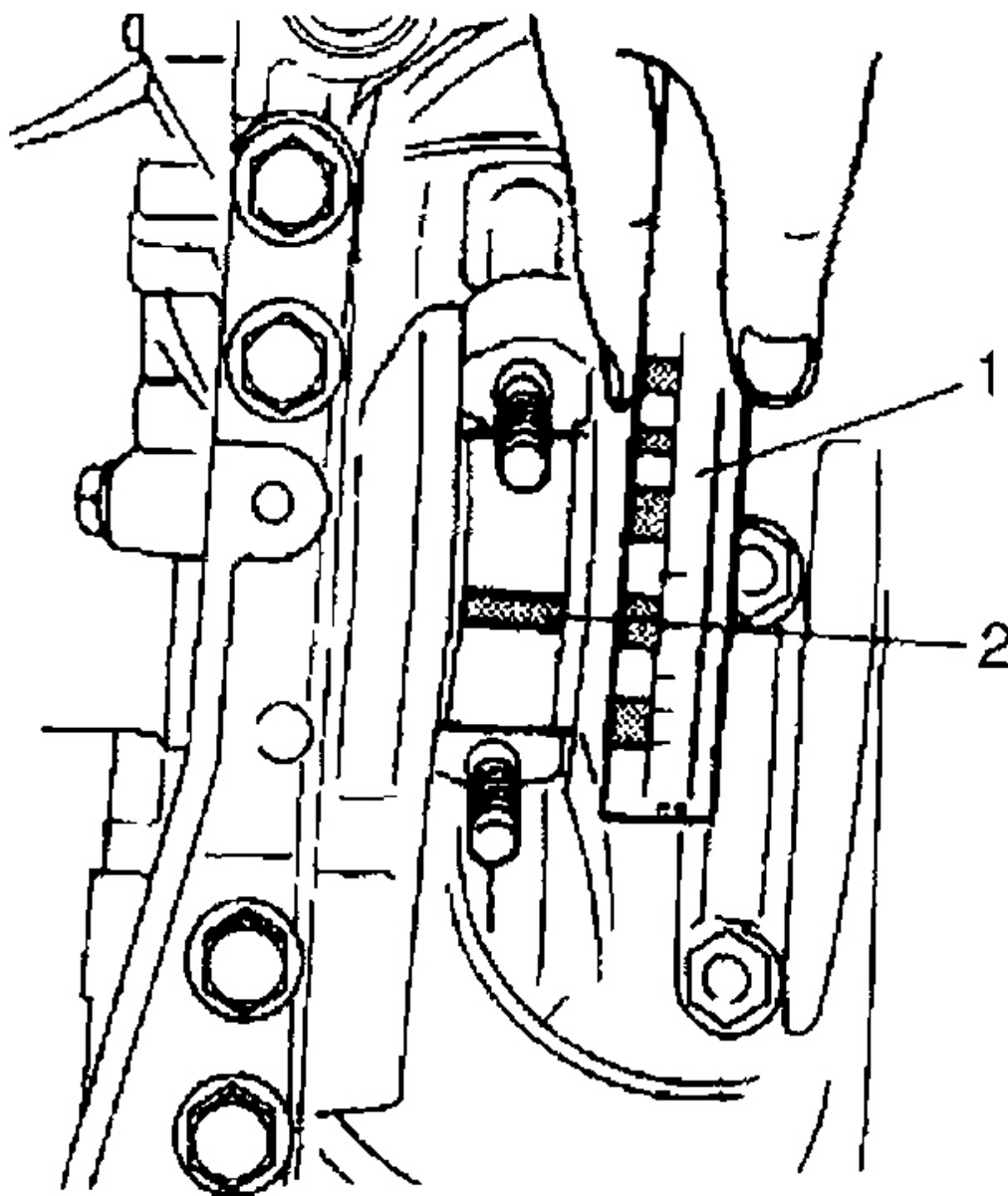
If clearance exceed its limit, use a new standard size bearing referring to **SELECTION OF CONNECTING ROD BEARINGS**.

After selecting new bearing, recheck clearance.

Bearing clearance

Standard: 0.045 - 0.063 mm (0.0018 - 0.0024 in.)

Limit: 0.08 mm (0.0031 in.)



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Fig. 193: Measuring Gaging Plastic
Courtesy of SUZUKI OF AMERICA CORP.

- F. If clearance can not be brought to within its limit even by using a new standard size bearing, regrind crankpin to undersize and use 0.25 mm undersize bearing as follows.

- a. Install 0.25 mm undersize bearing to connecting rod big end.
- b. Measure bore diameter of connecting rod big end.
- c. Regrind crank pin to following finished diameter:

Finished crank pin dia. = Measuring big end bore dia. (including under-size bearing) - 0.054 mm (0.0021 in.)

- d. Confirm that bearing clearance is within above standard value.

Selection of connecting rod bearings

NOTE:

- If bearing is in malcondition, or bearing clearance is out of specification, select a new standard bearing according to the following procedure and install it.
- When replacing crankshaft or connecting rod and its bearing due to any reason, select new standard bearings to be installed by referring to numbers stamped on connecting rod and its cap and/or alphabets stamped on crank web No. 3.

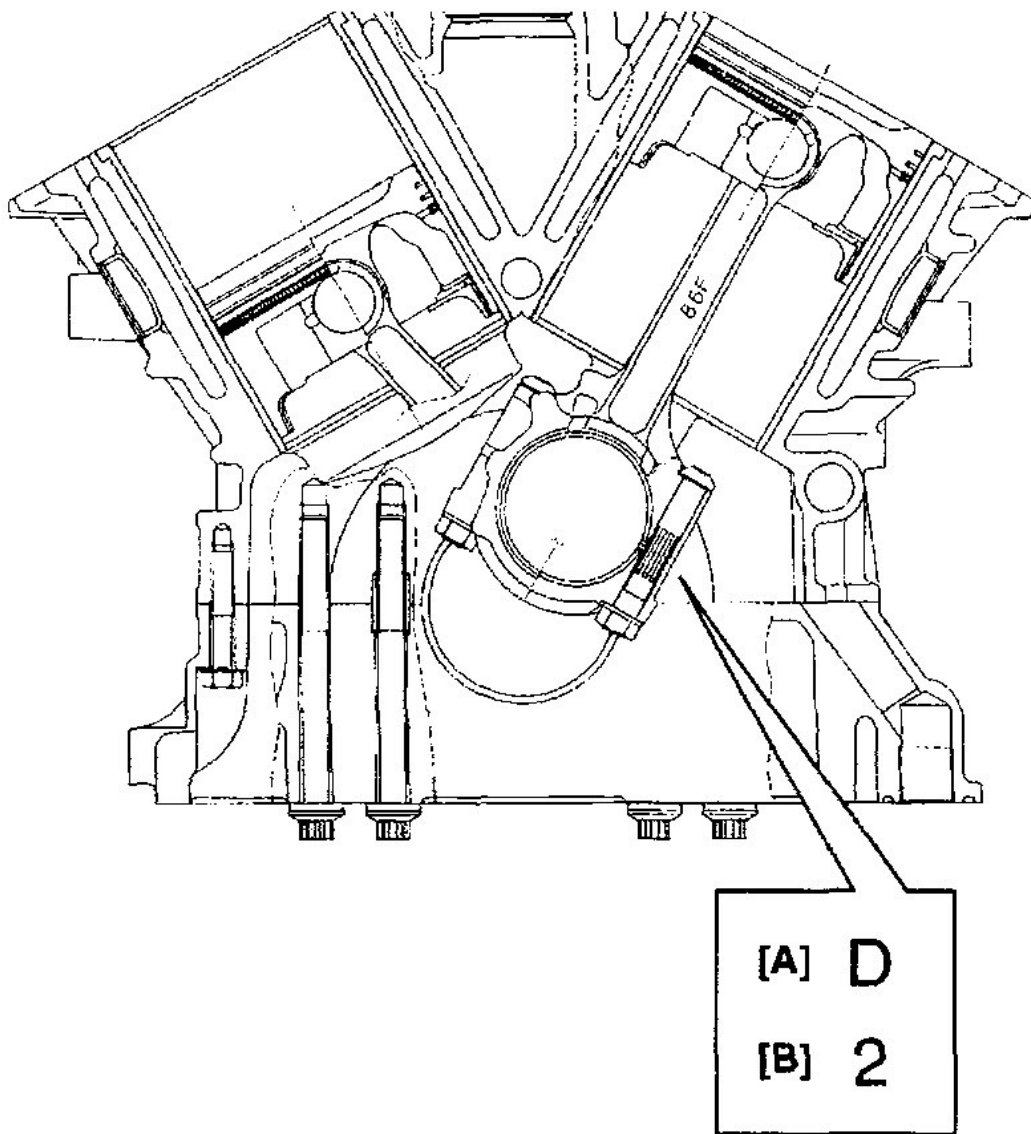
- A. Check stamped numbers on connecting rod and its cap as shown.

Three kinds of numbers ("1", "2" and "3") represent the following connecting rod big end inside diameters. For example, stamped number "1" indicates that corresponding connecting rod big end inside diameter is 53.0000 - 53.0060 mm (2.0867 - 2.0868 in.).

Stamped numbers	connecting rod big end inside diameter
1	53.0000 - 53.0060 mm (2.0867 - 2.0868 in.)
2	53.0061 - 53.0120 mm (2.0869 - 2.0870 in.)
3	53.0121 - 53.0180 mm (2.0871 - 2.0873 in.)

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Fig. 194: Connecting Rod Big End Stamping Identification Chart
Courtesy of SUZUKI OF AMERICA CORP.



[A]: Weight indication mark

[B]: Connecting rod big end inside diameter number

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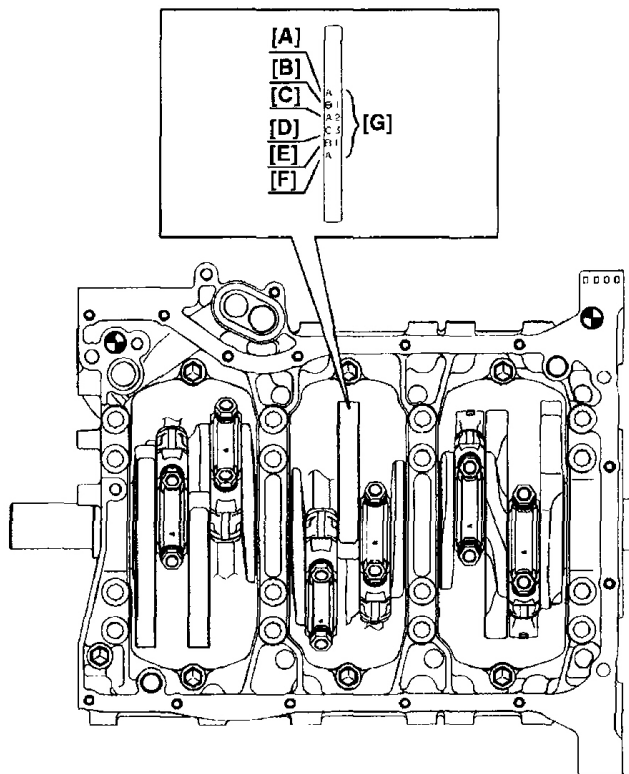
Fig. 195: Locating Connecting Rod Big End Stamping
Courtesy of SUZUKI OF AMERICA CORP.

- B. Next, check crankshaft pin diameter. On crank web No. 3, six alphabets are stamped as shown in figure. Three kinds of alphabet ("A", "B" and "C") represent the following crankshaft pin diameter respectively. For example, stamped "A" indicates that corresponding crankshaft pin diameter is 49.9940 - 50.0000 mm (1.9683 - 1.9685 in.).

Stamped alphabet	Crankshaft pin diameter
A	49.9940 - 50.0000 mm (1.9683 - 1.9685 in.)
B	49.9880 - 49.9939 mm (1.9681 - 1.9682 in.)
C	49.9820 - 49.9879 mm (1.9677 - 1.9680 in.)

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Fig. 196: Crankshaft Pin Diameter Stamping Identification Chart
Courtesy of SUZUKI OF AMERICA CORP.



[A]: Crankshaft pin diameter for No.1 cylinder	[E]: Crankshaft pin diameter for No.5 cylinder
[B]: Crankshaft pin diameter for No.2 cylinder	[F]: Crankshaft pin diameter for No.6 cylinder
[C]: Crankshaft pin diameter for No.3 cylinder	[G]: Crank main shaft outside diameter tolerance mark
[D]: Crankshaft pin diameter for No.4 cylinder	

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Fig. 197: Locating Crankshaft Pin Diameter Stamping
 Courtesy of SUZUKI OF AMERICA CORP.

- C. There are five kinds of standard bearings differing in thickness. To distinguish them, they are painted in the following colors at the position as indicated in figure.

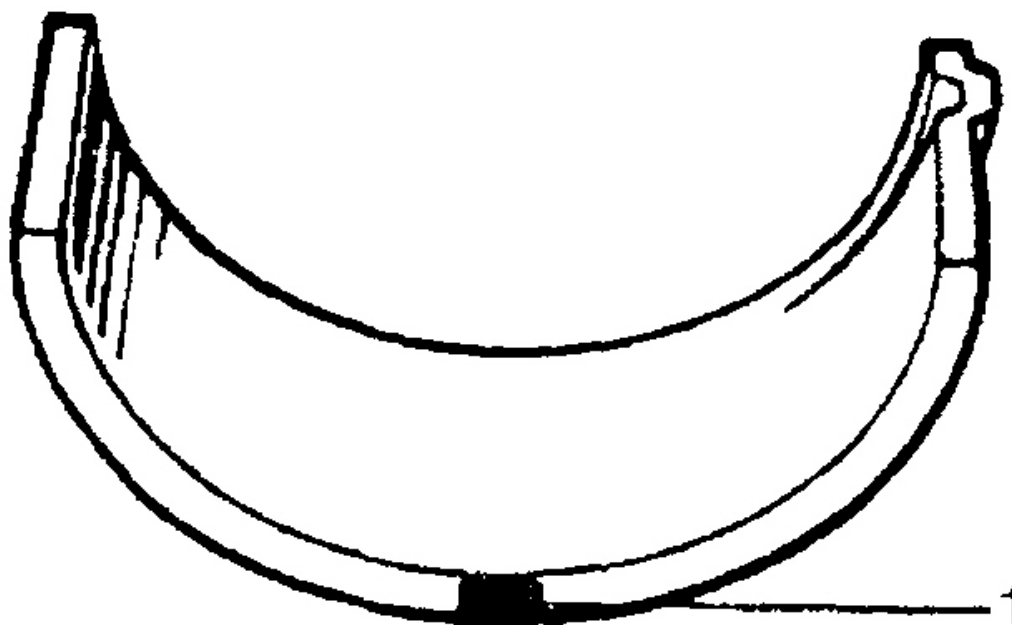
Each color indicated the following thickness at the center of bearing.

Standard size of connecting rod bearing thickness

Color painted	Bearing thickness
Blue	1.494 - 1.497 mm (0.05882 - 0.05893 in.)
Yellow	1.491 - 1.494 mm (0.05871 - 0.05881 in.)
Nothing	1.488 - 1.491 mm (0.05859 - 0.05870 in.)
Black	1.485 - 1.488 mm (0.05847 - 0.05858 in.)
Green	1.482 - 1.485 mm (0.05835 - 0.05846 in.)

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Fig. 198: Standard Connecting Rod Bearing Identification Chart
 Courtesy of SUZUKI OF AMERICA CORP.



1. Paint

G02264066

Fig. 199: Locating Connecting Rod Bearing Paint Mark
Courtesy of SUZUKI OF AMERICA CORP.

- D. From number stamped on connecting rod and its cap and alphabets stamped on crank web No. 3., determine new standard bearing to be installed to connecting rod big end inside, by referring to table. For example, if number stamped on connecting rod and its cap is "1" and alphabet stamped on crank web No. 3 is "B", install a new standard bearing painted in "Black" to its connecting rod big end inside.

		Number stamped on connecting rod and its cap (connecting rod big end inside diameter)		
		1	2	3
Alphabet stamped on crank web No.3 (Crankshaft pin outer diameter)	A	Green	Black	Nothing
	B	Black	Nothing	Yellow
	C	Nothing	Yellow	Blue
		New standard bearing to be installed.		

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Fig. 200: New Standard Connecting Rod Bearing Size Specification Table
Courtesy of SUZUKI OF AMERICA CORP.

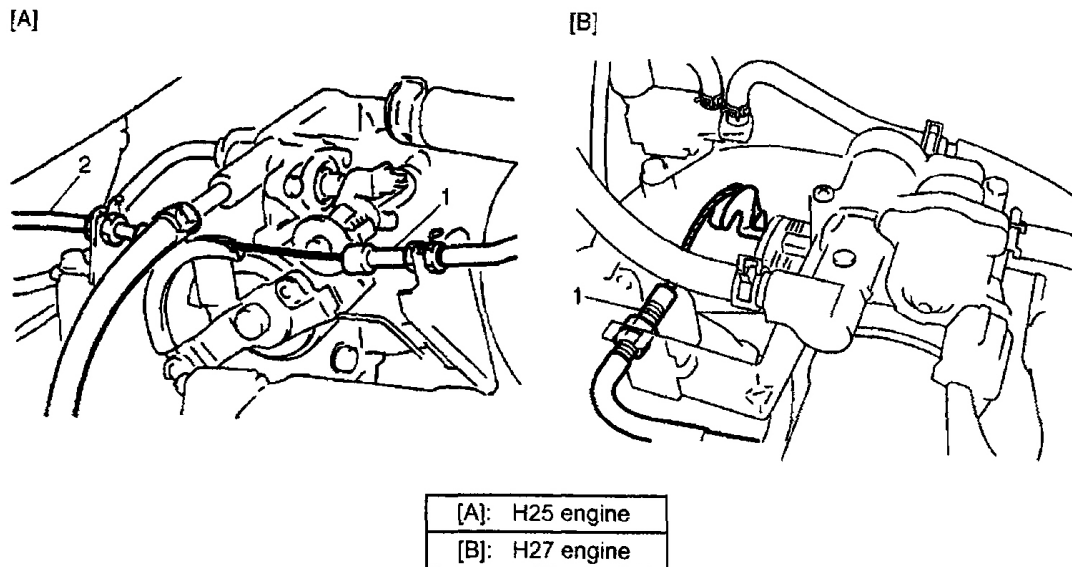
- E. Check bearing clearance with newly selected standard bearing referring to Connecting rod bearing clearance .

If clearance still exceeds its limit, use next thicker bearing and recheck clearance.

ENGINE ASSEMBLY REMOVAL & INSTALLATION

Removal

1. Release fuel pressure in fuel feed line referring to FUEL PRESSURE RELIEF PROCEDURE .
2. Disconnect negative (-) cable at battery.
3. Remove engine hood.
4. Drain engine oil.
5. Drain coolant referring to COOLANT DRAINING .
6. Remove radiator, radiator fan shroud, cooling fan and radiator reservoir. Refer to COOLING FAN & FAN CLUTCH REMOVAL & INSTALLATION and RADIATOR REMOVAL & INSTALLATION .
7. Disconnect accelerator cable (1) and A/T throttle cable (2) (with A/T) from throttle body.



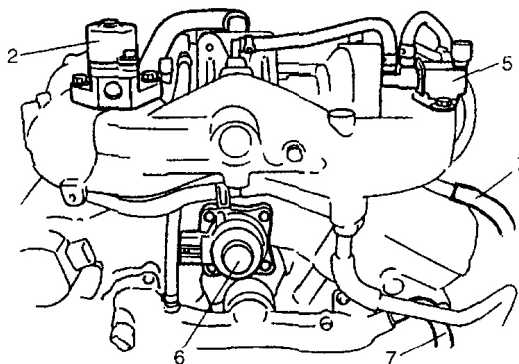
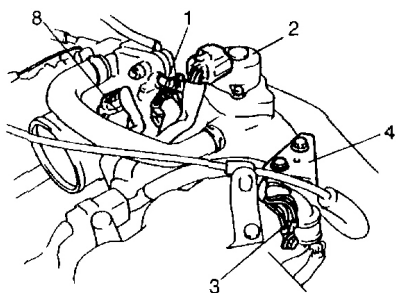
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Fig. 201: Disconnecting Accelerator Cable From Throttle Body
 Courtesy of SUZUKI OF AMERICA CORP.

