

2008 Subaru Impreza 2.5i

2008 ENGINE Mechanical (H4SO Engine) - Impreza

2008 ENGINE**Mechanical (H4SO Engine) - Impreza****GENERAL DESCRIPTION****SPECIFICATION****GENERAL SPECIFICATION**

Engine	Model		2.5 L	
	Cylinder arrangement		Horizontally opposed, liquid cooled, 4-cylinder, 4-stroke gasoline engine	
	Valve system mechanism		Belt driven Single overhead camshaft 4 valve/cylinder	
	Bore x Stroke mm (in)		99.5 x 79.0 (3.917 x 3.110)	
	Piston displacement cm ³ (cu in)		2,457 (150)	
	Compression ratio		10.0	
	Compression pressure (at 200 - 300 rpm) kPa (kg/cm ² , psi)		1,020 - 1,275 (10.4 - 13.0, 148 - 185)	
	Number of piston rings		Pressure ring: 2, Oil ring: 1	
	Intake valve timing	Constant	Open	BTDC 0°
			Close	ABDC 58°
		Low speed	Open	BTDC 0°
			Close	ABDC -10°
		High speed	Open	BTDC 14°
			Close	ABDC 62°
	Exhaust valve timing		Open	BBDC 30°
			Close	ATDC 14°
	Valve clearance mm (in)		Intake	0.20±0.04 (0.0079±0.0016)
			Exhaust	0.25±0.04 (0.0098±0.0016)
	Idling speed [at neutral position on MT, or "P" or "N" position on AT] rpm		MT	650±100 (No load) 850±100 (A/C ON)
			AT	700±100 (No load) 850±100 (A/C ON)
Ignition order			1 --> 3 --> 2 --> 4	
Ignition timing BTDC/rpm		MT	10°±8°/650	
		AT	15°±10°/700	

NOTE: US: Undersize OS: Oversize**BELT TENSION SPECIFICATION**

Belt tension		
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adjuster	Protrusion of adjuster rod			mm (in)	5.2 - 6.2 (0.205 - 0.244)	
Belt tensioner	Spacer O.D.			mm (in)	17.955 - 17.975 (0.7069 - 0.7077)	
	Tensioner bushing I.D.			mm (in)	18.00 - 18.08 (0.7087 - 0.7118)	
	Clearance between spacer and bushing	mm (in)	Standard	0.025 - 0.125 (0.0010 - 0.0049)		
	Side clearance of spacer	mm (in)	Standard	0.20 - 0.55 (0.0079 - 0.0217)		
Valve rocker arm	Clearance between shaft and arm	mm (in)	Standard	0.020 - 0.054 (0.0008 - 0.0021)		
Camshaft	Bending limit			mm (in)	0.025 (0.0010)	
	Thrust clearance			mm (in)	Standard 0.030 - 0.090 (0.0012 - 0.0035)	
	Cam lobe height	mm (in)	Intake	Constant	Standard	40.075 - 40.175 (1.5778 - 1.5817)
			Low speed	Standard	35.496 - 35.596 (1.3975 - 1.4014)	
			High speed	Standard	40.315 - 40.415 (1.5872 - 1.5911)	
		Exhaust		Standard	39.289 - 39.389 (1.5468 - 1.5507)	
	Camshaft journal O.D.			mm (in)	31.928 - 31.945 (1.2570 - 1.2577)	
	Camshaft journal hole I.D.			mm (in)	32.000 - 32.018 (1.2598 - 1.2605)	
	Oil clearance			mm (in)	Standard 0.055 - 0.090 (0.0022 - 0.0035)	
Cylinder head	Surface warpage limit (Mating surface with cylinder block)			mm (in)	0.035 (0.0014)	
	Grinding limit			mm (in)	0.1 (0.004)	
	Standard height			mm (in)	97.5 (3.84)	
Valve seat	Seating angle				90°	
	Contacting width	mm (in)	Intake	Standard	0.8 - 1.4 (0.03 - 0.055)	
			Exhaust	Standard	1.2 - 1.8 (0.047 - 0.071)	
Valve guide	Inside diameter			mm (in)	6.000 - 6.012 (0.2362 - 0.2367)	
	Protrusion above head	mm (in)	Intake	20.0 - 21.0 (0.787 - 0.827)		
			Exhaust	16.5-17.5 (0.650 - 0.689)		
Valve	Head edge thickness	mm (in)	Intake	Standard	0.8-1.2 (0.03 - 0.047)	
			Exhaust	Standard	1.0-1.4 (0.039 - 0.055)	
	Stem outer diameter	mm (in)	Intake	5.950 - 5.965 (0.2343 - 0.2348)		
			Exhaust	5.945 - 5.960 (0.2341 - 0.2346)		
	Valve stem gap	mm (in)	Standard	Intake	0.035 - 0.062 (0.0014 - 0.0024)	
				Exhaust	0.040 - 0.067 (0.0016 - 0.0026)	
	Overall length	mm (in)	Intake	120.6 (4.75)		
Exhaust			121.7 (4.79)			
Valve spring	Free length			mm (in)	55.2 (2.173)	
	Squareness			2.5°, 2.4 (0.094) or less		
	Tension/spring height	N (kgf, lb)/mm (in)	Set	235.3 - 270.7 (24 - 27.6, 52.9 - 60.8)/45.0 (1.772)		
			Lift	578.9 - 639.9 (59.1 - 65.3, 130.3 - 143.9)/34.7 (1.366)		