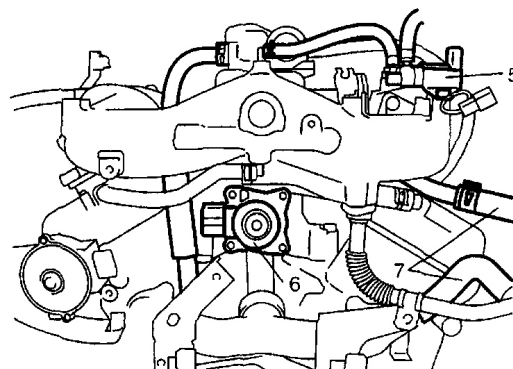
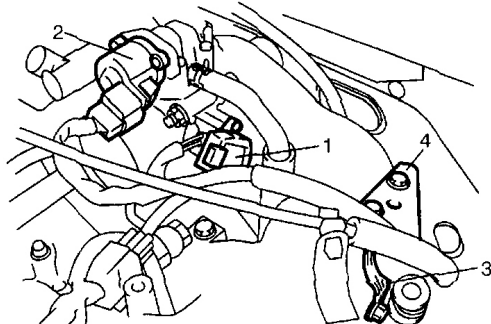
8. Detach fuse/relay box, then remove strut tower bar and surge tank cover.
9. Remove air cleaner upper case, intake air hose, intake air pipe and surge tank pipe as a component.
10. Remove engine oil level gauge guide and A/T fluid level gauge guide (for A/T vehicle).
11. Remove ignition coil covers.
12. Disconnect the following electric lead wires:
 - Injector wire coupler
 - CMP sensor coupler
 - Ignition coil couplers
 - CKP sensor coupler
 - MAP sensor coupler
 - MAF sensor (8) coupler
 - TP sensor (1) coupler
 - IAC valve (2) coupler
 - Earth wire (3) from surge tank
 - EVAP canister purge valve (5) coupler
 - EGR valve (6) coupler
 - Oxygen sensor-1 and -2 couplers (Refer to **EXHAUST MANIFOLD REMOVAL & INSTALLATION**)
 - Coolant temperature sensor coupler
 - Generator wires

- Starter wires
 - Oil pressure wire
 - P/S pump wire
 - Earth wire from generator bracket
 - Engine block heater (if equipped)
13. Remove clamps and brackets (4).
 14. Disconnect the following hoses:
 - Heater hose (7) from heater water pipe and water outlet cap
 - Tank pressure control solenoid valve hose from intake manifold
 - EVAP canister hose from canister purge pipe
 - Brake booster vacuum hose
 15. Remove EVAP canister purge valve (5).
 16. Remove IAC valve (2).

[A]



[B]



[A]: H25 engine

[B]: H27 engine

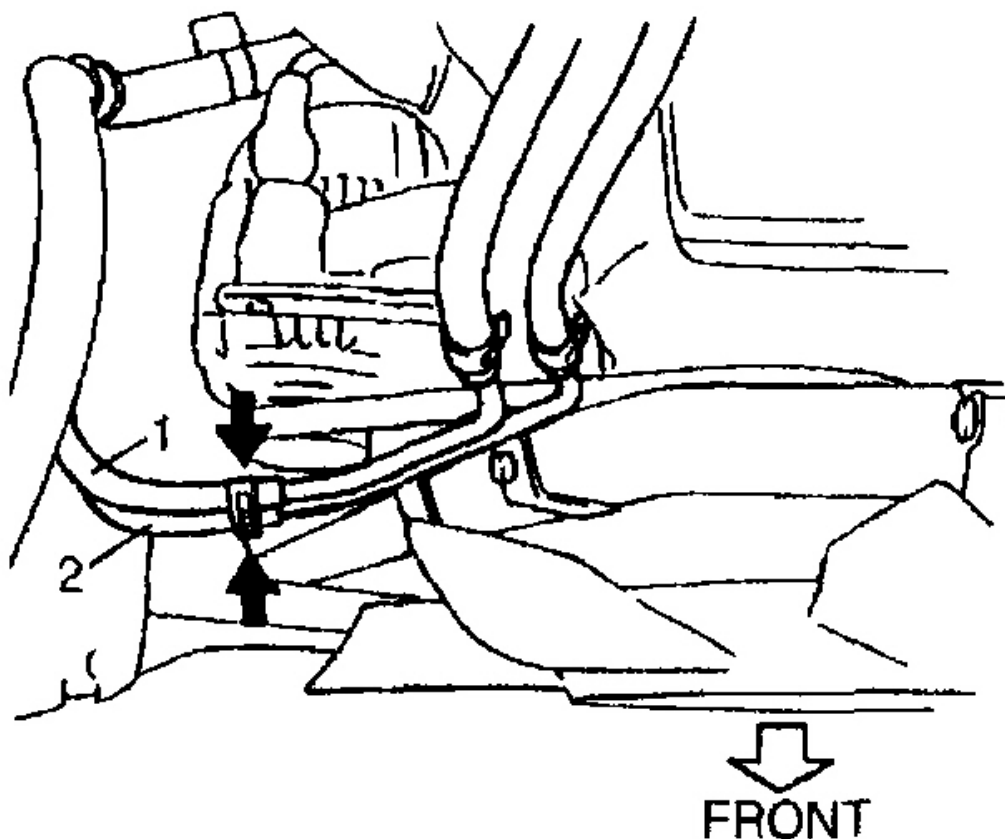
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Fig. 202: Locating Connectors

Courtesy of SUZUKI OF AMERICA CORP.

17. Disconnect the following hoses at the location shown in the figure:

- Fuel feed hose (1) from fuel feed pipe
- Fuel return hose (2) from fuel return pipe



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Fig. 203: Locating Hoses

Courtesy of SUZUKI OF AMERICA CORP.

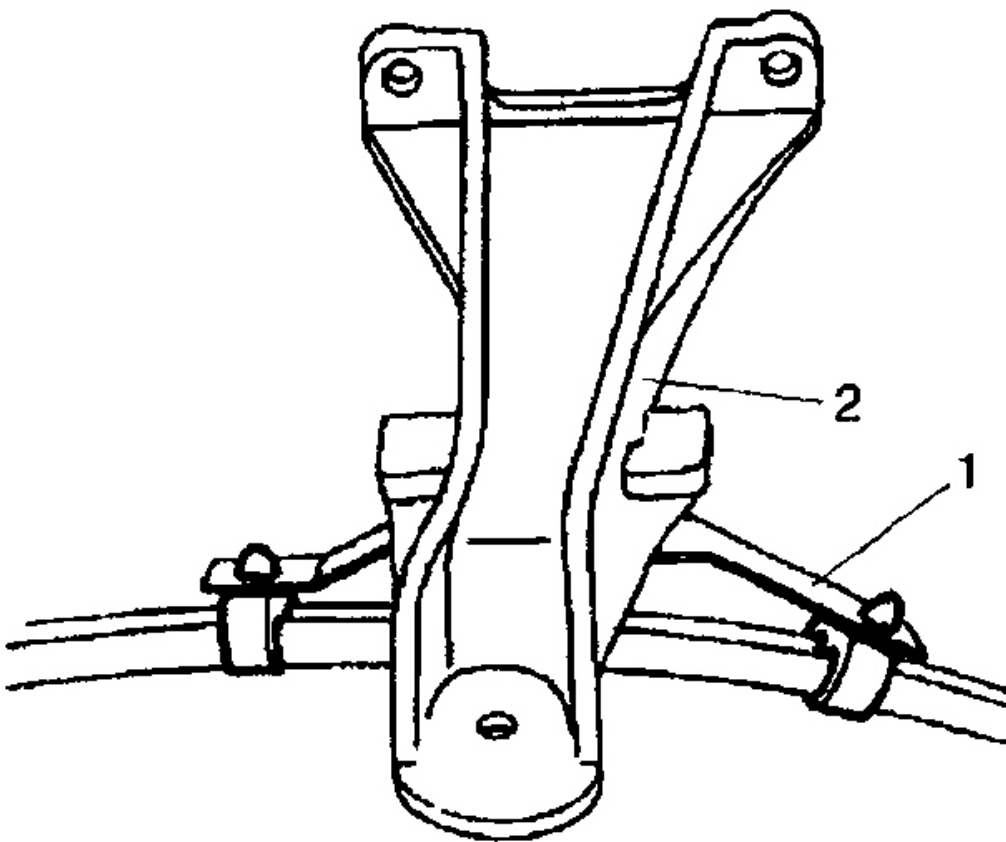
18. Remove P/S pump assembly referring to **P/S PUMP REMOVAL & INSTALLATION**.
19. Remove A/C compressor assembly.

Refer to **COMPRESSOR ASSEMBLY REMOVAL & INSTALLATION FOR H25 ENGINE MODEL**.

20. Remove steering shaft lower assembly referring to **STEERING LOWER SHAFT ASSEMBLY**

REMOVAL & INSTALLATION .

21. Raise vehicle.
22. Remove front differential housing with differential from chassis if equipped. Refer to **FRONT DIFFERENTIAL DISMOUNTING & REMOUNTING .**
23. Remove exhaust No. 1 pipe referring to **EXHAUST MANIFOLD REMOVAL & INSTALLATION .**
24. Remove exhaust manifold stiffener from transmission.
25. Remove A/T fluid hose clamps (1) from engine mounting bracket (2). (for A/T vehicle)



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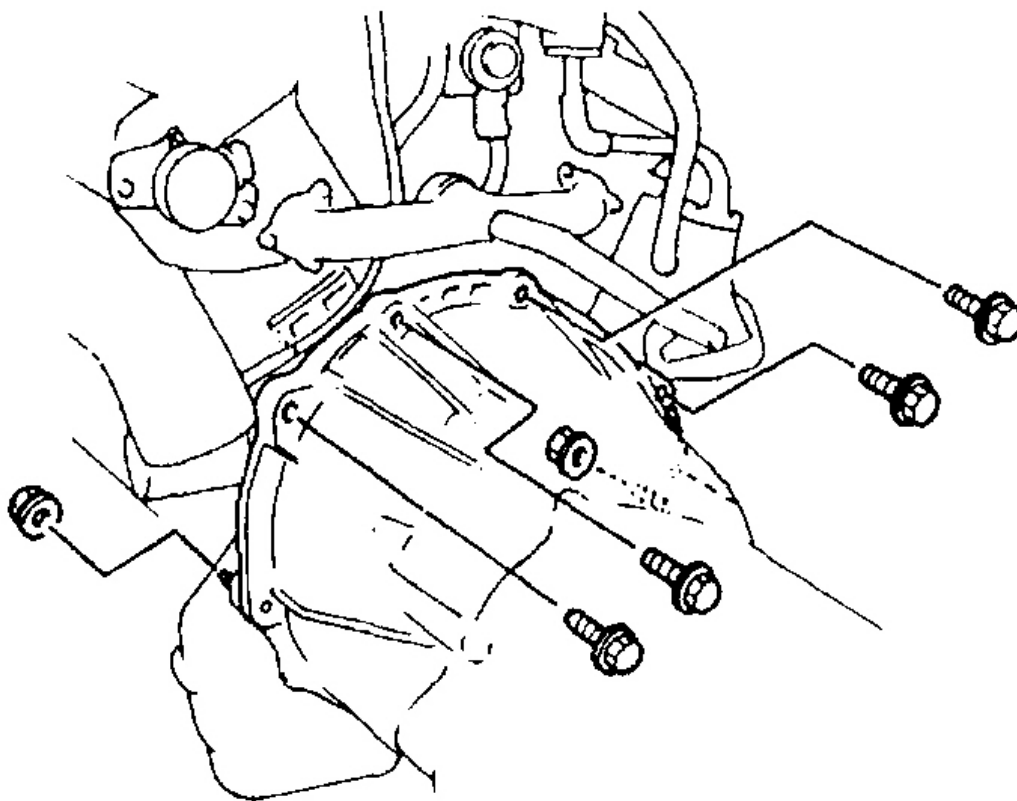
Fig. 204: Removing A/T Fluid Hose Clamps From Engine Mounting Bracket (A/T Only)
Courtesy of SUZUKI OF AMERICA CORP.

26. Remove clutch housing lower plate.
27. Remove torque converter bolts (for A/T vehicle).

28. Remove starter motor.
29. Lower vehicle.
30. Support transmission.

CAUTION: Do not support A/T by placing a jacking equipment under oil pan. If may damage to A/T.

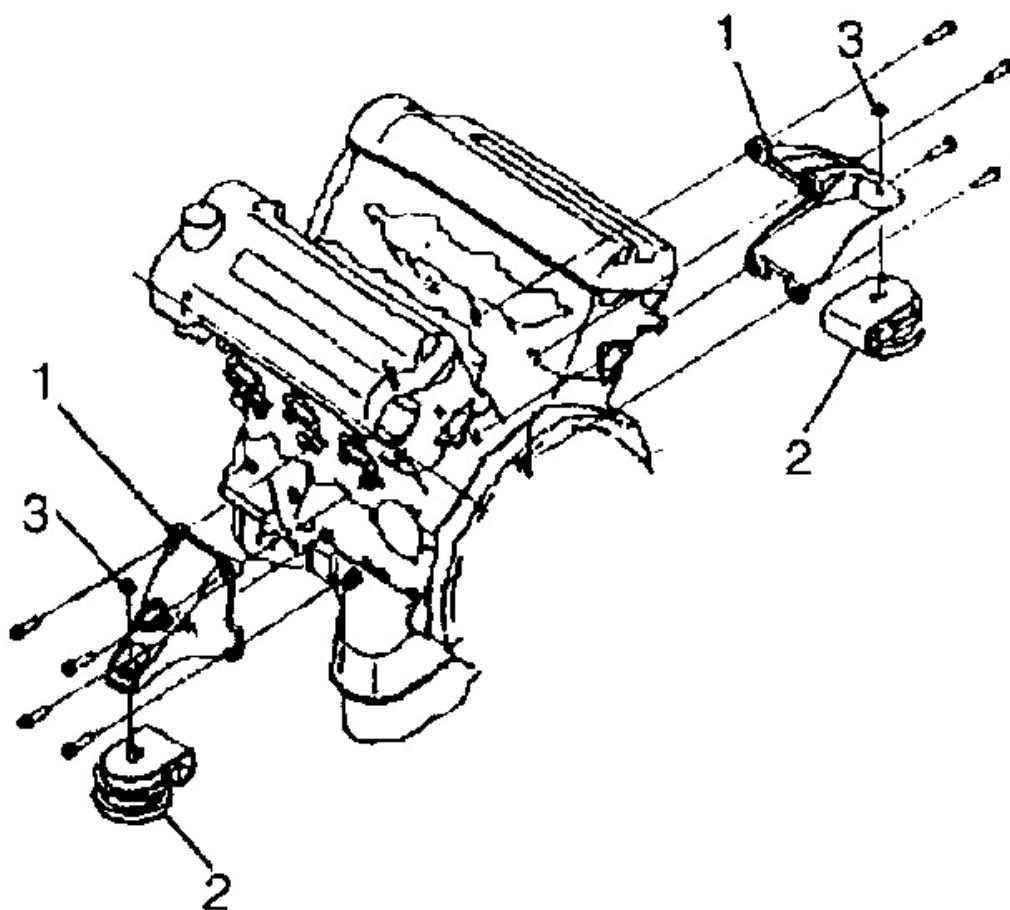
31. Remove bolts and nuts fastening cylinder block and transmission.



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Fig. 205: Removing Bolts & Nuts Fastening Cylinder Block & Transmission
Courtesy of SUZUKI OF AMERICA CORP.

32. Install lifting device.
33. Disconnect engine side mounting brackets (1) from engine mountings (2) by removing nuts (3).



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Fig. 206: Disconnecting Engine Side Mounting Brackets
Courtesy of SUZUKI OF AMERICA CORP.

34. Before lifting engine, check to ensure all hoses, wires and cables are disconnected from engine.
35. Remove engine assembly from chassis and transmission by sliding toward front, and then, carefully hoist engine assembly.

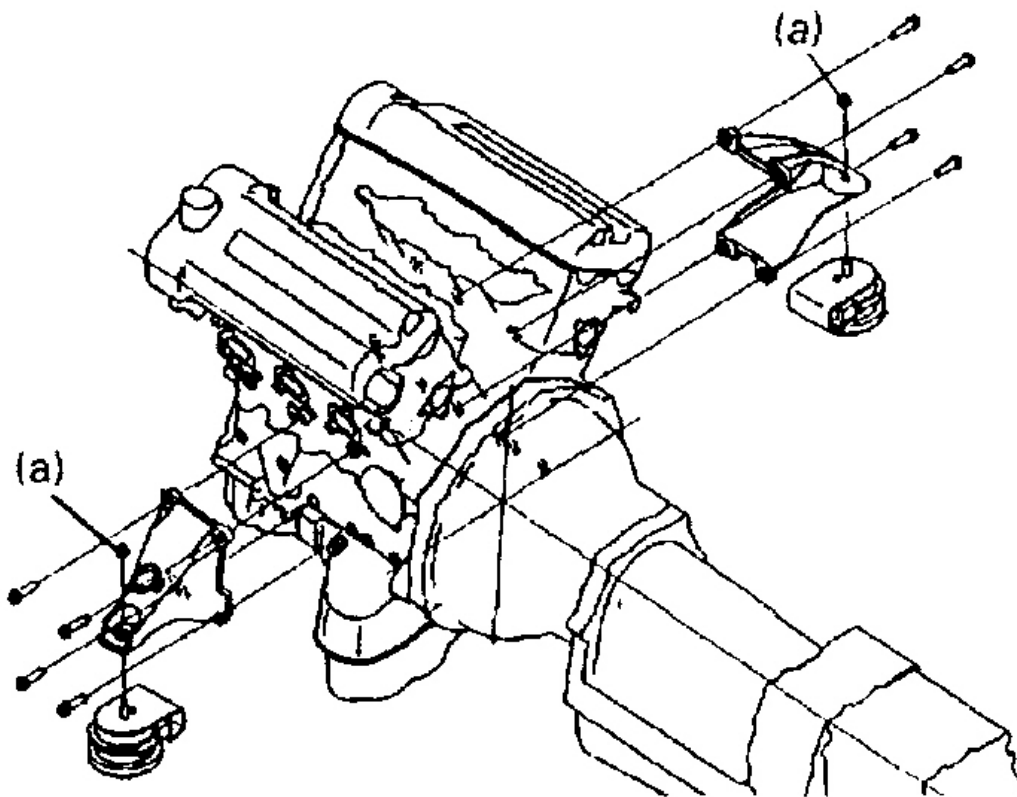
Installation

Reverse removal procedure for installation noting the following points.

- Tighten engine side mounting bracket nuts to specified torque.

Tightening torque

Engine side mounting bracket nut (a): 55 N.m (5.5 kg-m, 40.0 lb-ft)



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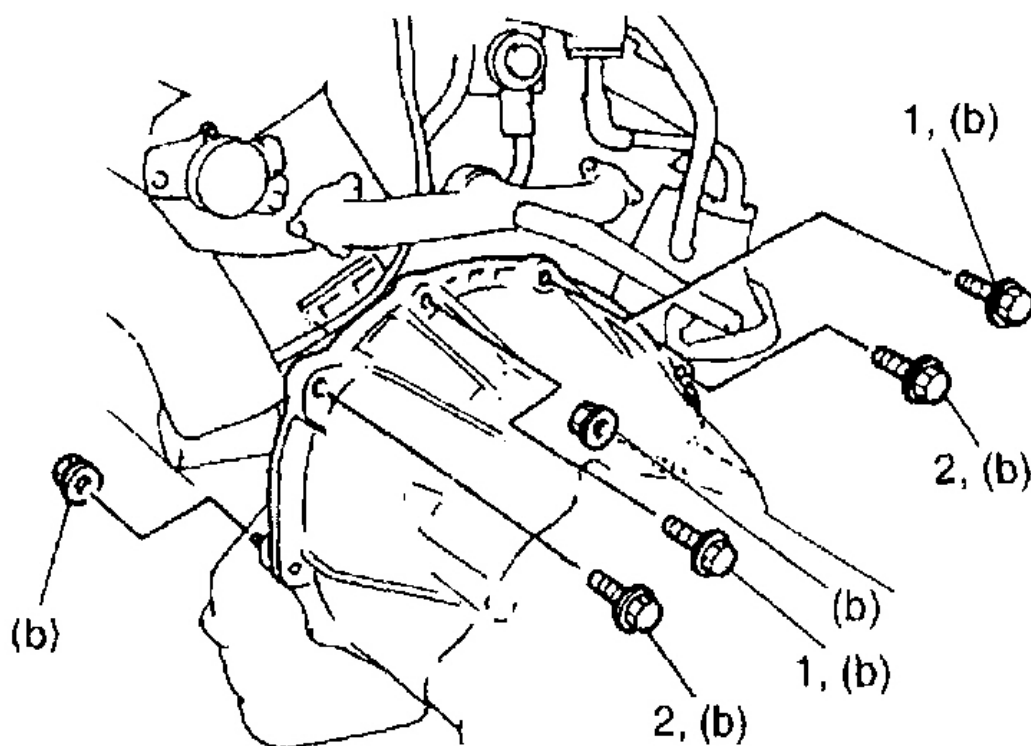
Fig. 207: Exploded View Of Engine Side Mounting Brackets
Courtesy of SUZUKI OF AMERICA CORP.

- Tighten transmission case bolts and nuts to specified torque.

Tightening torque

Transmission case bolt and nut (b): 85 N.m (8.5 kg-m, 61.5 lb-ft) (for M/T vehicle)

Transmission case bolt and nut (b): 80 N.m (8.0 kg-m, 58.0 lb-ft) (for A/T vehicle)



1. Bolt (short)

2. Bolt (Long)

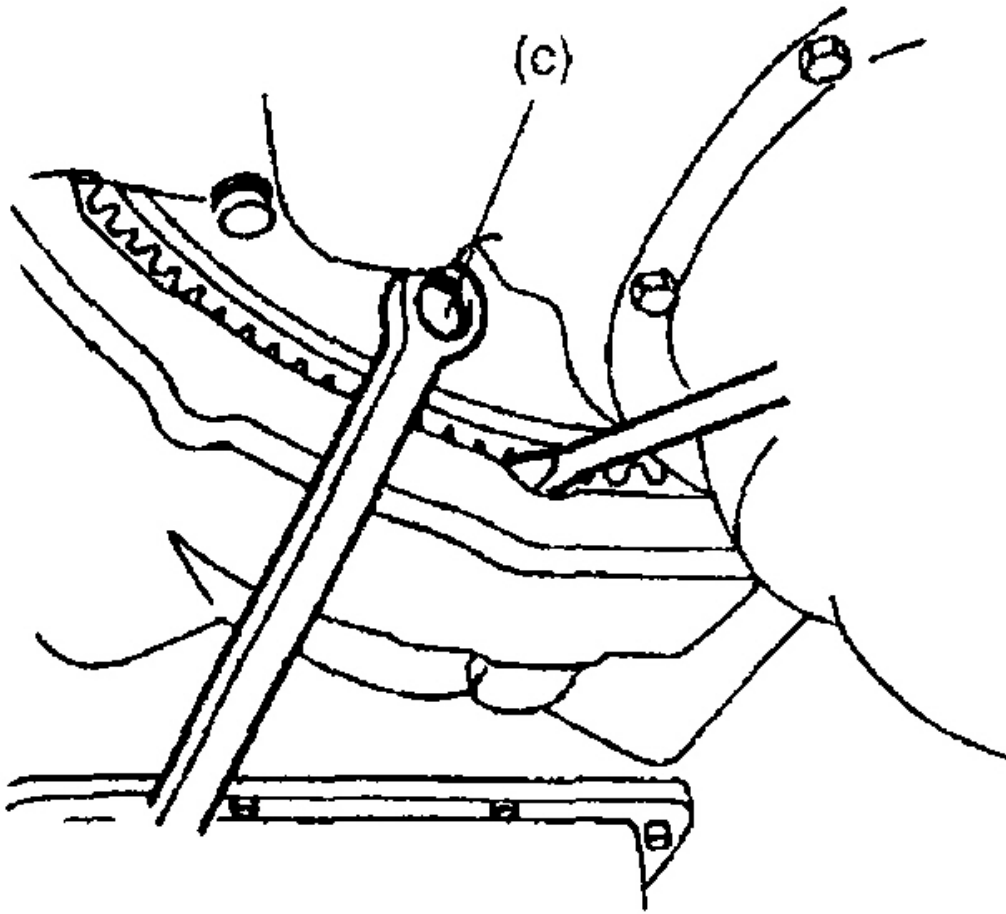
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Fig. 208: Identifying Transmission Case Bolts & Nuts
Courtesy of SUZUKI OF AMERICA CORP.

- Tighten torque converter bolts to specified torque (for A/T vehicle).

Tightening torque

Torque converter bolt (c): 65 N.m (6.5 kg-m, 47.0 lb-ft)



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Fig. 209: Tightening Torque Converter Bolts (A/T Only)

Courtesy of SUZUKI OF AMERICA CORP.

- Tighten bolts and nuts of exhaust No. 1 pipe (1) to specified torque.

Tightening torque**Exhaust No. 1 pipe bolt and nut (d): 50 N.m (5.0 kg-m, 36.5 lb-ft)**

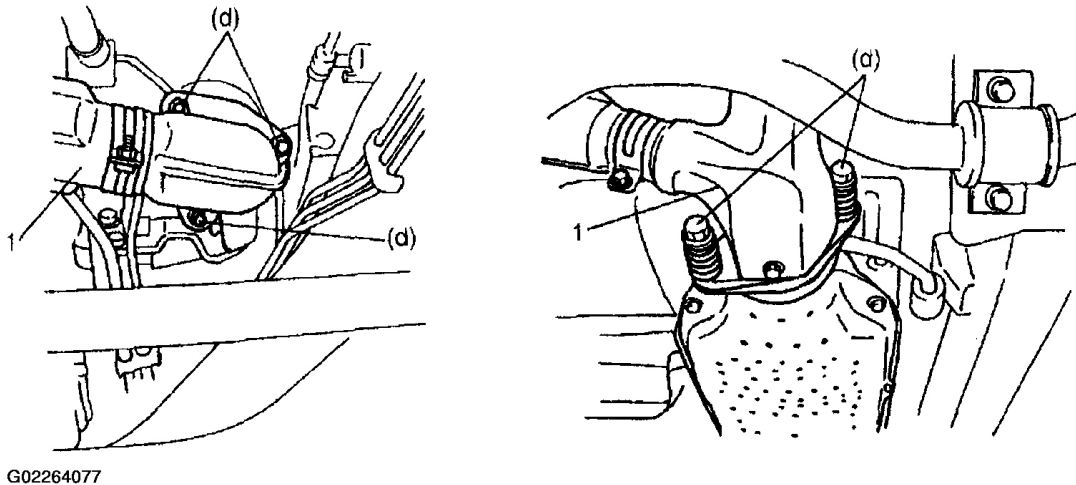


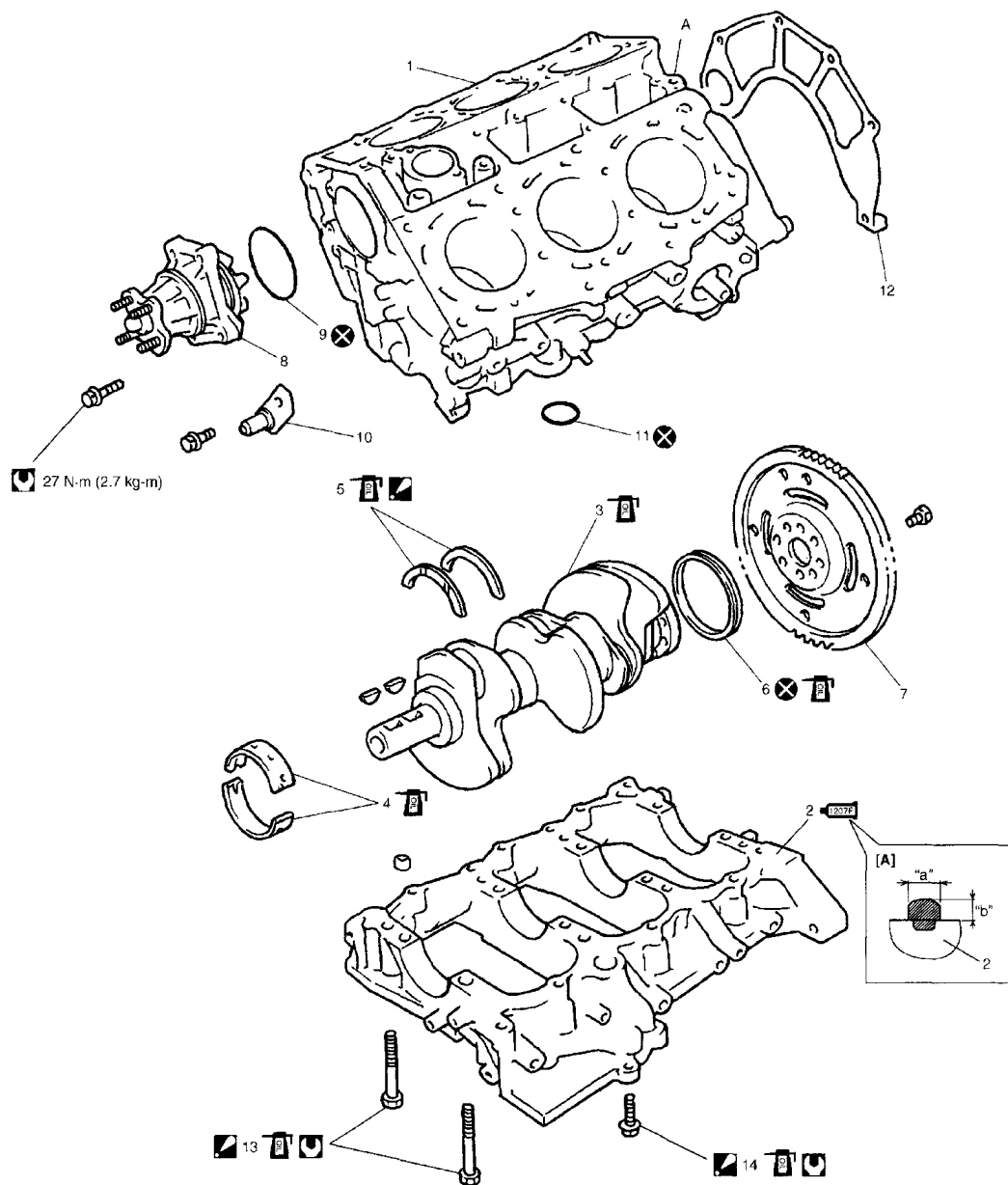
Fig. 210: Tightening Bolts & Nuts Of Exhaust No. 1 Pipe
 Courtesy of SUZUKI OF AMERICA CORP.

- Install front differential housing with differential to chassis referring to **FRONT DIFFERENTIAL DISMOUNTING & REMOUNTING** , if necessary.
- Install steering shaft lower assembly referring to **STEERING LOWER SHAFT ASSEMBLY REMOVAL & INSTALLATION** .
- Install A/C compressor assembly.
- Refer to **COMPRESSOR ASSEMBLY REMOVAL & INSTALLATION** .
- Install P/S pump assembly referring to **P/S PUMP REMOVAL & INSTALLATION** .
- Adjust accelerator cable play and A/T throttle cable play (with A/T) referring to **ACCELERATOR CABLE ADJUSTMENT** and **A/T THROTTLE CABLE ADJUSTMENT (H25 ENGINE WITH A/T ONLY)** .
- Refill engine with engine oil .
- Refill cooling system referring to **COOLING SYSTEM FLUSH & REFILL** .
- Check to ensure that all fasteners and clamps are tightened.
- Upon completion of installation, verify that there is no fuel leakage, coolant leakage, P/S fluid leakage or exhaust gas leakage at each connection.

MAIN BEARINGS, CRANKSHAFT & CYLINDER BLOCK COMPONENTS

2004 Suzuki Grand Vitara EX

2004 ENGINES 2.5L V6



1. Cylinder block	8. Water pump	[A]: Sealant application amount
2. Lower crankcase: Apply sealant 99000-31250 to lower crankcase mating surface.	9. O-ring	"a": Width 3 mm (0.12 in.)
3. Crankshaft: Apply engine oil to crankshaft journals.	10. Timing chain oil jet	"b": Height 2 mm (0.08 in.)
4. Main bearing: Apply engine oil to bearing inside surfaces.	11. O-ring	Tightening torque
5. Thrust bearing: Set bearing facing grooved side to crank weds. Apply engine oil.	12. Clutch housing plate	Do not reuse.
6. Rear oil seal: Apply engine oil to contact part of crankshaft with oil seal lip.	13. Crankcase bolt (10 mm (0.39 in.) thread diameter): Tighten 42 N·m (4.2 kg-m, 30.5 lb-ft), 0 N·m (0 kg-m, 0 lb-ft), 42 N·m (4.2 kg-m, 30.5 lb-ft) and 60 N·m (6.0 kg-m, 43.5 lb-ft) by the specified procedure.	Apply engine oil.
7. Flywheel (M/T), Drive plate (A/T)	14. Crankcase bolt (8 mm (0.31 in.) thread diameter): Tighten 27 N·m (2.7 kg-m, 19.5 lb-ft) by the specified procedure.	

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Fig. 211: Exploded View Of Main Bearings, Crankshaft & Cylinder Block Components
Courtesy of SUZUKI OF AMERICA CORP.

MAIN BEARINGS, CRANKSHAFT & CYLINDER BLOCK REMOVAL & INSTALLATION

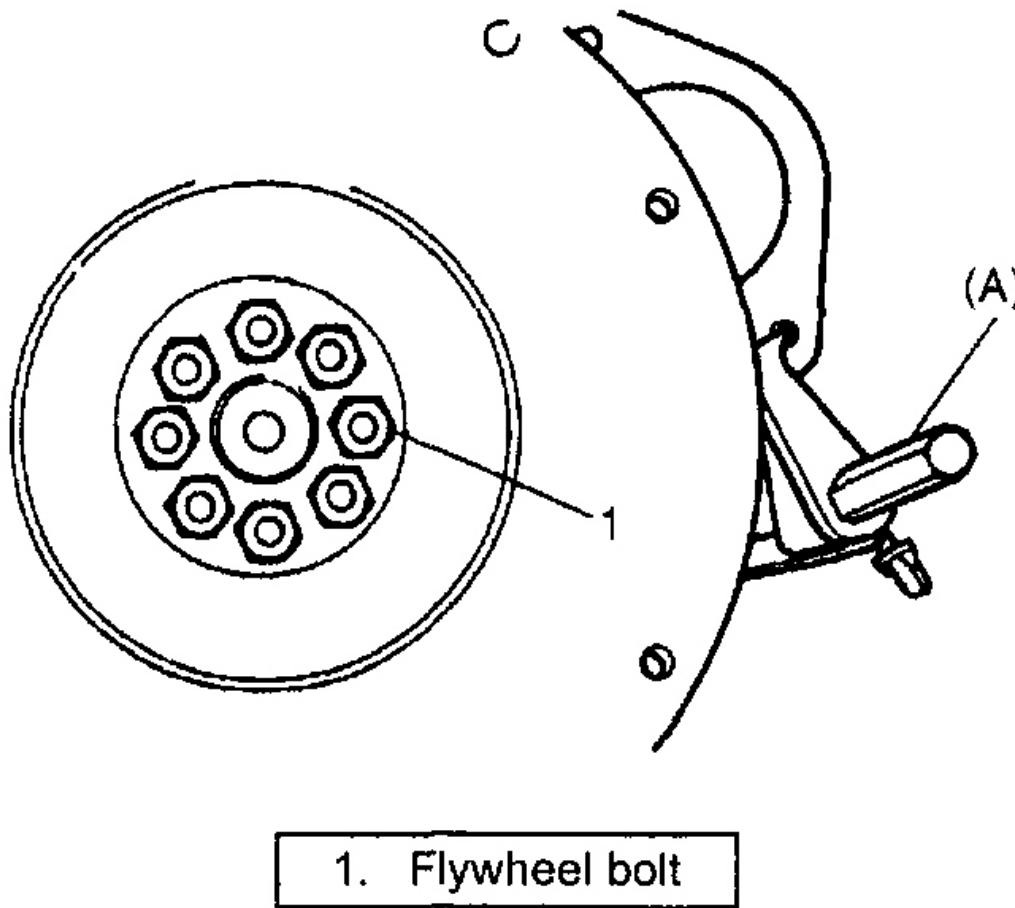
Removal

1. Remove engine assembly from vehicle referring to **ENGINE ASSEMBLY REMOVAL & INSTALLATION** .
2. Remove clutch and flywheel (for M/T vehicle) or drive plate (for A/T vehicle). For clutch removal, refer to **CLUTCH COVER, CLUTCH DISC & FLYWHEEL REMOVAL & INSTALLATION** .

Using special tool (flywheel holder), remove flywheel (M/T vehicle) or drive plate (A/T vehicle).

Special tool

(A): 09924-17811



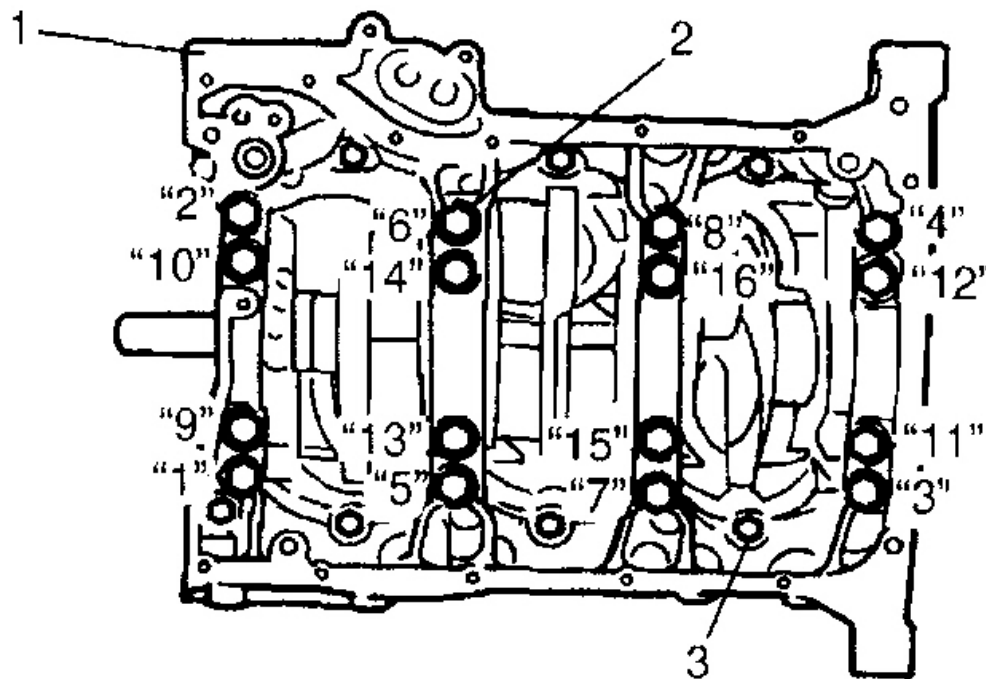
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Fig. 212: Removing Flywheel (M/T) Or Drive Plate (A/T)
Courtesy of SUZUKI OF AMERICA CORP.