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Cylinder block	Surface warpage limit (mating with cylinder head)			mm (in)	0.025 (0.00098)		
	Grinding limit			mm (in)	0.1 (0.004)		
	Standard height			mm (in)	201.0 (7.91)		
	Cylinder inner diameter	mm (in)	Standard	A	99.505 - 99.515 (3.9175 - 3.9179)		
				B	99.495 - 99.505 (3.9171 - 3.9175)		
	Taper			mm (in)	Standard	0.015 (0.0006)	
	Out-of-roundness			mm (in)	Standard	0.010 (0.0004)	
	Piston clearance			mm (in)	Standard	-0.010 - 0.010 (-0.00039 - 0.00039)	
Cylinder inner diameter boring limit (diameter)				mm (in)	To 100.005 (3.9372)		
Piston	Outer diameter		mm (in)	Standard	A	99.505 - 99.515 (3.9175 - 3.9179)	
					B	99.495 - 99.505 (3.9171 - 3.9175)	
						0.25 (0.0098) OS	99.745 - 99.765 (3.9270 - 3.9278)
						0.50 (0.0197) OS	99.995 - 100.015 (3.9368 - 3.9376)
Piston pin	Clearance between piston and piston pin:			mm (in)	Standard	0.004 - 0.008 (0.0002 - 0.0003)	
	Degree of fit				Piston pin must be fitted into position with thumb at 20°C (68° F).		
Piston ring	Ring closed gap		mm (in)	Top ring	Standard	0.20 - 0.35 (0.0079 - 0.0138)	
				Second ring	Standard	0.37 - 0.52 (0.0144 - 0.0203)	
				Oil ring	Standard	0.20 - 0.50 (0.0079 - 0.0197)	
	Ring groove gap		mm (in)	Top ring	Standard	0.040 - 0.080 (0.0016 - 0.0031)	
				Second ring	Standard	0.030 - 0.070 (0.0012 - 0.0028)	
Connecting rod	Bend or twist per 100 mm (3.94 in) in length			mm (in)	Limit	0.10 (0.0039)	
	Thrust clearance			mm (in)	Standard	0.070 - 0.330 (0.0028 - 0.0130)	
Bearing of large end	Oil clearance			mm (in)	Standard	0.016 - 0.044 (0.00063 - 0.0017)	
	Bearing size (Thickness at center)		mm (in)	Standard		1.492 - 1.501 (0.0587 - 0.0591)	
				0.03 (0.0012) US		1.510 - 1.513 (0.0594 - 0.0596)	
				0.05 (0.0020) US		1.520 - 1.523 (0.0598 - 0.0600)	
				0.25 (0.0098) US		1.620 - 1.623 (0.0638 - 0.0639)	
Bushing of small end	Clearance between piston pin and bushing				mm (in)	Standard	0 - 0.022 (0 - 0.0009)
	Bend limit			mm (in)	0.035 (0.0014)		
	Crank pin	Out-of-roundness		mm (in)	0.003 (0.0001)		
		Cylindrically		mm (in)	0.004 (0.0002)		
		Grinding limit (dia.)		mm (in)	To 51.750 (2.0374)		
		Out-of-roundness		mm (in)	0.005 (0.0002)		

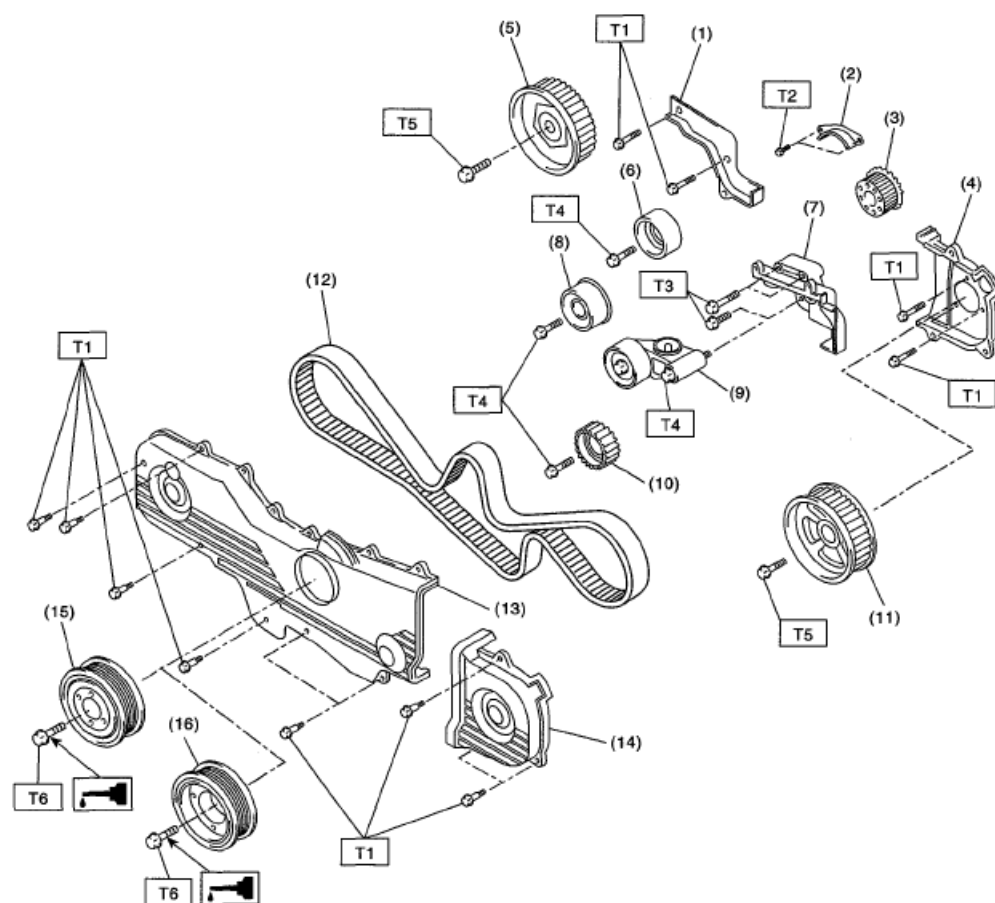
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Crankshaft	Crank journal		Cylindrically	mm (in)	0.006 (0.0002)
			Grinding limit (dia.)	mm (in)	To 59.758 (2.3527)
	Crank pin outer diameter	mm (in)	Standard	51.984 - 52.000 (2.0466 - 2.0472)	
			0.03 (0.0012) US	51.954 - 51.970 (2.0454 - 2.0461)	
			0.05 (0.0020) US	51.934 - 51.950 (2.0446 - 2.0453)	
			0.25 (0.0098) US	51.734 - 51.750 (2.0368 - 2.0374)	
	Crank journal outer diameter	mm (in)	Standard	59.992 - 60.008 (2.3619 - 2.3625)	
			0.03 (0.0012) US	59.962 - 59.978 (2.3607 - 2.3613)	
			0.05 (0.0020) US	59.942 - 59.958 (2.3599 - 2.3605)	
			0.25 (0.0098) US	59.742 - 59.758 (2.3520 - 2.3527)	
Thrust clearance		mm (in)	Standard	0.030 - 0.115 (0.0012 - 0.0045)	
Oil clearance		mm (in)	Standard	0.010 - 0.030 (0.0001 - 0.0012)	
Main bearing	Main bearing	mm (in)	#1, #3	Standard	1.998 - 2.011 (0.0787 - 0.0792)
				0.03 (0.0012) US	2.017 - 2.020 (0.0794 - 0.0795)
				0.05 (0.0020) US	2.027 - 2.030 (0.0798 - 0.0799)
				0.25 (0.0098) US	2.127 - 2.130 (0.0837 - 0.0839)
			#2, #4, #5	Standard	2.000 - 2.013 (0.0787 - 0.0793)
				0.03 (0.0012) US	2.019 - 2.022 (0.0795 - 0.0796)
				0.05 (0.0020) US	2.029 - 2.032 (0.0799 - 0.0800)
				0.25 (0.0098) US	2.129 - 2.132 (0.0838 - 0.0839)

COMPONENT

TIMING BELT



ME-03552

- | | |
|--|------------------------------|
| (1) Timing belt cover No. 2 RH | (10) Belt idler No. 2 |
| (2) Timing belt guide (MT model) | (11) Cam sprocket No. 2 |
| (3) Crank sprocket | (12) Timing belt |
| (4) Timing belt cover No. 2 LH | (13) Front timing belt cover |
| (5) Cam sprocket No. 1 | (14) Timing belt cover LH |
| (6) Belt idler (No. 1) | (15) Crank pulley (MT model) |
| (7) Tensioner bracket | (16) Crank pulley (AT model) |
| (8) Belt idler (No. 2) | |
| (9) Automatic belt tension adjuster ASSY | |

Tightening torque:N-m (kgf-m, ft-lb)

T1: 5 (0.5, 3.7)

T2: 9.75 (1.0, 7.2)

T3: 24.5 (2.5, 18.1)

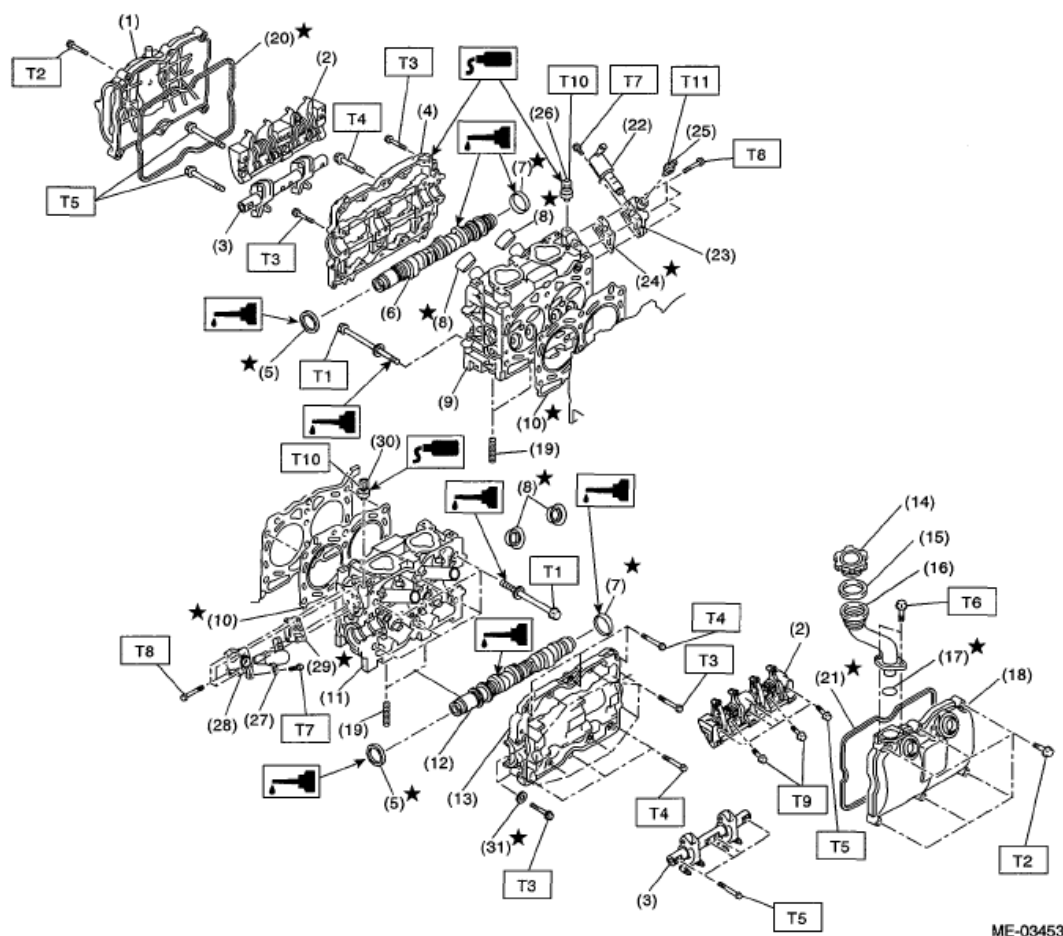
T4: 39 (4.0, 28.8)

T5: 78 (8.0, 57.5)

T6: <Ref. to ME(H4SO)-47, INSTALLATION, Crank Pulley.>

Fig. 1: Identifying Timing Belt Components With Torque Specifications
 Courtesy of SUBARU OF AMERICA, INC.