3. Remove throttle body with intake manifold and exhaust manifold referring to **THROTTLE BODY & INTAKE MANIFOLD REMOVAL & INSTALLATION (H25 ENGINE)** and **EXHAUST MANIFOLD REMOVAL & INSTALLATION**.
4. Remove oil pans (lower and upper) and oil pump strainer. Refer to **OIL PAN & OIL PUMP STRAINER REMOVAL & INSTALLATION**.
5. Remove cylinder head cover referring to **CYLINDER HEAD COVERS REMOVAL & INSTALLATION**.
6. Remove timing chain cover. Refer to **TIMING CHAIN COVER REMOVAL & INSTALLATION**.
7. Remove LH bank 2nd timing chain and tensioner referring to **LH (NO. 1) BANK 2ND TIMING CHAIN & CHAIN TENSIONER REMOVAL**.

8. Remove 1st timing chain and tensioner referring to **1ST TIMING CHAIN & CHAIN TENSIONER REMOVAL** .
9. Remove RH bank 2nd timing chain and tensioner referring to **RH (NO. 2) BANK 2ND TIMING CHAIN & CHAIN TENSIONER REMOVAL** .
10. Remove cylinder head assembly referring to **VALVES & CYLINDER HEADS REMOVAL & INSTALLATION** .
11. Remove pistons and connecting rods referring to **PISTONS, PISTON RINGS, CONNECTING RODS & CYLINDERS REMOVAL & INSTALLATION** .
12. Remove oil pump referring to **OIL PUMP REMOVAL & INSTALLATION** .
13. Remove oil pump chain referring to **OIL PUMP CHAIN REMOVAL & INSTALLATION** .
14. Loosen crankcase bolts, following sequence in figure and remove them.

NOTE: Loosen 8 mm (0.31 in.) thread diameter bolts first, then loosen 10 mm (0.39 in.) thread diameter bolts following the order shown in the figure.



1. Lower crankcase
2. Bolt (10 mm (0.39 in.) thread diameter)
3. Bolt (8 mm (0.31 in.) thread diameter)

G02264080

Fig. 213: Identifying Crankcase Bolt Loosening Sequence
Courtesy of SUZUKI OF AMERICA CORP.

15. Remove crankshaft from cylinder block.

Installation

NOTE:

- All parts to be installed must be perfectly clean.
- Be sure to oil crankshaft journals, journal bearings, thrust bearings, crank pins, connecting rod bearings, pistons, piston rings and cylinder bores.

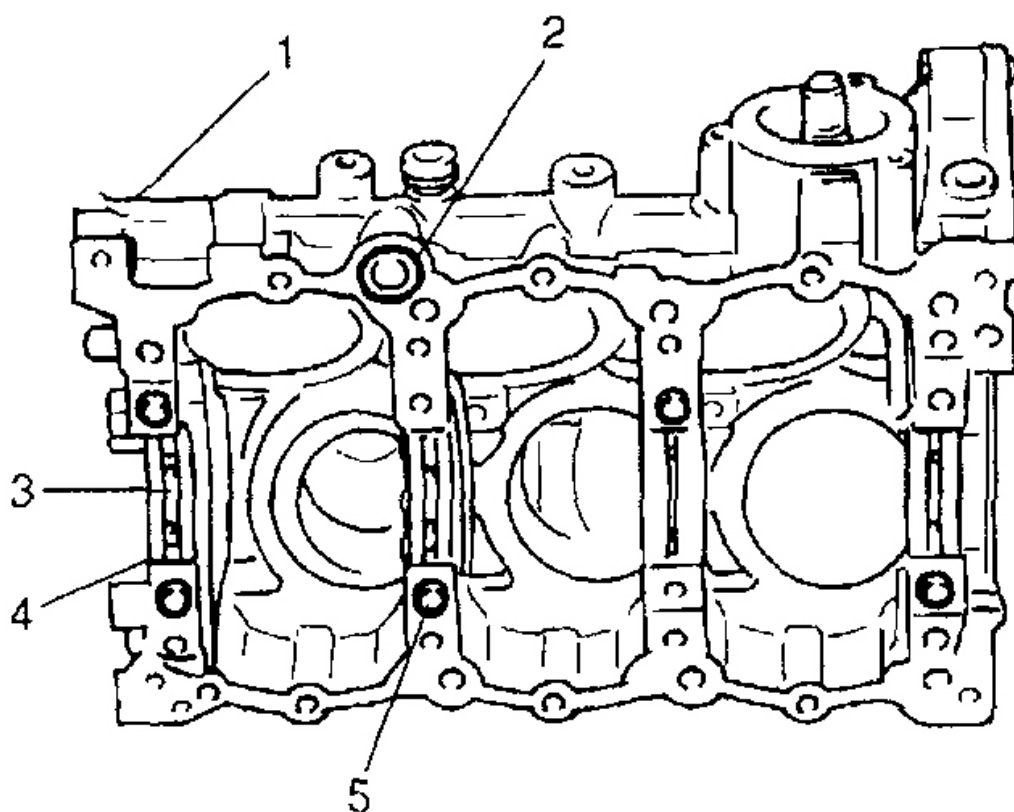
- **Journal bearings, crankcase (bearings caps), connecting rods, rod bearings, rod bearing caps, pistons and piston rings are in combination sets. Do not disturb combination and try to see that each part goes back to where it came from, when installing.**
- **Clean mating surface of cylinder block and crankcase, remove oil, old sealant and dust from mating surface.**

1. Fit main bearings (4) to cylinder block (1).

One of two halves of main bearing, has oil groove (3). Install this half with oil groove to cylinder block, and another half without oil groove to crankcase.

Make sure that two halves are painted in the same color.

2. Install O-ring (2) to cylinder block.

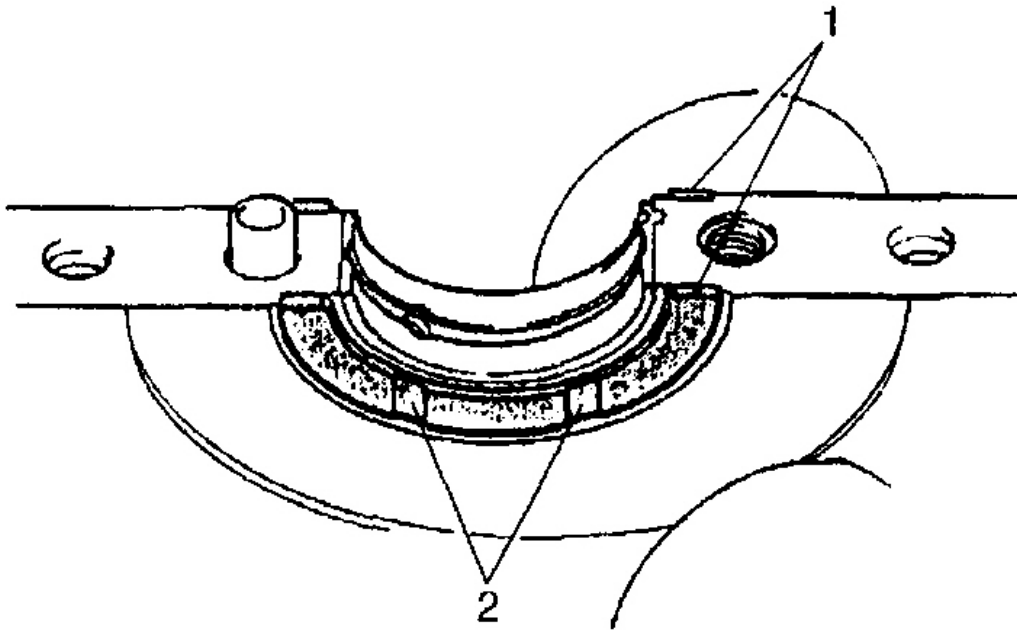


5. Knock pin

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Fig. 214: Fitting Main Bearings & O-Ring To Cylinder Block
Courtesy of SUZUKI OF AMERICA CORP.

3. Fit thrust bearings (1) to cylinder block between No. 2 and No. 3 cylinders. Face oil groove (2) sides to crank webs.

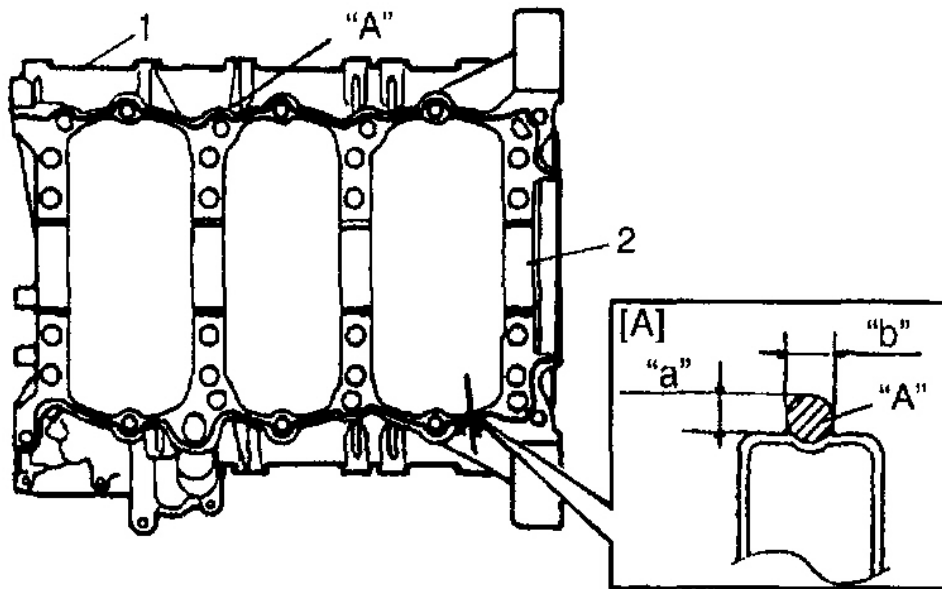


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Fig. 215: Fitting Thrust Bearings To Cylinder Block
Courtesy of SUZUKI OF AMERICA CORP.

4. Put crankshaft to cylinder block.
5. Apply sealant "A" to crankcase mating surface area as shown in the figure.

"A": Water tight sealant 99000-31250



[A]: Sealant application amount	1. Lower crankcase
"a": 2 mm (0.08 in.)	2. Bearing
"b": 3 mm (0.12 in.)	

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Fig. 216: Applying Sealant To Crankcase Mating Surface Area
 Courtesy of SUZUKI OF AMERICA CORP.

6. Install crankcase to cylinder block. Apply oil to crankcase bolts before installing them. Tighten crankcase bolts gradually as follows.
 - A. Tighten crankcase bolts (10 mm (0.39 in.) thread diameter) to 42 N. m (4.2 kg-m, 30.5 lb-ft) according to numerical order in figure.
 - B. Loosen all bolts until tightening torque is reduced to 0 in reverse order of tightening.
 - C. In the same manner as Step A , tighten them to 42 N. m (4.2 kg-m, 30.5 lb-ft).
 - D. In the same manner as Step A again, tighten them to specified torque.
 - E. Tighten crankcase bolts (8 mm (0.31 in.) thread diameter) to specified torque.

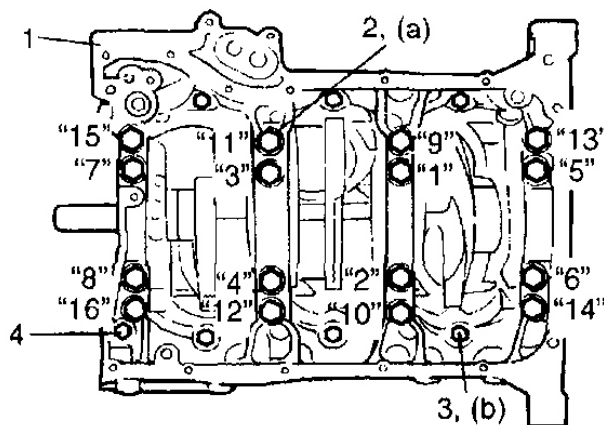
NOTE: Tighten 10 mm (0.39 in.) thread diameter bolts first (the following the order shown in figure), then tighten 8 mm (0.31 in.) thread diameter bolts.

Tightening torque

Crankcase bolt (a): Tighten 42 N. m (4.2 kg-m, 30.5 lb-ft), 0 N. m (0 kg-m, 0 lb-ft), 42 N. m (4.2 kg-m, 30.5 lb-ft) and 60 N. m (6.0 kg-m, 43.5 lb-ft) by the specified procedure (10 mm (0.39 in.) thread diameter)

Crankcase bolt (b): Tighten 27 N. m (2.7 kg-m, 19.5 lb-ft) by the specified procedure (8 mm (0.31 in.) thread diameter)

NOTE: After tightening crankcase bolts, check to be sure that crankshaft rotates smoothly when turned by hand.



1. Lower crankcase	3. Bolt (8 mm (0.31 in.) thread diameter)
2. Bolt (10 mm (0.39 in.) thread diameter)	4. Long bolt (8 mm (0.31 in.) thread diameter)

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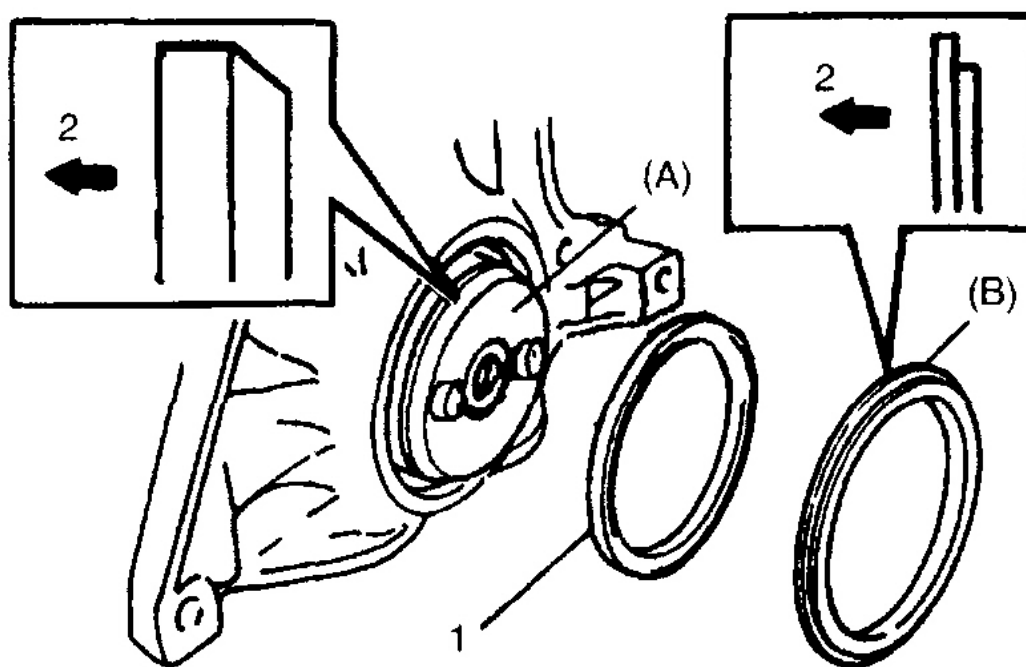
Fig. 217: Identifying Crankcase Bolts & Torque Sequence
Courtesy of SUZUKI OF AMERICA CORP.

- Using special tools (Oil seal installer and oil seal guide), install rear oil seal (1).

Special tool

(A): 09911-97710

(B): 09911-97811



2. Crankshaft side
3. Oil seal side

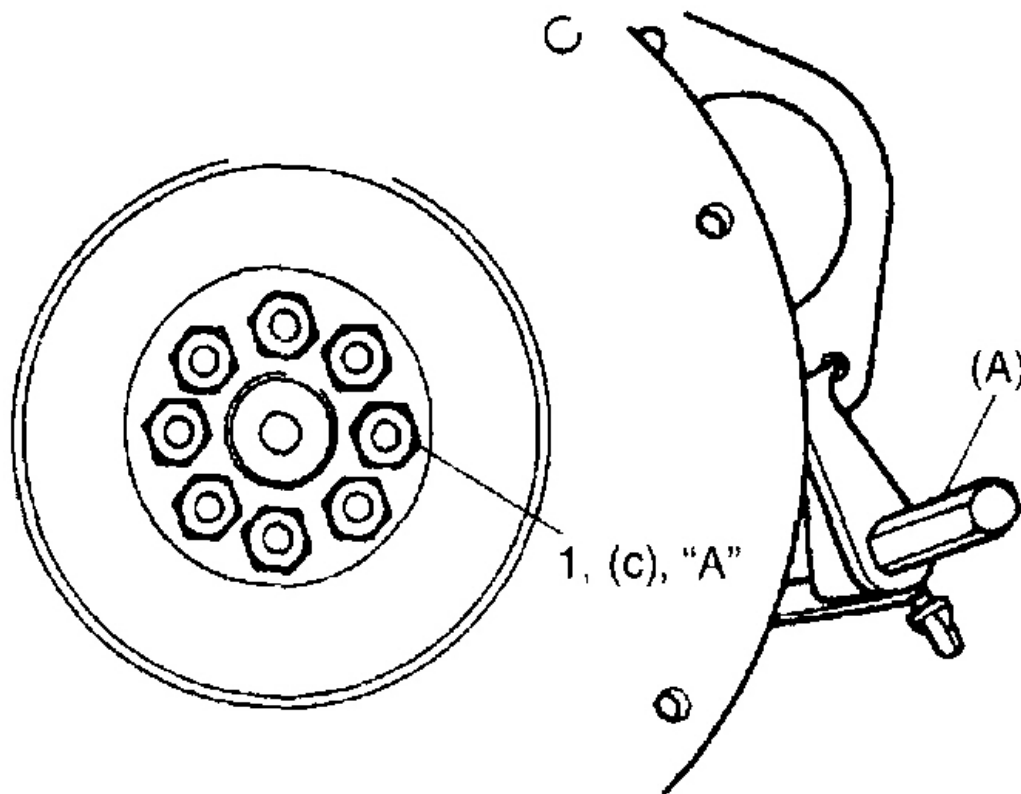
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Fig. 218: Installing Rear Oil Seal

Courtesy of SUZUKI OF AMERICA CORP.

8. Install flywheel (M/T vehicle) or drive plate (A/T vehicle). Using special tool, lock flywheel or drive plate, and tighten flywheel or drive plate bolts to specification.

"A": Sealant 99000-31110**Special tool****(A):** 09924-17811**Tightening torque****Flywheel (or drive plate) bolt (c):** 70 N.m (7.0 kg-m, 51.0 lb-ft)



1. Fly wheel bolt

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Fig. 219: Installing Flywheel (M/T) Or Drive Plate (A/T)
Courtesy of SUZUKI OF AMERICA CORP.

9. Install oil pump referring to **OIL PUMP REMOVAL & INSTALLATION**.
10. Install pistons and connecting rods referring to **PISTONS, PISTON RINGS, CONNECTING RODS & CYLINDERS REMOVAL & INSTALLATION**.
11. Install oil pump strainer and oil pan referring to **OIL PAN & OIL PUMP STRAINER REMOVAL & INSTALLATION**.
12. Install cylinder heads assembly to cylinder block referring to **VALVES & CYLINDER HEADS REMOVAL & INSTALLATION**.
13. Install oil pump chain referring to **OIL PUMP CHAIN REMOVAL & INSTALLATION**.