CYLINDER HEAD AND CAMSHAFT

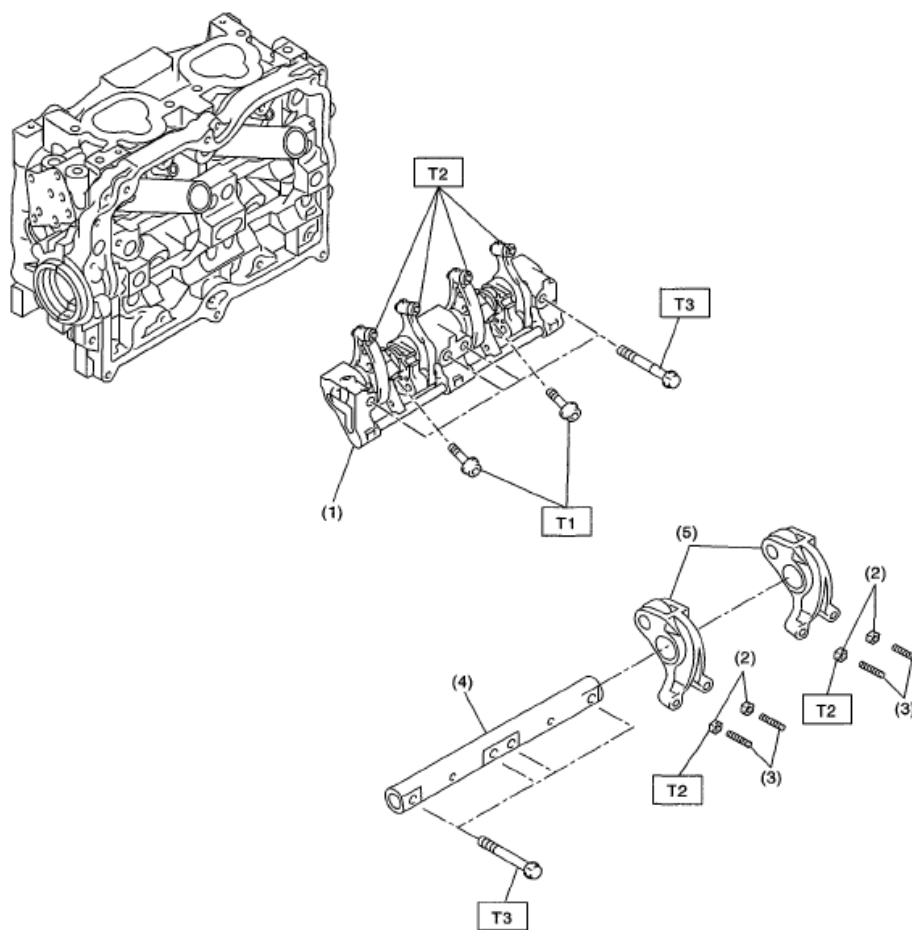


ME-03453

(1) Rocker cover RH	(18) Rocker cover LH	(31) Seal washer
(2) Intake valve rocker ASSY	(19) Stud bolt	
(3) Exhaust valve rocker ASSY	(20) Rocker cover gasket RH	Tightening torque:N-m (kgf-m, ft-lb)
(4) Camshaft cap RH	(21) Rocker cover gasket LH	T1: <Ref. to ME(H4SO)-65, INSTALLATION, Cylinder Head.>
(5) Oil seal	(22) Oil switching solenoid valve RH	T2: <Ref. to ME(H4SO)-57, INSTALLATION, Valve Rocker Assembly.>
(6) Camshaft RH	(23) Oil switching solenoid valve holder RH	
(7) Plug	(24) Gasket	T3: 9.75 (1.0, 7.2)
(8) Spark plug pipe gasket	(25) Oil temperature sensor	T4: 18 (1.8, 13.3)
(9) Cylinder head RH	(26) Variable valve lift diagnosis oil pressure switch RH	T5: 25 (2.5, 18.4)
(10) Cylinder head gasket	(27) Oil switching solenoid valve LH	T6: 6.4 (0.65, 4.7)
(11) Cylinder head LH	(28) Oil switching solenoid valve holder LH	T7: 8 (0.8, 5.9)
(12) Camshaft LH	(29) Gasket	T8: 10 (1.0, 7.4)
(13) Camshaft cap LH	(30) Variable valve lift diagnosis oil pressure switch LH	T9: 6 (0.6, 4.4)
(14) Oil filler cap		T10: 17 (1.7, 12.5)
(15) Gasket		T11: 18 (1.8, 13.3)
(16) Oil filler duct		
(17) O-ring		

Fig. 2: Identifying Cylinder Head And Camshaft Components With Torque Specifications
 Courtesy of SUBARU OF AMERICA, INC.

VALVE ROCKER ASSEMBLY



ME-02691

- | | |
|----------------------------------|------------------------------|
| (1) Intake valve rocker arm ASSY | (5) Exhaust valve rocker arm |
| (2) Valve rocker nut | |
| (3) Valve rocker adjusting screw | |
| (4) Exhaust rocker shaft | |

Tightening torque:N·m (kgf·m, ft·lb)

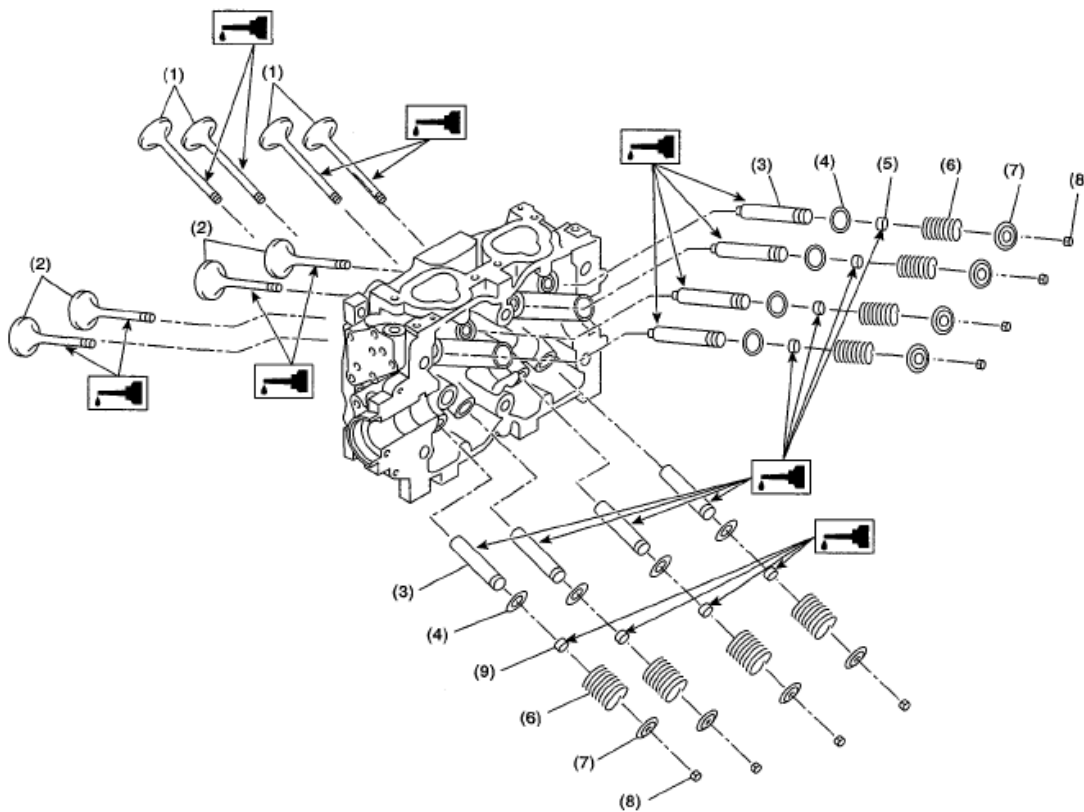
T1: 6 (0.6, 4.3)

T2: 9.75 (1.0, 7.2)

T3: 25 (2.5, 18.4)

Fig. 3: Identifying Valve Rocker Assembly Components With Torque Specifications
 Courtesy of SUBARU OF AMERICA, INC.

CYLINDER HEAD AND VALVE ASSEMBLY

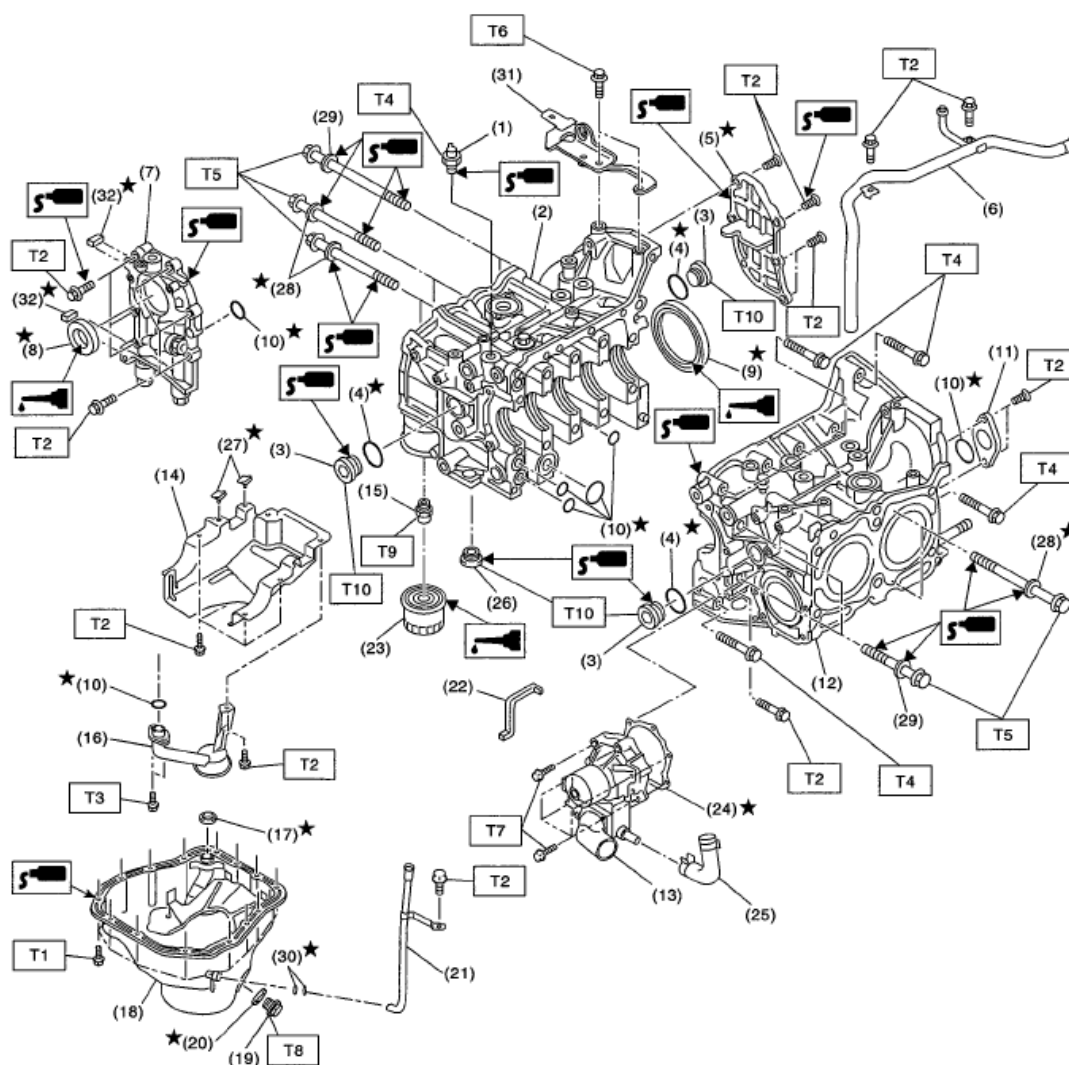


ME-03322

- | | | |
|-------------------|---------------------------|----------------------------|
| (1) Exhaust valve | (4) Valve spring seat | (7) Retainer |
| (2) Intake valve | (5) Intake valve oil seal | (8) Retainer key |
| (3) Valve guide | (6) Valve spring | (9) Exhaust valve oil seal |

Fig. 4: Identifying Cylinder Head And Valve Assembly Components
 Courtesy of SUBARU OF AMERICA, INC.

CYLINDER BLOCK



ME-03529

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

- (32) Oil pump seal

Tightening torque:N-m (kgf-m, ft-lb)

T1: 5 (0.5, 3.7)

T2: 6.4 (0.65, 4.7)

T3: 10 (1.0, 7.4)

T4: 25 (2.5, 18.4)

T5: <Ref. to ME(H4SO)-77, INSTALLATION, Cylinder Block.>

T6: 16 (1.6, 11.8)

T7: First 12 (1.2, 8.7)

Second 12 (1.2, 8.7)