14. Install RH bank 2nd timing chain and tensioner referring to **RH (NO. 2) BANK 2ND TIMING CHAIN & CHAIN TENSIONER INSTALLATION** .
15. Install 1st timing chain and tensioner referring to **1ST TIMING CHAIN & CHAIN TENSIONER INSTALLATION** .
16. Install LH bank 2nd timing chain and tensioner referring to **LH (NO. 1) BANK 2ND TIMING CHAIN & CHAIN TENSIONER INSTALLATION** .
17. Install timing chain cover and crankshaft pulley referring to **TIMING CHAIN COVER REMOVAL & INSTALLATION** .
18. Install cylinder head covers referring to **CYLINDER HEAD COVERS REMOVAL & INSTALLATION** .
19. Install exhaust manifold referring to **EXHAUST MANIFOLD REMOVAL & INSTALLATION** .
20. Install intake manifold with throttle body. Refer to **THROTTLE BODY & INTAKE MANIFOLD REMOVAL & INSTALLATION (H25 ENGINE)** .
21. Install clutch to flywheel (for M/T vehicle). For clutch installation, refer to **CLUTCH COVER, CLUTCH DISC & FLYWHEEL REMOVAL & INSTALLATION** .
22. Install engine assembly to vehicle referring to **ENGINE ASSEMBLY REMOVAL & INSTALLATION** .

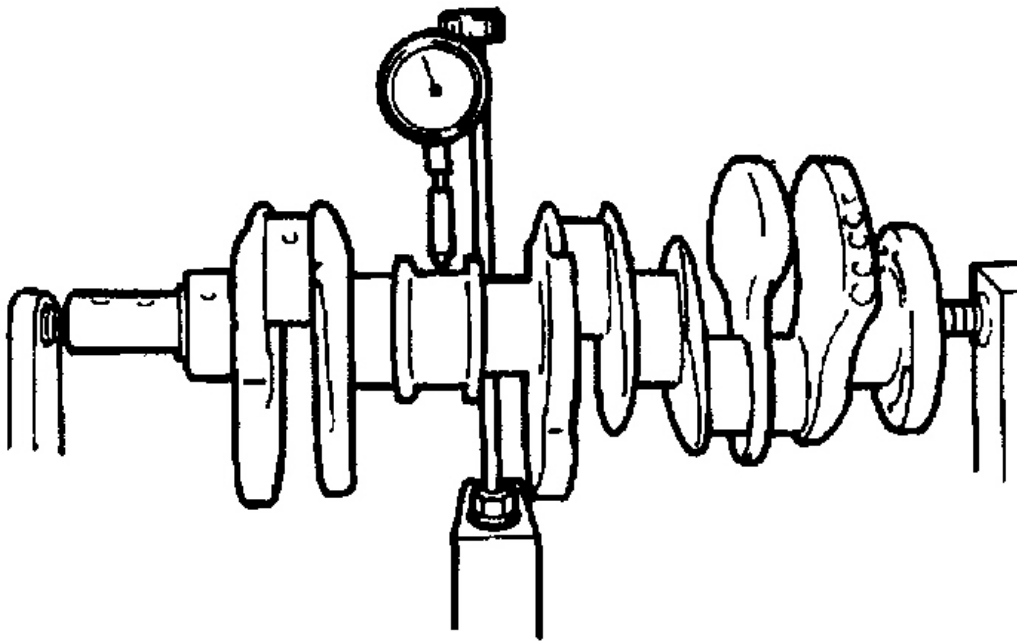
CRANKSHAFT INSPECTION

Crankshaft Runout

Using a dial gauge, measure runout at center journal. Rotate crankshaft slowly. If runout exceeds its limit, replace crankshaft.

Crankshaft runout

Limit: 0.06 mm (0.0023 in.)



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Fig. 220: Measuring Crankshaft Runout
Courtesy of SUZUKI OF AMERICA CORP.

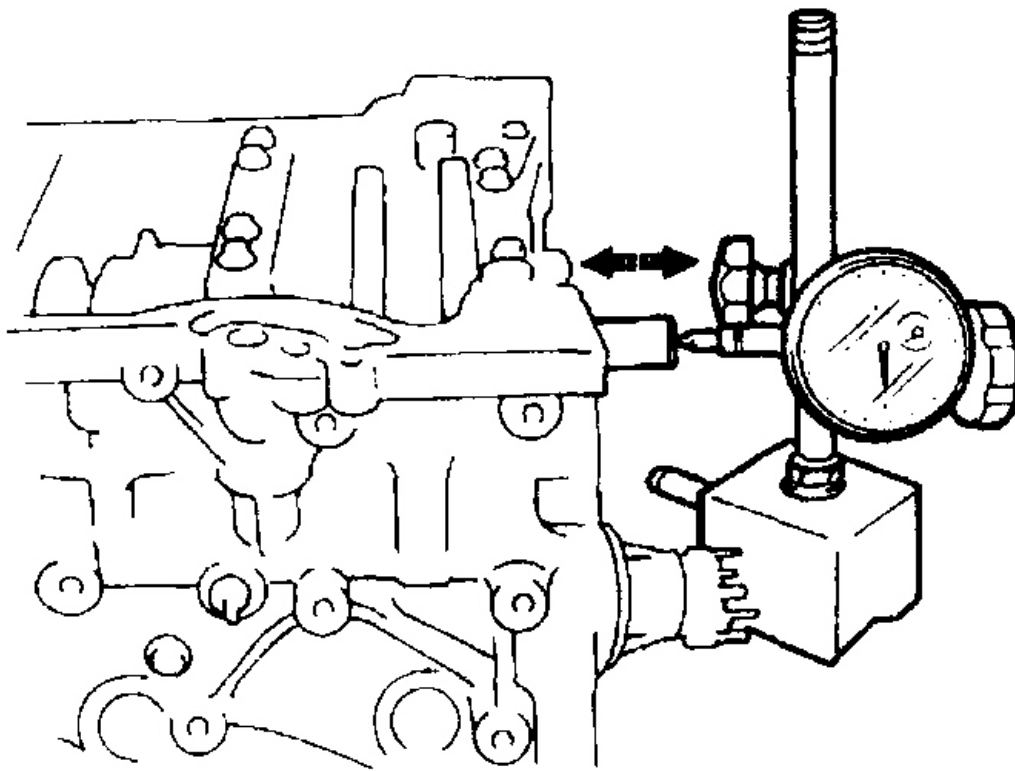
Crankshaft Thrust Play

Measure this play with crankshaft set in cylinder block in the normal manner, that is, with thrust bearing and journal bearing caps installed. Tighten crankcase bolts gradually as follows.

1. Tighten crankcase bolts (10 mm (0.39 in.) thread diameter) to 42 N. m (4.2 kg-m, 30.5 lb-ft) according to numerical order in figure.
2. Loosen all bolts until tightening torque is reduced to 0 in reverse order of tightening.
3. In the same manner as Step 1, tighten them to 42 N. m (4.2 kg-m, 30.5 lb-ft).
4. In the same manner as Step 1 again tighten them to specified torque.
5. Tighten crankcase bolts (8 mm (0.31 in.) thread diameter) to specified torque.

NOTE: Tighten 10 mm (0.394 in.) thread diameter bolts first (following the order shown in figure), then tighten 8 mm (0.315 in.) thread diameter bolts.

Tightening torque



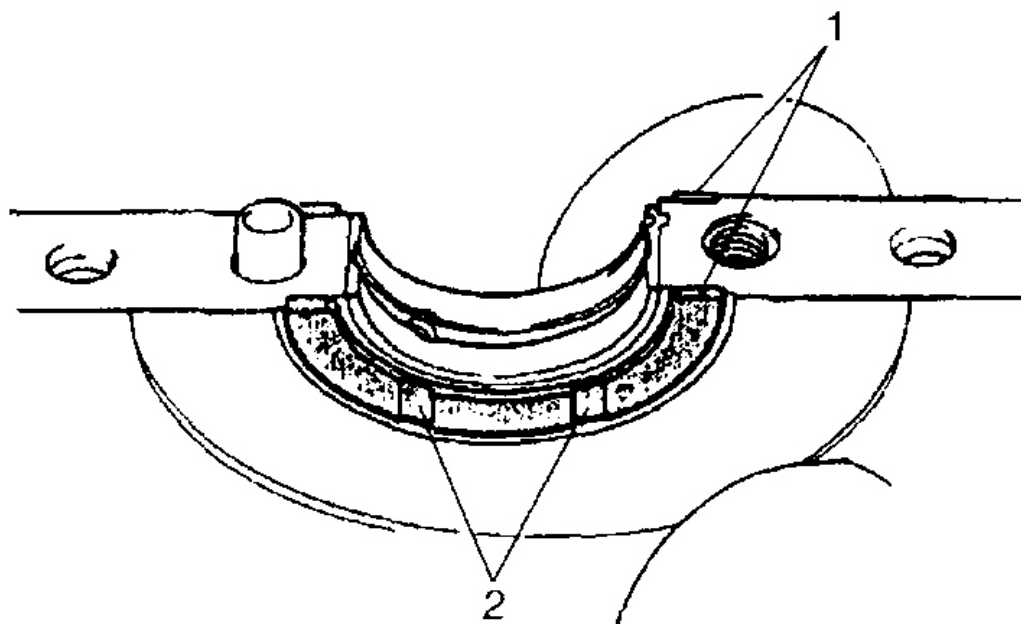
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Fig. 222: Measuring Crankshaft Thrust Play
Courtesy of SUZUKI OF AMERICA CORP.

Thickness of crankshaft thrust bearing

Standard: 2.500 mm (0.984 in.)

Oversize (0.125 mm (0.0049 in.)): 2.563 mm (0.1009 in.)



- | |
|-------------------|
| 1. Thrust bearing |
| 2. Oil groove |

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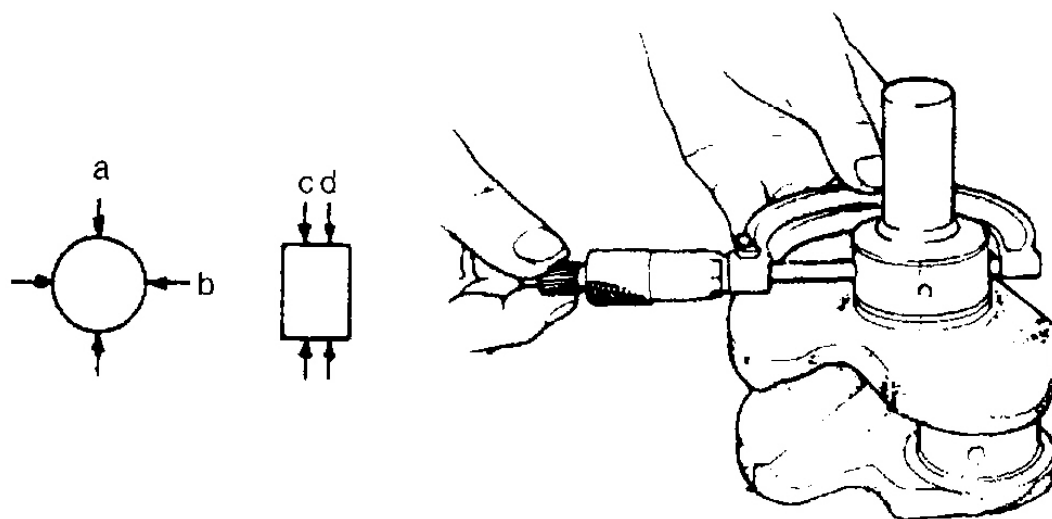
Fig. 223: Locating Crankshaft Thrust Bearing
Courtesy of SUZUKI OF AMERICA CORP.

Out-of-Round & Taper (Uneven Wear) of Journals

An unevenly worn crankshaft journal shows up as a difference in diameter at a cross section or along its length (or both). This difference, if any, is determined by taking micrometer readings. If any one of journals is badly damaged or if amount of uneven wear in the sense explained above exceeds its limit, regrind or replace crankshaft.

Crank journal out-of-round (a - b) and taper (c - d)

Limit: 0.01 mm (0.0004 in.)



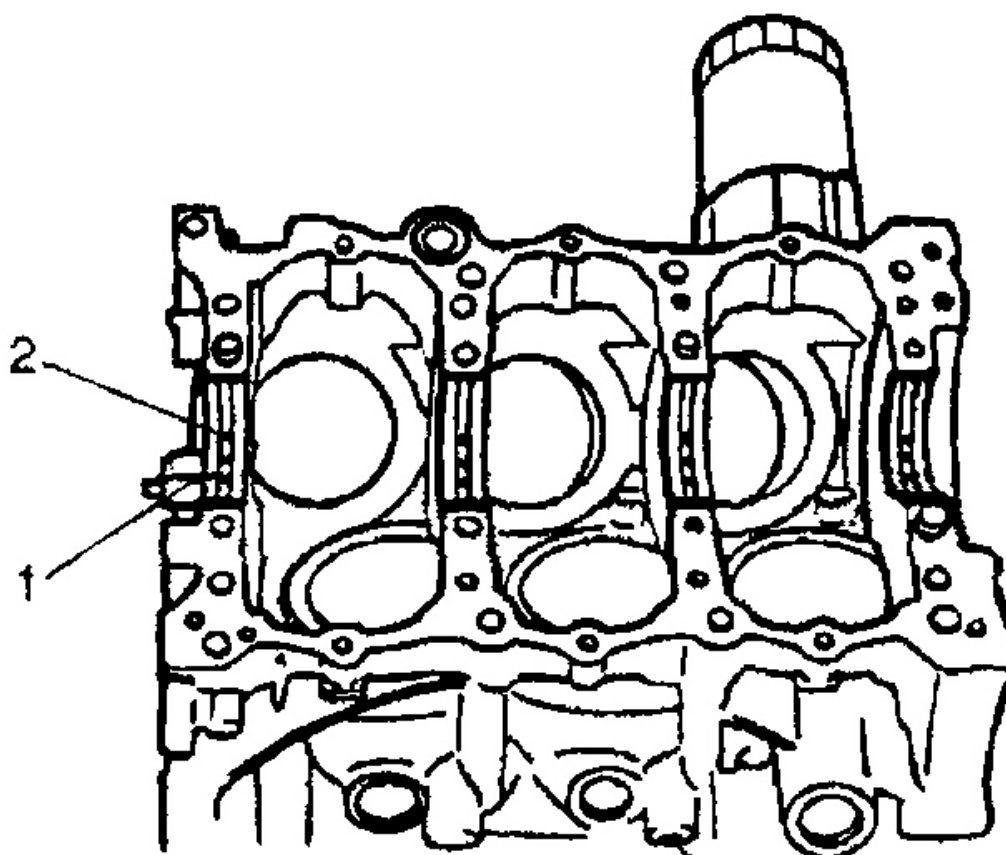
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Fig. 224: Measuring Crankshaft Journal Out-Of-Round & Taper
Courtesy of SUZUKI OF AMERICA CORP.

MAIN BEARINGS INSPECTION

NOTE: Before inspecting main bearings, note the following points.

- Service main bearings are available in standard size and 0.25 mm (0.0098 in.) undersize, and each of them has 5 kinds of bearings differing in tolerance.
- Upper half of bearing (1) has oil groove (2) as shown in the figure. Install this half with oil groove toward cylinder block.



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Fig. 225: Locating Upper Half Of Main Bearing Oil Groove
Courtesy of SUZUKI OF AMERICA CORP.

- Lower half of bearing does not have oil groove.

Visual Inspection

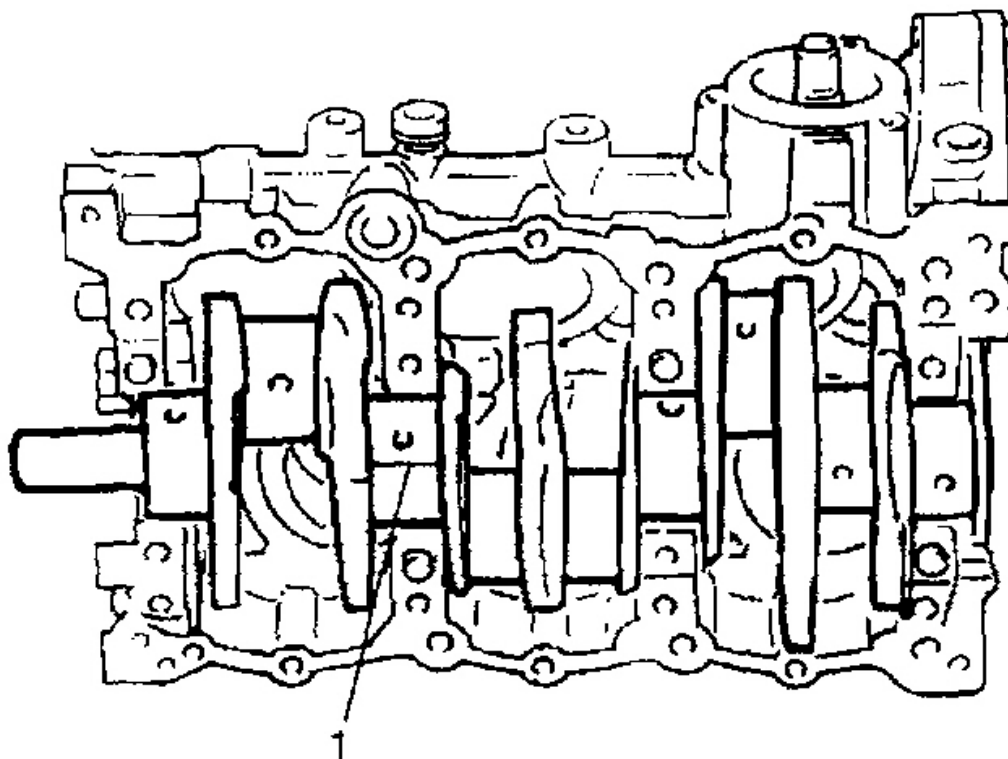
Check bearings for pitting, scratches, wear or damage.

If any malcondition is found, replace both upper and lower halves. Never replace either half without replacing the other half.

Main Bearing Clearance

Check clearance by using gauging plastic (1) according to the following procedure.

1. Remove crankcase.
2. Clean bearings and main journals.
3. Place a piece of gauging plastic (1) to full width of bearing (parallel to crankshaft) on journal, avoiding oil hole.



G02264093

Fig. 226: Placing A Piece Of Gauging Plastic On Crankshaft Journal
Courtesy of SUZUKI OF AMERICA CORP.

4. Install crankcase to cylinder block.

Tighten crankcase bolts, gradually as follows.

- A. Tighten crankcase bolts (10 mm (0.39 in.) thread diameter) to 42 N. m (4.2 kg-m, 30.5 lb-ft) according to numerical order in figure.
- B. Loosen all bolts until tightening torque is reduced to 0 in reverse order of tightening.
- C. In the same manner as Step A , tighten them to 42 N. m (4.2 kg-m, 30.5 lb-ft).

- D. In the same manner as Step A again, tighten them to specified torque.
- E. Tighten crankcase bolts (8 mm (0.31 in.) thread diameter) to specified torque.

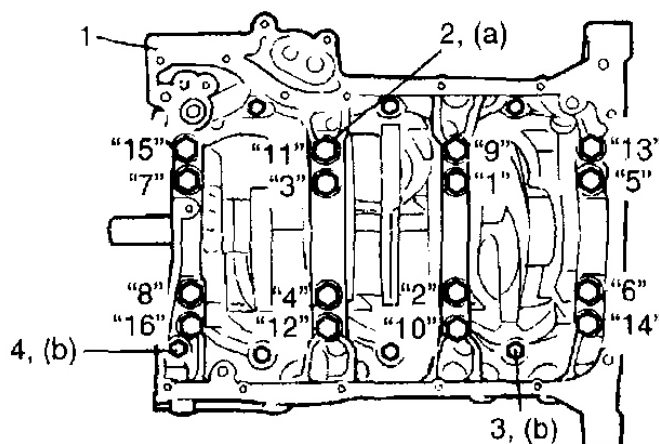
NOTE: Tighten 10 mm (0.394 in.) thread diameter bolts first (following the order shown in the figure) then tighten 8 mm (0.315 in.) thread diameter bolts.