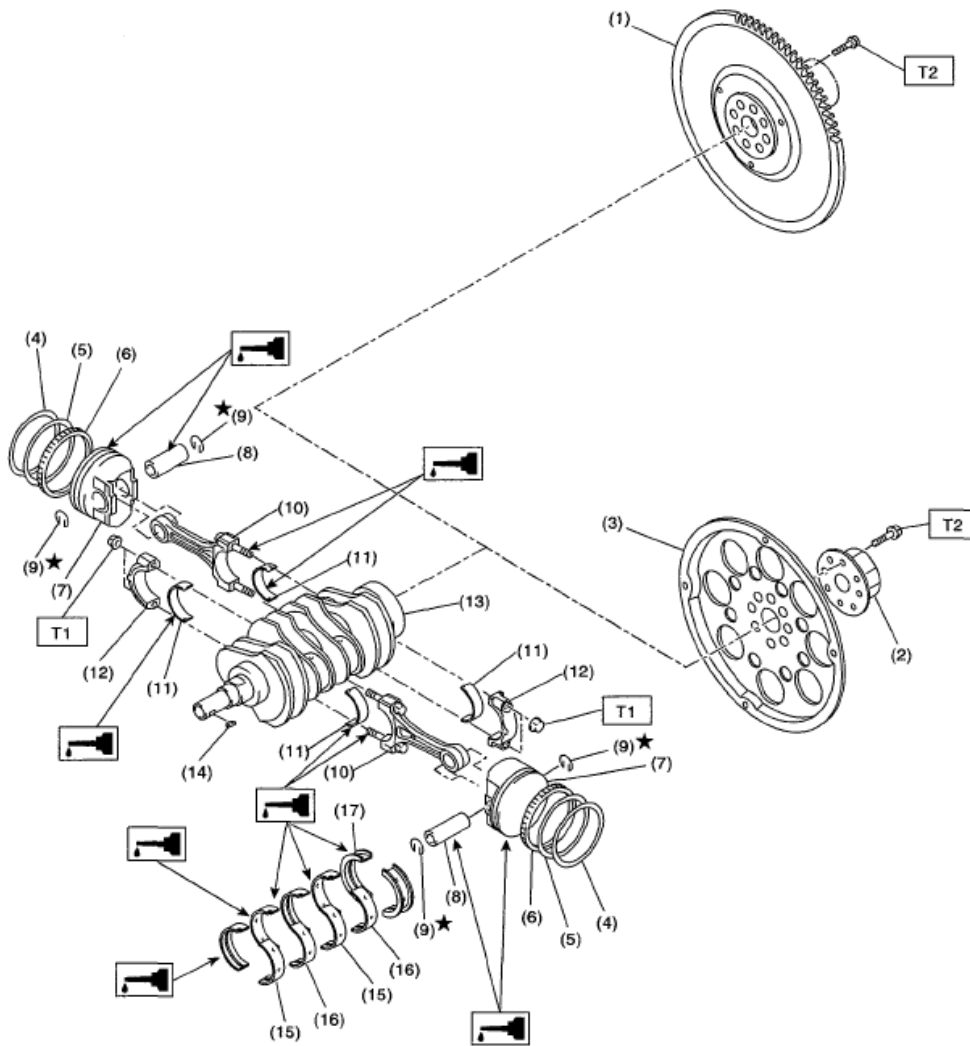
T8: 44 (4.5, 32.5)

T9: 45 (4.6, 33.2)

T10: 70 (7.1, 51.6)

Fig. 5: Identifying Cylinder Block Components With Torque Specifications
 Courtesy of SUBARU OF AMERICA, INC.

CRANKSHAFT AND PISTON



ME-03292

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

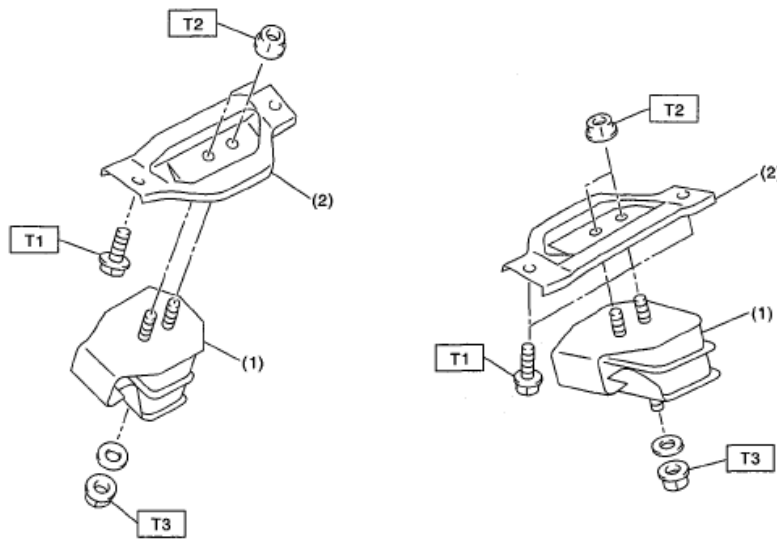
Tightening torque: N·m (kgf-m, ft-lb)

T1: 45 (4.6, 33.2)

T2: 72 (7.3, 53.1)

Fig. 6: Identifying Crankshaft And Piston Components With Torque Specifications
 Courtesy of SUBARU OF AMERICA, INC.

ENGINE MOUNTING



ME-00413

(1) Front cushion rubber

(2) Front engine mounting bracket

Tightening torque: N·m (kgf-m, ft-lb)

T1: 35 (3.6, 25.8)

T2: 42 (4.3, 31.0)

T3: 85 (8.7, 62.7)

Fig. 7: Identifying Engine Mounting Components With Torque Specifications
Courtesy of SUBARU OF AMERICA, INC.

CAUTION

- Wear appropriate work clothing, including a cap, protective goggles and protective shoes when performing any work.
- Remove contamination including dirt and corrosion before removal, installation or disassembly.
- Keep the disassembled parts in order and protect them from dust and dirt.
- Before removal, installation or disassembly, be sure to clarify the failure. Avoid unnecessary removal, installation, disassembly and replacement.
- Vehicle components are extremely hot after driving. Be wary of receiving burns from heated parts.
- Be sure to tighten fasteners including bolts and nuts to the specified torque.
- Place shop jacks or rigid racks at the specified points.
- Before disconnecting connectors of sensors or units, be sure to disconnect the ground cable from the battery.
- All parts should be thoroughly cleaned, paying special attention to engine oil passages, pistons and bearings.
- Rotating parts and sliding parts such as piston, bearing and gear should be coated with oil prior to

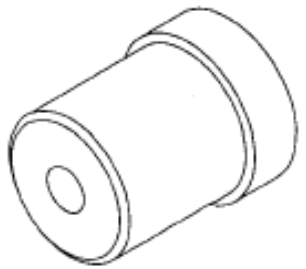
assembly.

- Be careful not to let oil, grease or coolant contact the timing belt, clutch disc and flywheel.
- All removed parts, if to be reused, should be reinstalled in the original positions and directions.
- Bolts, nuts and washers should be replaced with new parts as required.
- Even if necessary inspections have been made in advance, proceed with assembly work while making rechecks.
- Remove or install the engine in an area where chain hoists, lifting devices, etc. are available for ready use.
- Be sure not to damage coated surfaces of body panels with tools, or not to stain seats and windows with coolant or oil. Place a cover over fender, as required, for protection.
- Prior to starting work, prepare the following: Service tools, clean cloth, containers to catch coolant and oil, wire ropes, chain hoist, transmission jacks, etc.
- Lift up or lower the vehicle when necessary. Make sure to support the correct positions.

PREPARATION TOOL

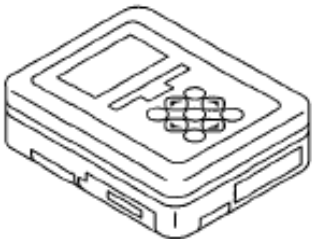
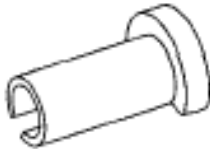
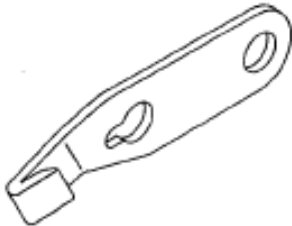
SPECIAL TOOL

SPECIAL TOOL CHART

ILLUSTRATION	TOOL NUMBER	DESCRIPTION	REMARKS
 ST18231AA010	18231AA010	CAM SPROCKET WRENCH	• Used for removing and installing cam sprocket LH. • CAM SPROCKET WRENCH (499207100) can also be used.
 ST-499587100	499207400	CAM SPROCKET WRENCH	Used for removing and installing cam sprocket RH.
	1B021XU0	SUBARU SELECT MONITOR III KIT	Used for troubleshooting the electrical system.

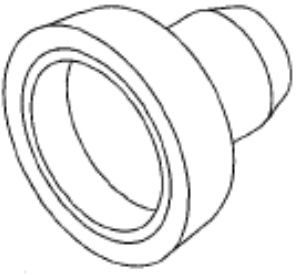
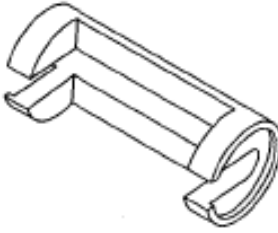
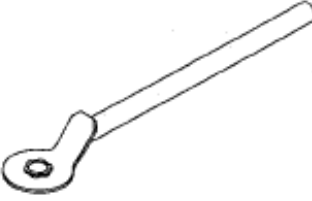
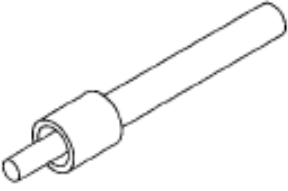
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 ST1B021XU0			
 ST42099AE000	498267800	CYLINDER HEAD TABLE	Used for replacing valve guides. Used for removing and installing valve spring.
 ST-498277200	498277200	STOPPER SET	Used for installing automatic transmission assembly to engine.
 ST-498497100	498457000	ENGINE STAND ADAPTER RH	Used together with the ENGINE STAND (499817100).
	498457100	ENGINE STAND ADAPTER LH	Used together with the ENGINE STAND (499817100).

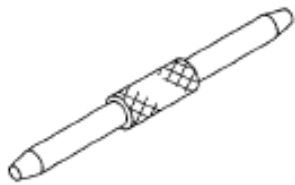
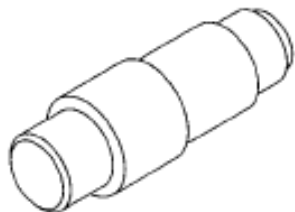
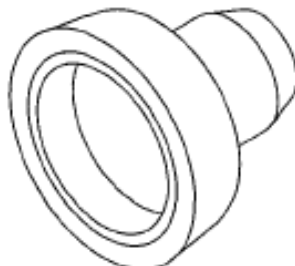
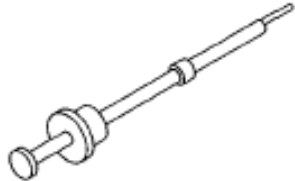
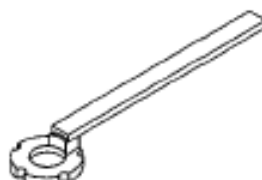
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 ST-499587200			
 ST-499597100	498497100	CRANKSHAFT STOPPER	Used for removing and installing the flywheel and the drive plate.
 ST-499718000	498747300	PISTON GUIDE	Used for installing piston in cylinder.
 ST-499977500	498857100	VALVE OIL SEAL GUIDE	Used for press-fitting of intake and exhaust valve guide oil seals.
 ST-498857100	499017100	PISTON PIN GUIDE	Used for installing piston pin, piston and connecting rod.

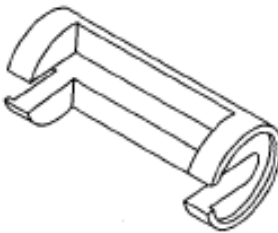
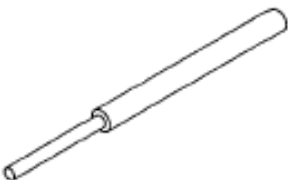
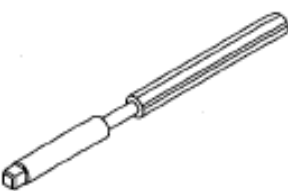
2008 Subaru Impreza 2.5i

2008 ENGINE Mechanical (H4SO Engine) - Impreza

 ST-499017100	499037100	CONNECTING ROD BUSHING REMOVER & INSTALLER	Used for removing and installing connecting rod bushing.
 ST-499037100	499587200	CRANKSHAFT OIL SEAL INSTALLER	• Used for installing crankshaft oil seal. • Used together with the CRANKSHAFT OIL SEAL GUIDE (499597100).
 ST-499587200	499587500	OIL SEAL INSTALLER	• Used for installing the camshaft oil seal. • Used together with the OIL SEAL GUIDE (499597000).
 ST-499097700	499587700	CAMSHAFT OIL SEAL INSTALLER	Used for installing cylinder head plug.
 ST-499207400	499097700	PISTON PIN REMOVER ASSY	Used for removing piston pin.

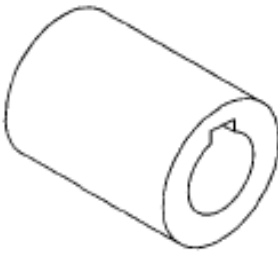
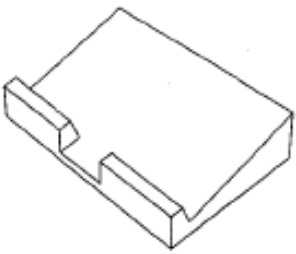
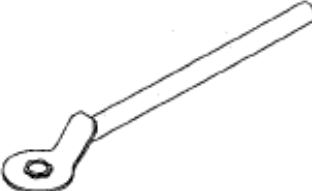
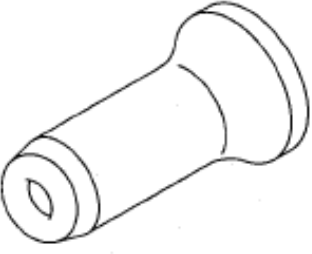
2008 Subaru Impreza 2.5i

2008 ENGINE Mechanical (H4SO Engine) - Impreza

 ST-499597100	499497000	TORX® PLUS	Used for removing and installing camshaft cap.
 ST-499718000	499587100	OIL SEAL INSTALLER	Used for installing oil pump oil seal.
 ST-499767200	499597000	OIL SEAL GUIDE	• Used for installing the camshaft oil seal. • Used together with the OIL SEAL INSTALLER (499587500).
 ST-499767400	499597100	CRANKSHAFT OIL SEAL GUIDE	• Used for installing crankshaft oil seal. • Used together with the CRANKSHAFT OIL SEAL INSTALLER (499587200).
 ST-499817100	499718000	VALVE SPRING REMOVER	Used for removing and installing valve spring.