Tightening torque

Crankcase bolt (a): Tighten 42 N. m (4.2 kg-m, 30.5 lb-ft), 0 N. m (0 kg-m, 0 lb-ft), 42 N. m (4.2 kg-m, 30.5 lb-ft) and 60 N. m (6.0 kg-m, 43.5 lb-ft) by the specified procedure (10 mm (0.39 in.) thread diameter)

Crankcase bolt (b): Tighten 27 N. m (2.7 kg-m, 19.5 lb-ft) by the specified procedure (8 mm (0.31 in.) thread diameter)

NOTE: Do not rotate crankshaft while gauging plastic is installed.



1. Lower crankcase	3. Bolt (8 mm (0.31 in.) thread diameter)
2. Bolt (10 mm (0.39 in.) thread diameter)	4. Long bolt (8 mm (0.31 in.) thread diameter)

G02264094

Fig. 227: Identifying Crankcase Bolts & Torque Sequence
Courtesy of SUZUKI OF AMERICA CORP.

- 5. Remove crankcase and using scale (2) on gauging plastic (1) envelop, measure gauging plastic (1) width at its widest point. If clearance exceeds its limit, replace bearing. Always replace both upper and lower

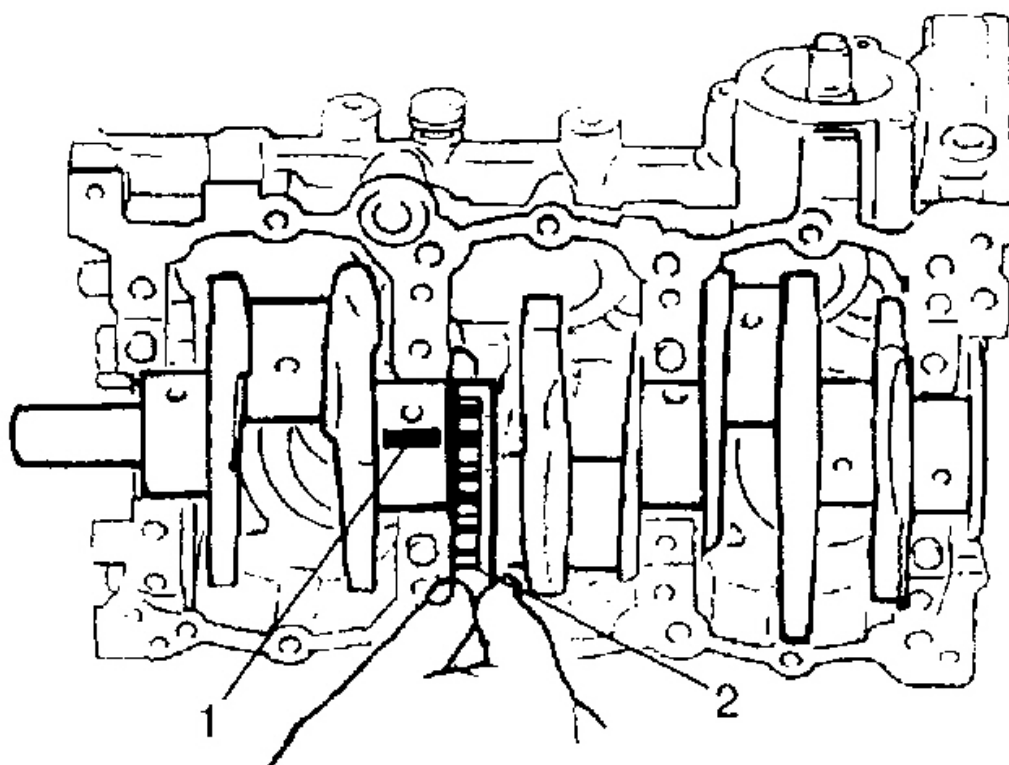
inserts as a unit. A new standard bearing may produce proper clearance. If not, it will be necessary to regrind crankshaft journal for use of 0.25 mm undersize bearing.

After selecting new bearing, recheck clearance.

Main bearing clearance

Standard: 0.024 - 0.044 mm (0.0010 - 0.0017 in.)

Limit: 0.060 mm (0.0023 in.)



G02264095

Fig. 228: Measuring Gauging Plastic
Courtesy of SUZUKI OF AMERICA CORP.

SELECTION OF MAIN BEARINGS

Standard bearing

If bearing is in malcondition, or bearing clearance is out of specification, select a new standard bearing according to the following procedure and install it.

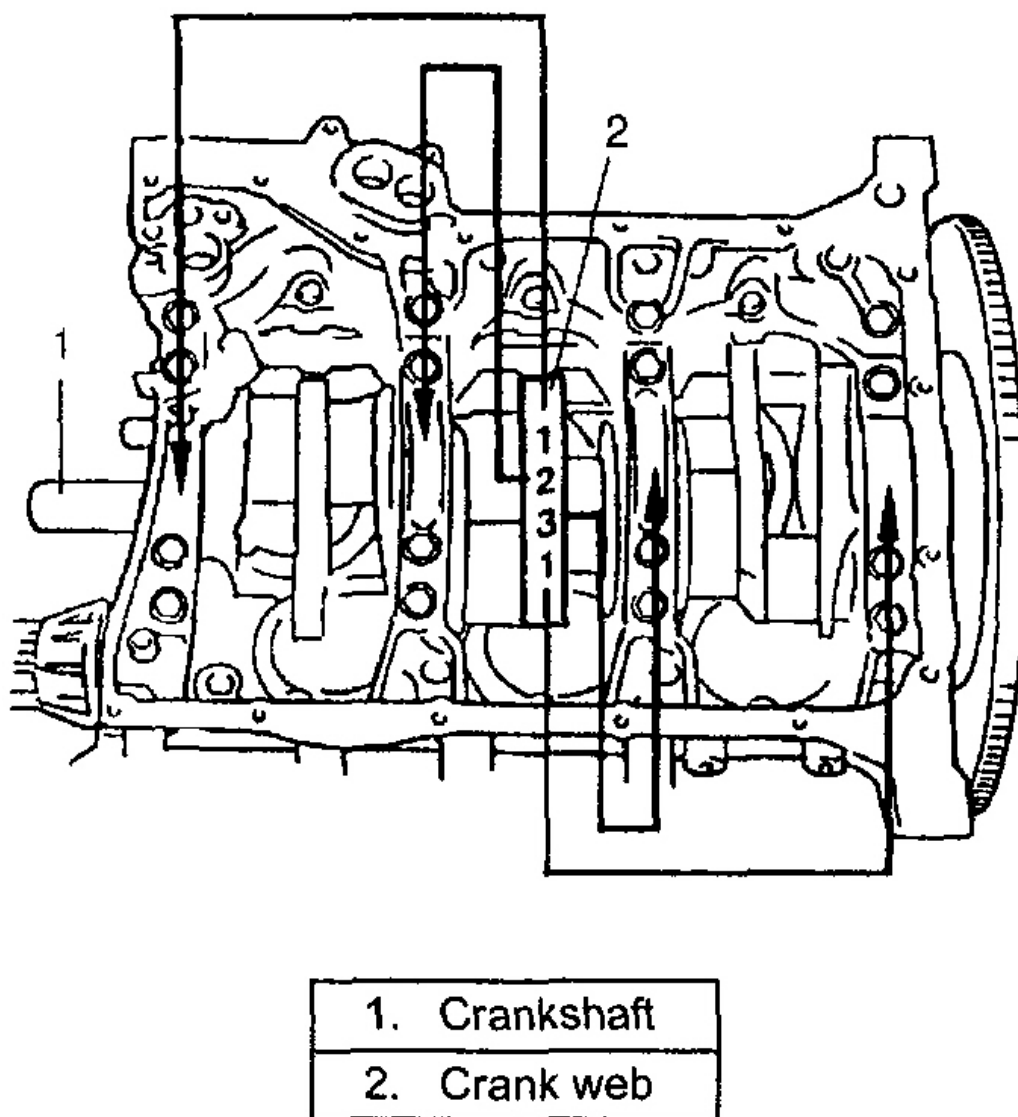
1. First check journal diameter. As shown in the figure, crank web has stamped numbers and alphabet at the center. Three kinds of numbers ("1", "2" and "3") represent the following journal diameters.

Journal diameter

Stamped numbers	Journal diameter
1	65.000 – 65.006 mm (2.5591 – 2.5593 in.)
2	64.994 – 65.000 mm (2.5588 – 2.5591 in.)
3	64.988 – 64.994 mm (2.5586 – 2.5588 in.)

G02264096

Fig. 229: Crank Main Journal Diameter Chart
Courtesy of SUZUKI OF AMERICA CORP.



G02264097

Fig. 230: Locating Crank Web Stamped Numbers
Courtesy of SUZUKI OF AMERICA CORP.

2. Next, check crankcase (bearing cap) bore diameter without bearing.

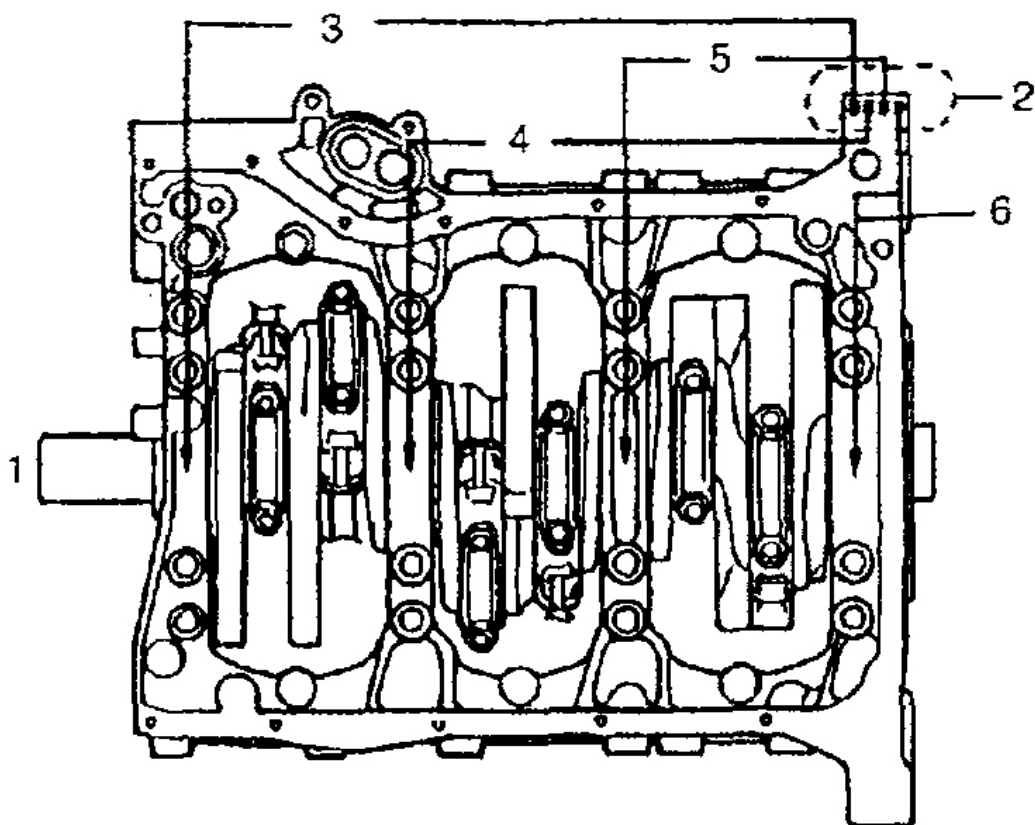
On lower surface of lower crankcase 4 alphabets are stamped as shown in the figure. Three kinds of alphabets (A, B and C) represent the following cap bore diameters.

Main bearing cap bore diameter

Stamped alphabet	Bearing cap bore diameter (without bearing)
A	70.000 – 70.006 mm (2.7559 – 2.7561 in.)
B	70.006 – 70.012 mm (2.7561 – 2.7564 in.)
C	70.012 – 70.018 mm (2.7564 – 2.7566 in.)

G02264098

Fig. 231: Main Bearing Cap Bore Diameter Chart
Courtesy of SUZUKI OF AMERICA CORP.



1. Crankshaft pulley side	4. No.2 bearing
2. Stamped alphabets	5. No.3 bearing
3. No.1 bearing	6. No.4 bearing

G02264099

Fig. 232: Locating Main Bearing Cap Bore Stamping
 Courtesy of SUZUKI OF AMERICA CORP.

- There are 5 kinds of standard bearings differing in thickness. To distinguish them, they are painted in the following colors at the position as indicated in the figure.

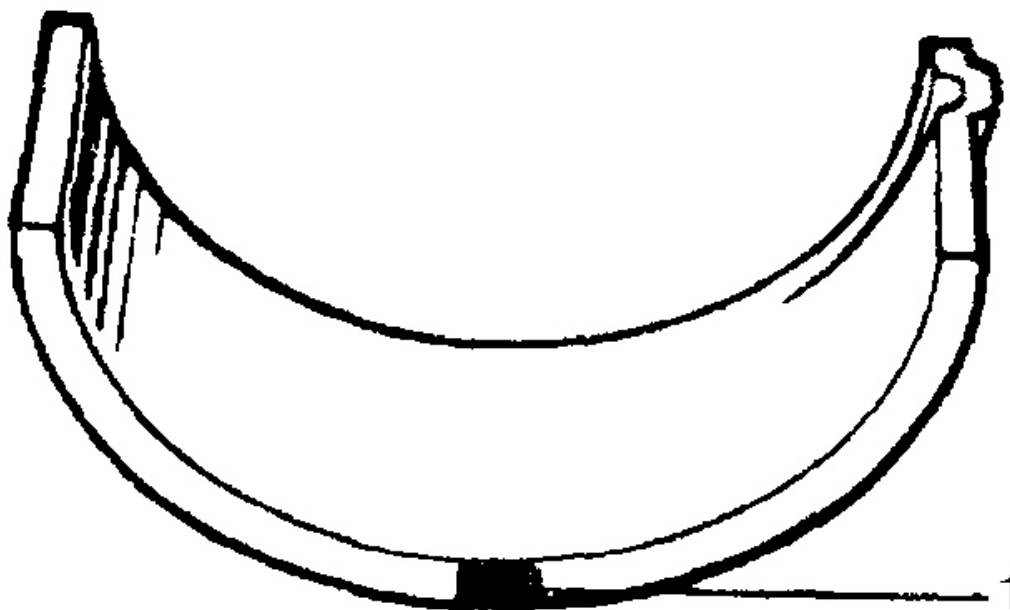
Each color indicates the following thickness at the center of bearing.

Standard size main bearing thickness

Color painted	Bearing thickness
Black	2.496 – 2.500 mm (0.0983 – 0.0984 in.)
Colorless (no paint)	2.499 – 2.503 mm (0.0984 – 0.0985 in.)
Yellow	2.502 – 2.506 mm (0.0985 – 0.0986 in.)
Blue	2.505 – 2.509 mm (0.0986 – 0.0987 in.)
Pink	2.508 – 2.512 mm (0.0987 – 0.0989 in.)

G02264100

Fig. 233: Standard Size Main Bearing Thickness Chart
Courtesy of SUZUKI OF AMERICA CORP.



1. Paint

G02264101

Fig. 234: Locating Main Bearing Paint Mark
Courtesy of SUZUKI OF AMERICA CORP.

4. From number stamped on crank webs at its center and alphabets stamped on crankcase lower side, determine new standard bearing to be installed to journal referring to the table shown below.

For example, if number stamped on crank webs is "1" and alphabet stamped on crankcase is "A", install a new standard bearing painted in "Black" to its journal.

		Number stamped on crank web (Journal diameter)		
		1	2	3
Alphabet stamped on lower crankcase (Cap bore diameter)	A	Black	Colorless	Yellow
	B	Colorless	Yellow	Blue
	C	Yellow	Blue	Pink

G02264102

Fig. 235: New Standard Size Main Bearing Specifications Table
Courtesy of SUZUKI OF AMERICA CORP.

5. Using gauging plastic, check bearing clearance with newly selected standard bearing. If clearance still exceeds its limit, use next thicker bearing and recheck clearance.
6. When replacing crankshaft or cylinder block and crankcase due to any reason, select new standard bearings to be installed by referring to number stamped on new crankshaft or alphabets stamped on new crankcase lower side.

Undersize bearing (0.25 mm (0.0098 in.))

0.25 mm (0.0098 in.) undersize bearing is available, in five kinds varying in thickness.

To distinguish them, each bearing is painted in following colors at such position as indicated in the figure.

Each color represents the following thickness at the center of bearing.

If necessary, regrind crankshaft journal and select undersize bearing to use with it as follows.

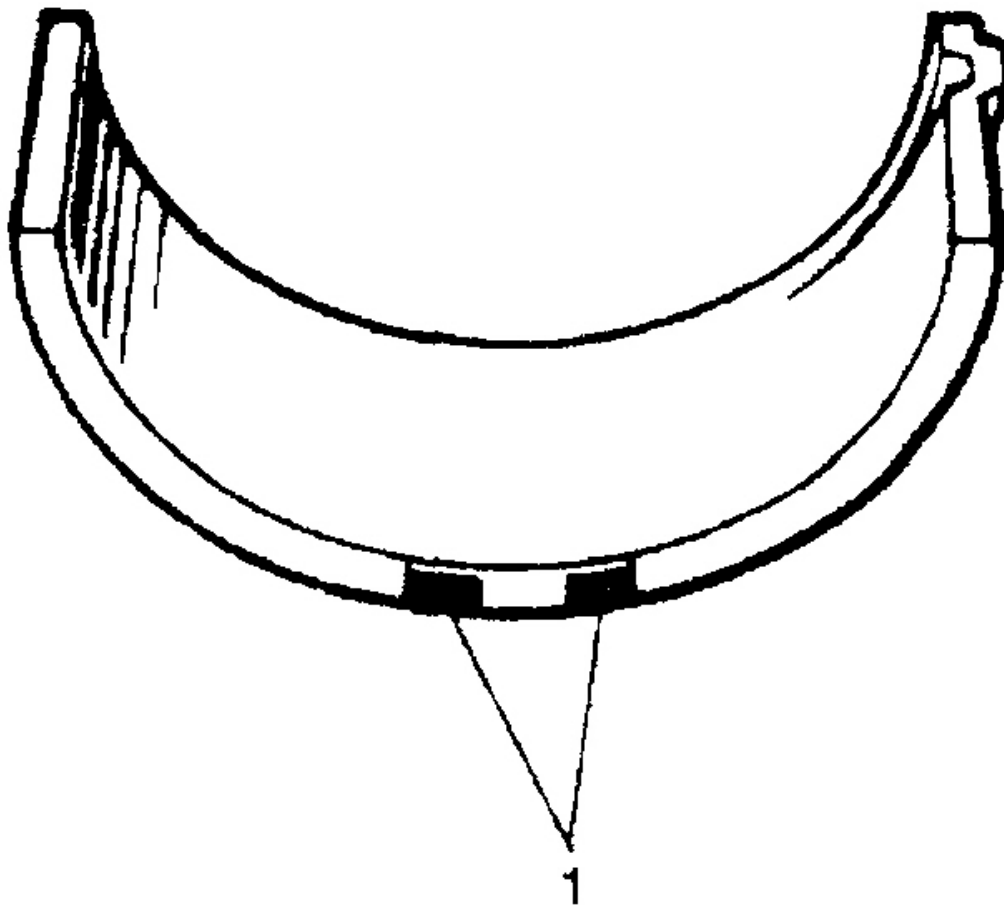
Undersize main bearing thickness

Color painted	Bearing thickness
Black & Red	2.621 – 2.625 mm (0.1032 – 0.1033 in.)
Red only	2.624 – 2.628 mm (0.1033 – 0.1034 in.)
Yellow & Red	2.627 – 2.631 mm (0.1034 – 0.1035 in.)
Blue & Red	2.630 – 2.634 mm (0.1035 – 0.1037 in.)
Pink & Red	2.633 – 2.637 mm (0.1037 – 0.1038 in.)

G02264103

Fig. 236: Undersize Main Bearing Thickness Chart

Courtesy of SUZUKI OF AMERICA CORP.



1. Paint

G02264104

Fig. 237: Locating Main Bearing Paint Mark
Courtesy of SUZUKI OF AMERICA CORP.

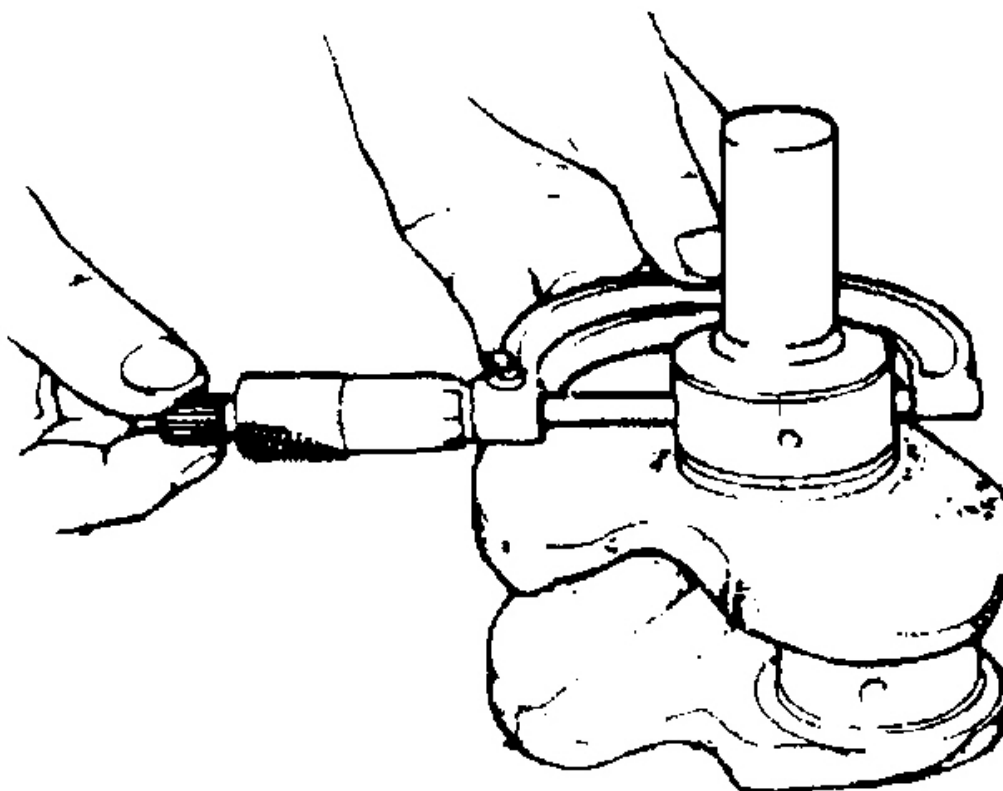
1. Regrind journal to the following finished diameter.

Finished journal diameter

Finished journal diameter: 64.738 - 64.756 mm (2.5487 - 2.5494 in.)

2. Using micrometer, measure reground journal diameter.

Measurement should be taken in two directions perpendicular to each other in order to check for out-of-round.



G02264105

Fig. 238: Measuring Reground Journal Diameter
Courtesy of SUZUKI OF AMERICA CORP.

3. Using journal diameter measured above and alphabets stamped on lower crankcase, select an undersize bearing referring to table given below.

Check bearing clearance with newly selected undersize bearing.

Undersize bearing specifications

		Measured journal diameter		
		64.750 – 64.756 mm (2.5492 – 2.5494 in.)	64.744 – 64.750 mm (2.5489 – 2.5492 in.)	64.738 – 64.744 mm (2.5487 – 2.5489 in.)
Alphabets stamped on lower crankcase	A	Black & Red	Red only	Yellow & Red
	B	Red only	Yellow & Red	Blue & Red
	C	Yellow & Red	Blue & Red	Pink & Red

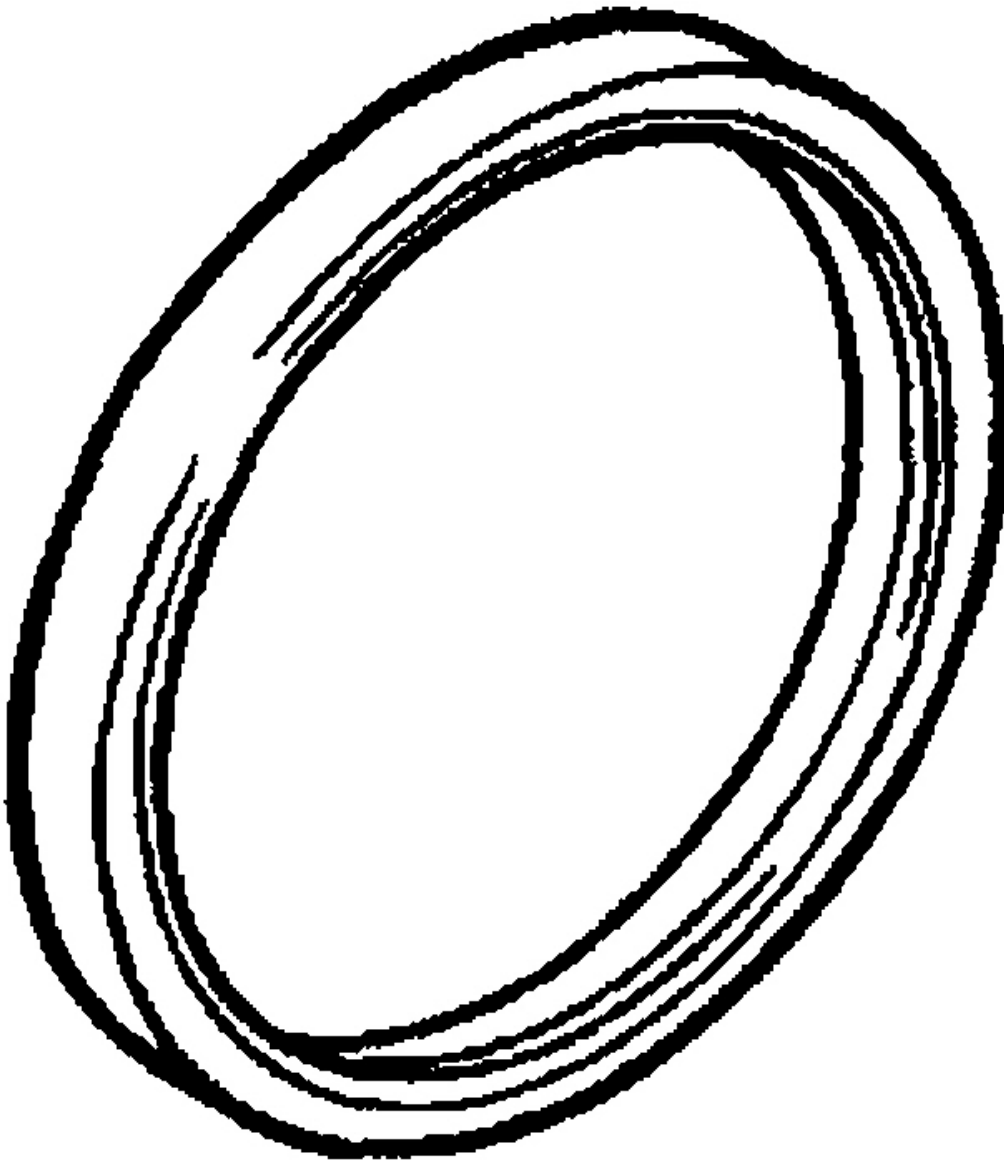
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Fig. 239: New Undersize Main Bearing Specifications Table
Courtesy of SUZUKI OF AMERICA CORP.

REAR OIL SEAL & FLYWHEEL INSPECTION

Rear Oil Seal

Carefully inspect oil seal for wear or damage. If lip portion is worn or damaged, replace oil seal.



G02264107

Fig. 240: Identifying Rear Oil Seal
Courtesy of SUZUKI OF AMERICA CORP.

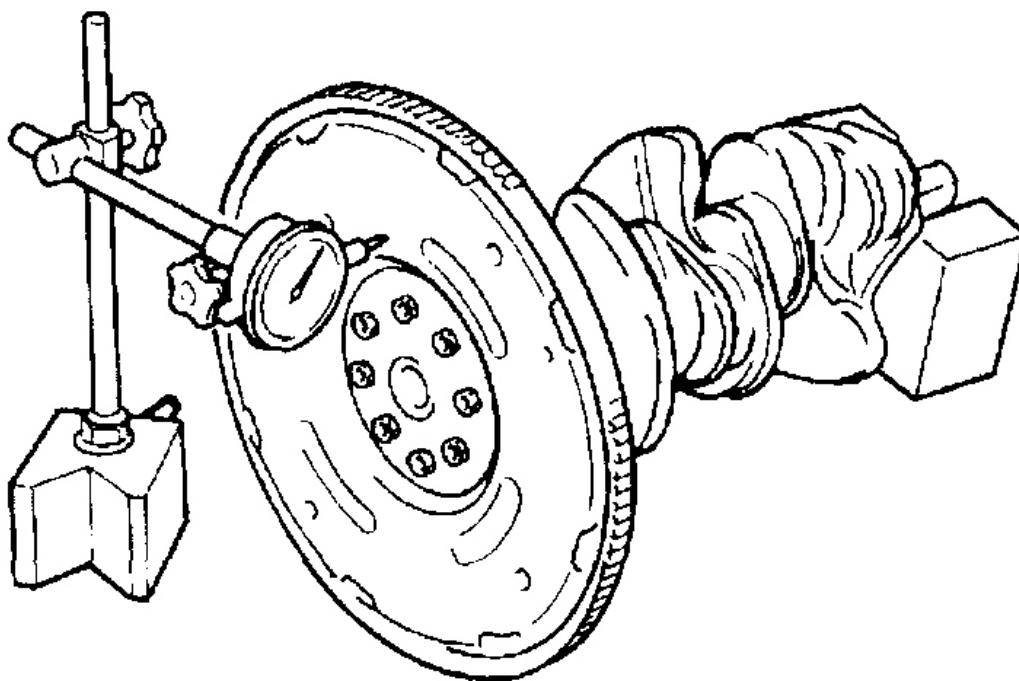
Flywheel

- If ring gear is damaged, cracked or worn, replace flywheel.

- If the surface contacting clutch disc is damaged, or excessively worn, replace flywheel.
- Check flywheel for face runout with a dial gauge. If runout exceeds its limit, replace flywheel.

Flywheel runout

Limit: 0.2 mm (0.0078 in.)



G02264108

Fig. 241: Checking Flywheel

Courtesy of SUZUKI OF AMERICA CORP.

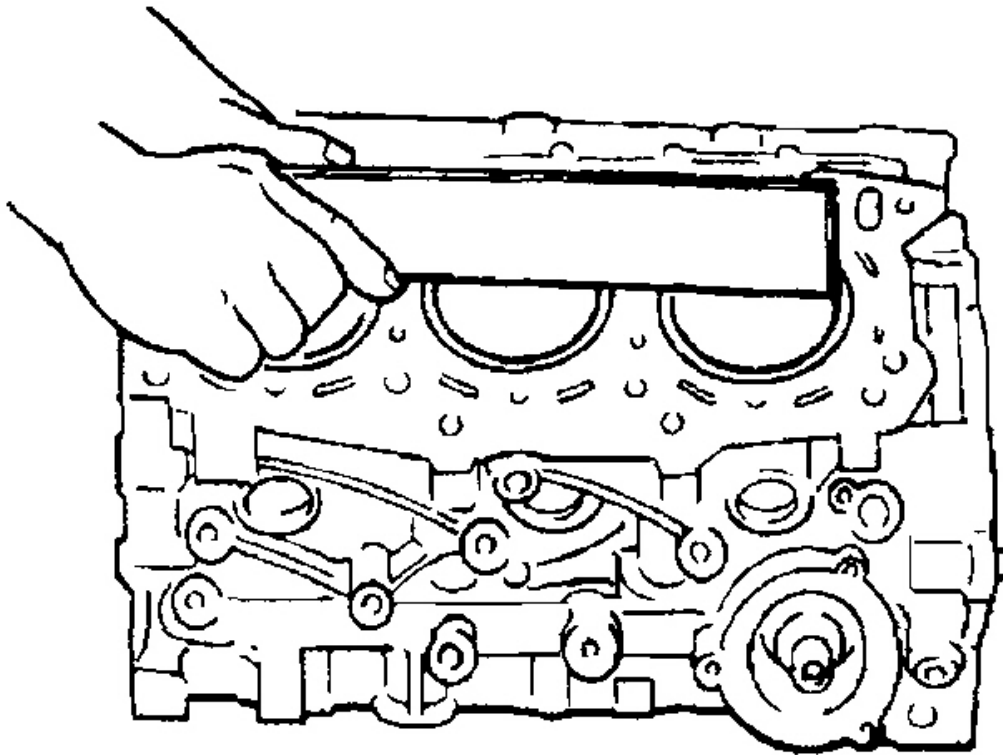
CYLINDER BLOCK INSPECTION

Distortion of Gasketed Surface

Using straightedge and thickness gauge, check gasketed surface for distortion. If flatness exceeds its limit, correct or replace it.

Gasketed surface flatness

Limit: 0.06 mm (0.0024 in.)



G02264109

Fig. 242: Checking Cylinder Block Gasketed Surface
 Courtesy of SUZUKI OF AMERICA CORP.

Honing Or Reboring Cylinders

1. When any cylinder needs reboring, all other cylinders must also be rebored at the same time.
2. Select oversized piston according to amount of cylinder wear.

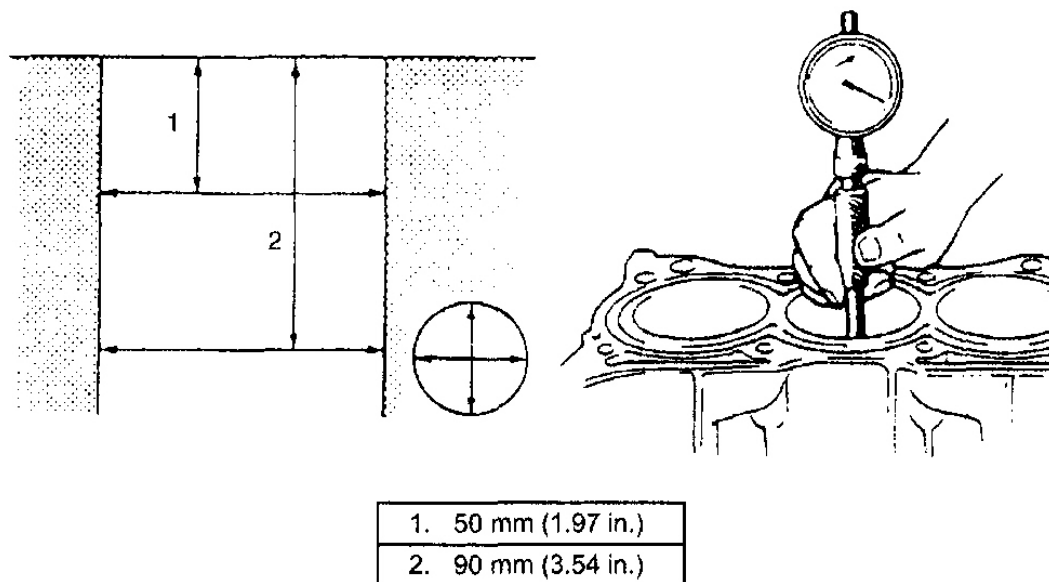
Oversize piston diameter specifications

Engine Type	Standard	Oversize 0.50
For H25 engine	83.970 – 83.990 mm (3.3059 – 3.3067 in.)	84.470 – 84.490 mm (3.3256 – 3.3264 in.)
For H27 engine	87.970 – 87.990 mm (3.4634 – 3.4642 in.)	88.470 – 88.490 mm (3.4831 – 3.4839 in.)

G02264110

Fig. 243: Oversize Piston Diameter Specifications Chart
 Courtesy of SUZUKI OF AMERICA CORP.

3. Using micrometer, measure piston diameter.



G02264111

Fig. 244: Measuring Cylinder Bore Diameter
Courtesy of SUZUKI OF AMERICA CORP.

4. Calculate cylinder bore diameter to be rebored as follows.

$$D = A + B - C$$

D: Cylinder bore diameter to be rebored

A: Piston diameter as measured

B: Piston clearance = 0.02 - 0.04 mm (0.0008 - 0.0015 in.)

C: Allowance for honing = 0.02 mm (0.0008 in.)

5. Rebore and hone cylinder to calculated dimension.

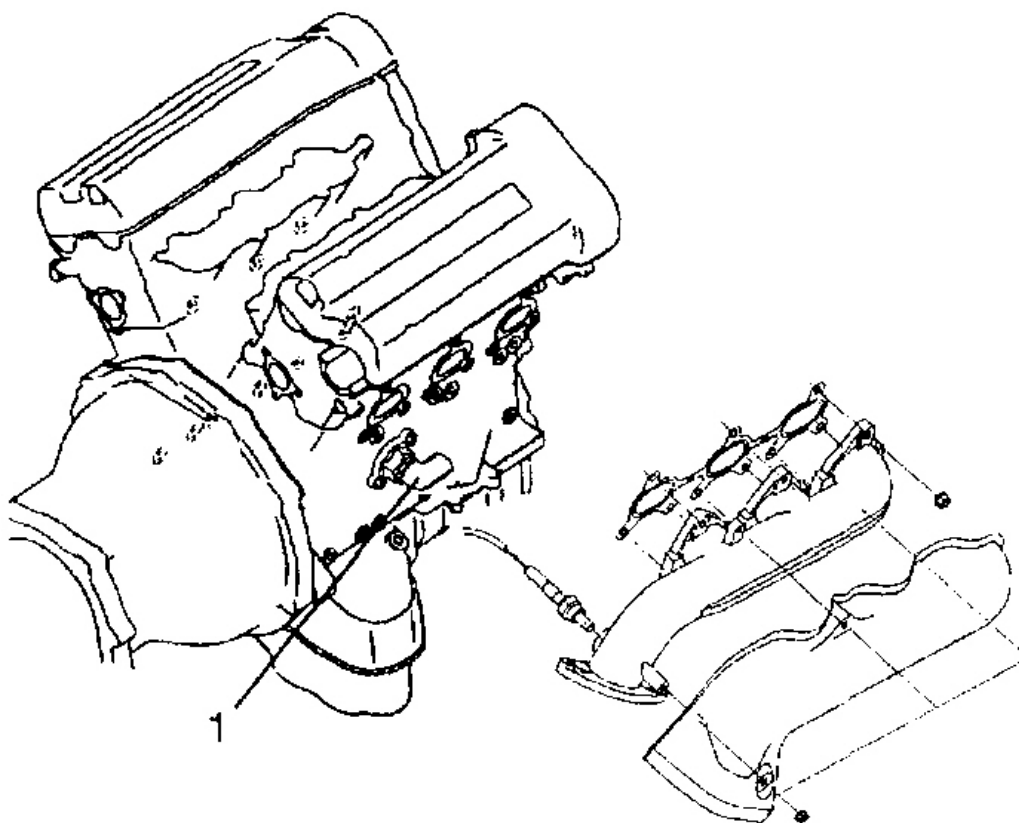
NOTE: Before reboring, install all main bearing caps in place and tighten to specification to avoid distortion of bearing bores.

6. Measure piston clearance after honing.

ENGINE BLOCK HEATER (IF EQUIPPED) REMOVAL & INSTALLATION

Removal

1. Disconnect negative (-) cable at battery.
2. Drain engine coolant referring to **COOLANT DRAINING**.
3. Remove strut tower bar, if equipped. Refer to **STRUT ASSEMBLY**.
4. Remove right side exhaust manifold. Refer to **EXHAUST MANIFOLD REMOVAL & INSTALLATION**.
5. Disconnect engine block heater and remove engine block heater (1).



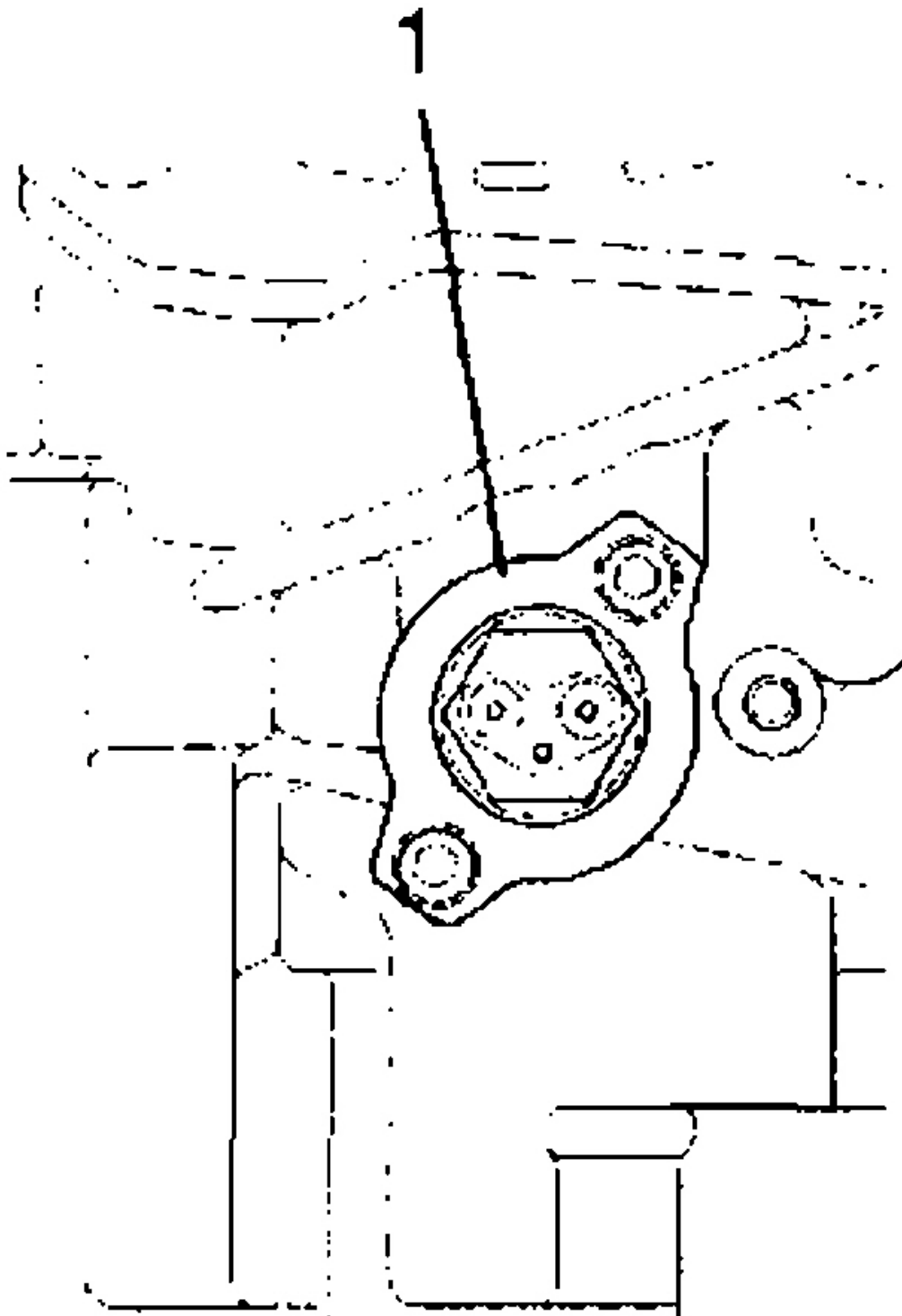
G02264112

Fig. 245: Removing Engine Block Heater
Courtesy of SUZUKI OF AMERICA CORP.

Installation

Reverse removal procedure for installation, noting the followings.

- Install engine block heater (1) in the direction as shown in the figure.



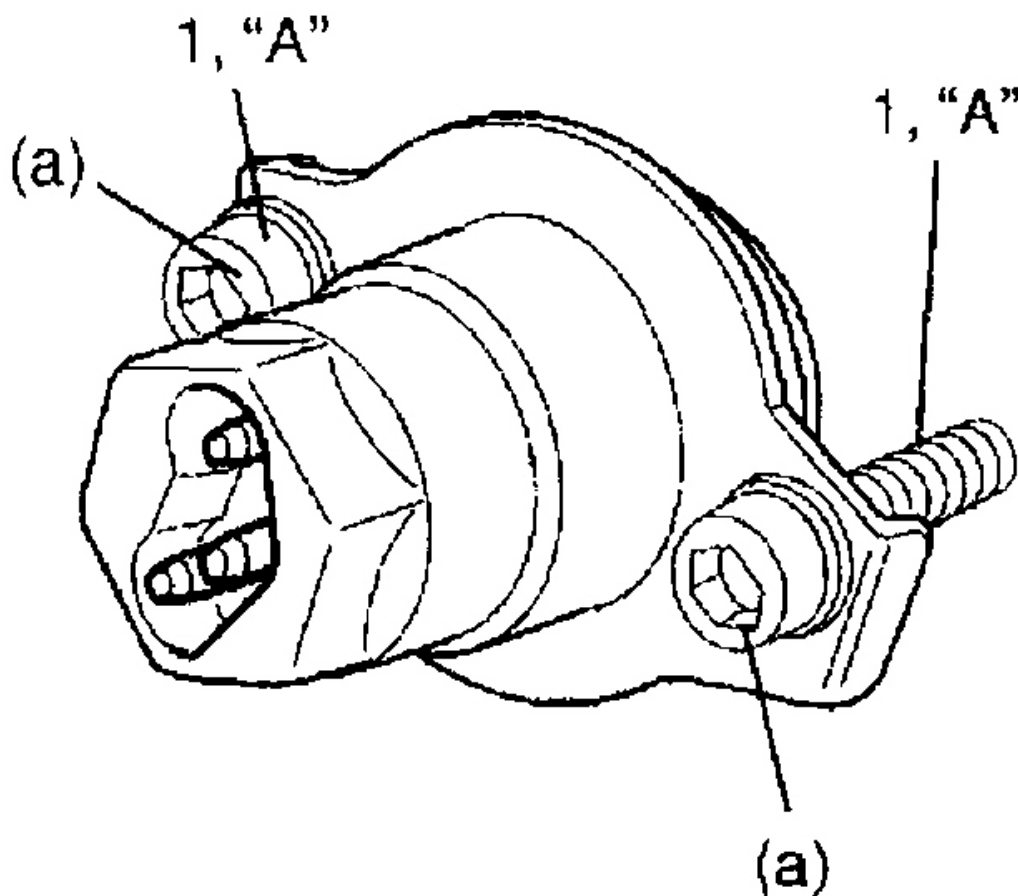
G02264113

Fig. 246: Installing Engine Block Heater
Courtesy of SUZUKI OF AMERICA CORP.

- Tighten engine block heater mounting bolt to specified torque.
 - A. Apply thread lock cement to block heater bolt (1).
- "A": Thread lock cement 99000-32020
- B. Tighten engine block heater mounting bolt to specified torque.

Tightening torque

Engine block heater mounting bolt (a): 11 N.m (1.1 kg-m, 8.0 lb-ft)



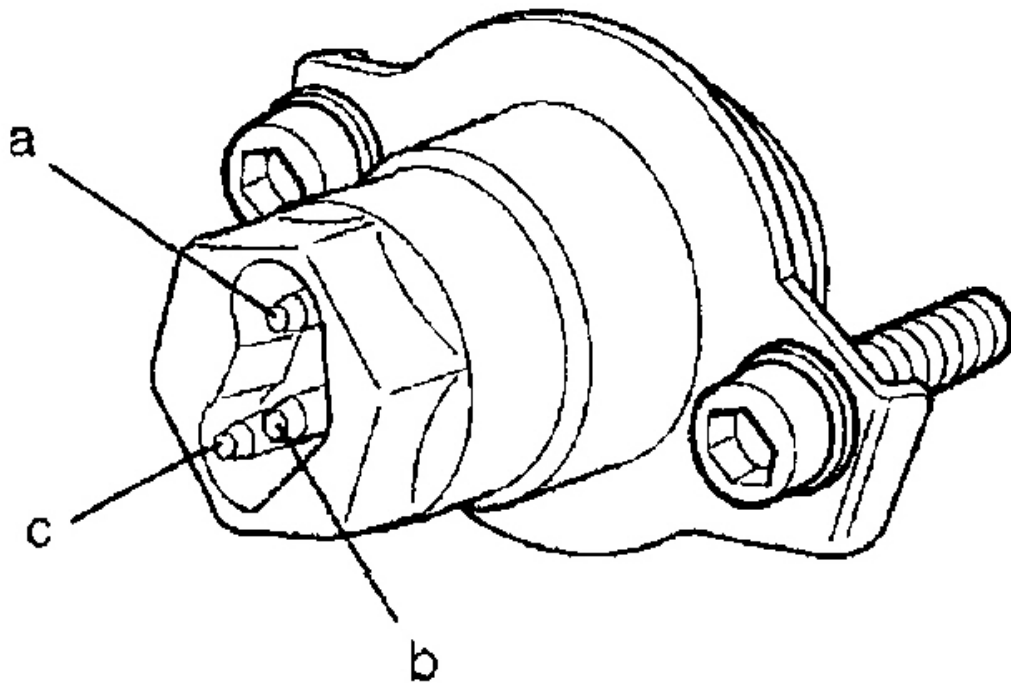
G02264114

Fig. 247: Installing Block Heater Bolts
Courtesy of SUZUKI OF AMERICA CORP.

- Use new exhaust manifold gasket.
- Tighten exhaust manifold mounting bolts and nuts to specified torque referring to **EXHAUST MANIFOLD REMOVAL & INSTALLATION** .
- Refill coolant referring to **COOLING SYSTEM FLUSH & REFILL** .
- Refill P/S fluid and bleed air in P/S system referring to **P/S SYSTEM AIR BLEEDING PROCEDURE** .
- Refill engine oil.
- Refill front differential gear oil referring to **FRONT DIFFERENTIAL GEAR OIL INSPECTION & CHANGE** .
- Finally, start engine and check for engine coolant leaks and exhaust gas leakage.

ENGINE BLOCK HEATER (IF EQUIPPED) INSPECTION

- Check continuity between terminal "a" and "c". If there is no continuity, replace it.
- Check that there is no continuity between terminal "a" or "b" and "c". If there is continuity, replace it.
- Check continuity between terminal "c" and engine block heater body. If there is no continuity, replace it.



G02264115

Fig. 248: Checking Engine Block Heater
Courtesy of SUZUKI OF AMERICA CORP.

SPECIFICATIONS

TIGHTENING TORQUE SPECIFICATIONS

2004 Suzuki Grand Vitara EX

2004 ENGINES 2.5L V6

Fastening part	Tightening torque			Note
	N·m	kg-m	lb-ft	
Strut tower bar mounting bolts	50	5.0	36.5	⌚ / ⌚ / ⌚ / ⌚
Cylinder head cover nut	10.5	1.1	7.5	⌚
Timing chain cover bolt	11	1.1	8.0	⌚
CKP sensor bolt	6	0.6	4.5	⌚
Crankshaft pulley bolt	150	15	108.5	⌚
Timing chain guide No.4 bolt	11	1.1	8.0	⌚
Camshaft timing sprocket bolt	80	8.0	58.0	⌚
Timing chain tensioner adjuster No.3 bolt	Tighten 11 N·m (1.1 kg-m, 7.5 lb-ft) by the specified procedure			⌚
Timing chain tensioner adjuster No.3 nut	Tighten 55 N·m (5.5 kg-m, 40.0 lb-ft) by the specified procedure			⌚
RH bank 1st timing chain intake camshaft sprocket bolt	80	8.0	58.0	⌚
Timing chain tensioner nut	27	2.7	19.5	⌚
Idler sprocket No.1 bolt	45	4.5	32.5	⌚
Timing chain tensioner adjuster No.1 bolt	11	1.1	8.0	⌚
Timing chain guide No.1 and No.2 bolt	9	0.9	6.5	⌚
Timing chain tensioner adjuster No.2 bolt	11	1.1	8.0	⌚
Camshaft housing bolt	Tighten 12 N·m (1.2 kg-m, 9.0 lb-ft) by the specified procedure			⌚ / ⌚
Timing chain guide No.3 bolt	11	1.1	8.0	⌚
Cylinder head bolt	Tighten 53 N·m (5.3 kg-m, 38.5 lb-ft), 84 N·m (8.4 kg-m, 61.0 lb-ft), 0 N·m (0 kg-m, 0 lb-ft), 53 N·m (5.3 kg-m, 38.5 lb-ft) and 105 N·m (10.5 kg-m, 76.0 lb-ft) by the specified procedure			⌚
Cylinder head bolt (hex hole bolt)	Tighten 11 N·m (1.1 kg-m, 7.5 lb-ft) by the specified procedure			⌚
Connecting rod bearing cap nut	45	4.5	32.5	⌚ / ⌚
Engine side mounting bracket nut	55	5.5	40.0	⌚
Transmission case bolt and nut	85	8.5	61.5	(for M/T vehicle) ⌚
Transmission case bolt and nut	80	8.0	58.0	(for A/T vehicle) ⌚
Torque converter bolt	65	6.5	47.0	⌚
Exhaust No.1 pipe bolt and nut	50	5.0	36.5	⌚
Crankcase bolt	Tighten 42 N·m (4.2 kg-m, 30.5 lb-ft), 0 N·m (0 kg-m, 0 lb-ft), 42 N·m (4.2 kg-m, 30.5 lb-ft) and 60 N·m (6.0 kg-m, 43.5 lb-ft) by the specified procedure			(10 mm (0.39 in.) thread diameter) ⌚ / ⌚ / ⌚
Crankcase bolt	Tighten 27 N·m (2.7 kg-m, 19.5 lb-ft) by the specified procedure			(8 mm (0.31 in.) thread diameter) ⌚ / ⌚ / ⌚
Flywheel (or drive plate) bolt	70	7.0	51.0	⌚
Engine block heater mounting bolt	11	1.1	8.0	⌚

G02264116

Fig. 249: Tightening Torque Specifications
Courtesy of SUZUKI OF AMERICA CORP.

NOTE: The specified tightening torque is also described in the following. **TIMING CHAIN COVER COMPONENTS** , **LH (NO. 1) BANK 2ND TIMING CHAIN & CHAIN TENSIONER COMPONENTS** , **1ST TIMING CHAIN & CHAIN TENSIONER COMPONENTS** , **RH (NO. 2) BANK 2ND TIMING CHAIN & CHAIN TENSIONER COMPONENTS** , **CAMSHAFTS & VALVE LASH ADJUSTERS COMPONENTS** , **VALVES & CYLINDER HEADS COMPONENTS** , **PISTONS, PISTON RINGS, CONNECTING RODS & CYLINDERS COMPONENTS** and **MAIN BEARINGS, CRANKSHAFT & CYLINDER BLOCK COMPONENTS** .

SPECIAL TOOLS & EQUIPMENT

RECOMMENDED SERVICE MATERIAL

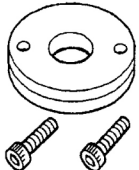
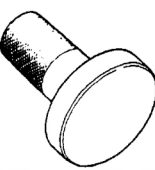
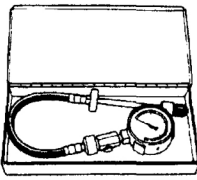
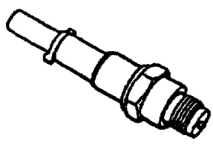
Material	SUZUKI Recommended Product		Note
Sealant	SUZUKI Bond No.1215	99000-31110	
Thread lock cement	Thread Lock Cement Super 1333B	99000-32020	
Water tight sealant	SUZUKI Bond No.1207B	99000-31140	
	SUZUKI Bond No.1207F	99000-31250	/ / / /

G02264117

Fig. 250: Recommended Service Material
 Courtesy of SUZUKI OF AMERICA CORP.

NOTE: Required service material is also described in the following: TIMING CHAIN COVER COMPONENTS , LH (NO. 1) BANK 2ND TIMING CHAIN & CHAIN TENSIONER COMPONENTS , 1ST TIMING CHAIN & CHAIN TENSIONER COMPONENTS , RH (NO. 2) BANK 2ND TIMING CHAIN & CHAIN TENSIONER COMPONENTS , CAMSHAFTS & VALVE LASH ADJUSTERS COMPONENTS , VALVES & CYLINDER HEADS COMPONENTS , PISTONS, PISTON RINGS, CONNECTING RODS & CYLINDERS COMPONENTS and MAIN BEARINGS, CRANKSHAFT & CYLINDER BLOCK COMPONENTS

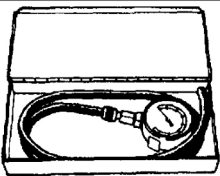
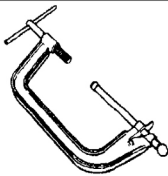
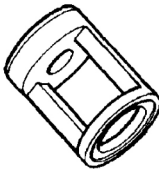
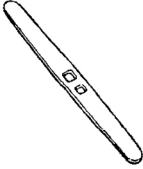
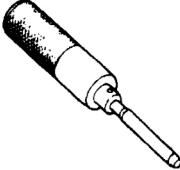
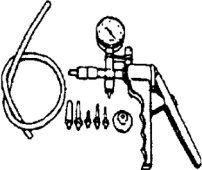
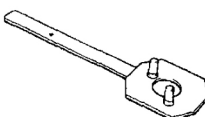
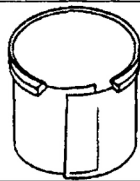
SPECIAL TOOL

09355-35754-600 Hose 	09367-04002 3-way joint 
09911-97710 Oil seal guide 	09911-97811 Oil seal installer 
09913-75510 Bearing installer 	09915-64510 Compression gauge set (0-20 kg/cm², M14) 
09915-64530 Compression gauge hose 	09915-67010 Compression gauge attachment (C) 

G02264118

Fig. 251: Special Tools (1 Of 3)

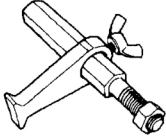
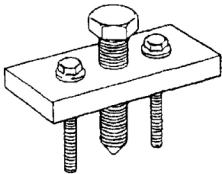
Courtesy of SUZUKI OF AMERICA CORP.

09915-67311 Vacuum gauge 	09916-14510 Valve lifter 
09916-14910 Valve spring compressor attachment 	09916-34542 Reamer handle 
09916-37810 Valve guide reamer (6 mm) 	09916-38210 Valve guide reamer (11 mm) 
09916-44910 Valve guide installer & remover 	09916-58210 Valve guide installer handle 
09916-77310 Piston ring compressor (50- 125 mm) 	09916-84511 Forceps 
09917-47011 Vacuum pump gauge 	09917-68221 Camshaft pulley holder 
09917-87810 Valve guide installer attachment (protrusion: 13.5 mm) 	09917-98221 Valve guide stem attachment 
09918-08210 Vacuum gauge hose joint 	09919-28610 Protector sleeve 

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Fig. 252: Special Tools (2 Of 3)

Courtesy of SUZUKI OF AMERICA CORP.

09924-17811 Flywheel holder 	09926-58010 Bearing remover attachment 
09944-36011 Steering wheel remover 	

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Fig. 253: Special Tools (3 Of 3)
Courtesy of SUZUKI OF AMERICA CORP.