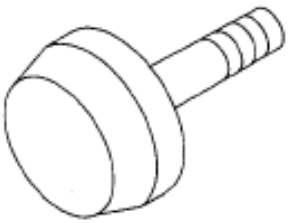
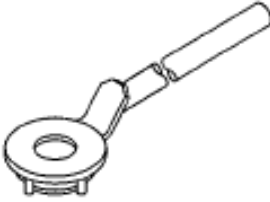
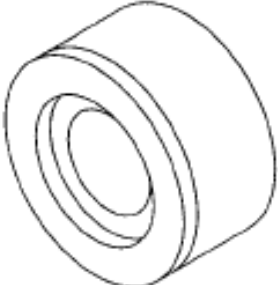
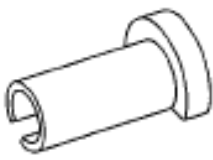
2008 Subaru Impreza 2.5i

2008 ENGINE Mechanical (H4SO Engine) - Impreza

 ST-499987500	499767200	VALVE GUIDE REMOVER	Used for removing valve guides.
 ST-498267600	499767400	VALVE GUIDE REAMER	Used for reaming valve guides.
 ST-499977500	499767700	VALVE GUIDE ADJUSTER	Used for installing valve guides. (Intake side)
 ST18251AA020	499767800	VALVE GUIDE ADJUSTER	Used for installing valve guides. (Exhaust side)
 ST-499587600	499817100	ENGINE STAND	• Stand used for engine disassembly and assembly. • Used together with the ENGINE STAND ADAPTER RH (498457000) & LH (498457100).

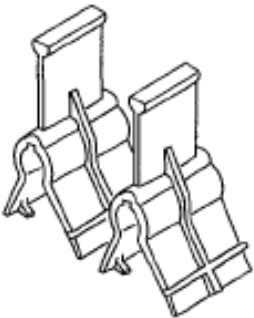
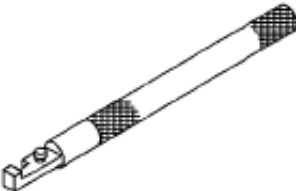
2008 Subaru Impreza 2.5i

2008 ENGINE Mechanical (H4SO Engine) - Impreza

 ST-499597200	499977100	CRANK PULLEY WRENCH	Used to stop rotation of the crank pulley when loosening or tightening crank pulley bolts. (MT model)
 ST-499977400	499977400	CRANK PULLEY WRENCH	Used to stop rotation of the crank pulley when loosening or tightening crank pulley bolts. (AT model)
 ST-499767800	499987500	CRANKSHAFT SOCKET	Used for rotating crankshaft.
 ST42099AE000	42099AE000	QUICK CONNECTOR RELEASE	Used for removing the quick connector.
	18354AA000	VALVE ROCKER HOLDER	Used for installing the valve rocker assembly (intake). (2-piece set)

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2008 ENGINE Mechanical (H4SO Engine) - Impreza

 ST18354AA000			
 ST18258AA000	18258AA000	SPRING INSTALLER	Used for installing the valve rocker assembly (intake).

GENERAL TOOL

GENERAL TOOL CHART

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

PROCEDURE

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

- V-belt
- Timing belt
- Valve rocker assembly
- Camshaft
- Cylinder head

COMPRESSION

INSPECTION

CAUTION: After warming-up, engine becomes very hot. Be careful not to burn yourself during measurement.

1. After warming-up the engine, turn the ignition switch to OFF.
2. Make sure that the battery is fully charged.
3. Release the fuel pressure.

<Ref. to **RELEASING OF FUEL PRESSURE** , PROCEDURE, Fuel . >

4. Remove all the spark plugs. <Ref. to **REMOVAL** , Spark Plug . >
5. Fully open the throttle valve.
6. Check the starter motor for satisfactory performance and operation.
7. Hold the compression gauge tightly against the spark plug hole.

NOTE: When using a screw-in type compression gauge, the screw should be less than 18 mm (0.71 in) long.

8. Crank the engine by the starter motor, and read the maximum value on the gauge when the needle of gauge is steady.

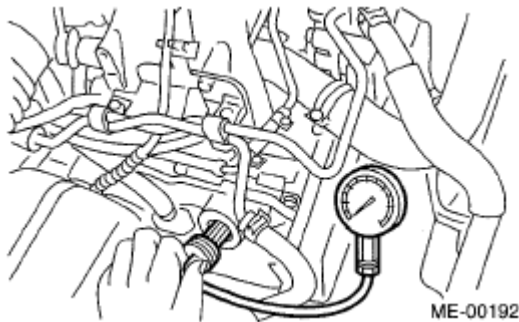


Fig. 8: Screwing Compression Gauge
Courtesy of SUBARU OF AMERICA, INC.

9. Perform at least two measurements per cylinder, and check that the values are correct.

Compression (throttle full open):

Standard

1,020 - 1,275 kPa (10.4 - 13.0 kgf/cm² , 148 - 185 psi)

Difference between cylinders

49 kPa (0.5 kgf/cm² , 7 psi) or less

10. After inspection, install the related parts in the reverse order of removal.

IDLE SPEED

INSPECTION

1. Before checking the idle speed, check the following item:
 1. Check the air cleaner element is free from clogging, ignition timing is correct, spark plugs are in good condition, and hoses are connected properly.
 2. Check the malfunction indicator light does not illuminate.
2. Warm-up the engine.
3. Read the engine idle speed using Subaru Select Monitor. <Ref. to **READ CURRENT DATA FOR ENGINE (NORMAL MODE)**, OPERATION, Subaru Select Monitor . >
4. Check the idle speed when no-loaded. (Headlight, heater fan, rear defroster, radiator fan, A/C and etc. are OFF)

Idle speed [No load and gears in neutral, "P" or "N" range]:

650±100 rpm (MT model)

700±100 rpm (A T model)

5. Check the idle speed when loaded. (Turn the A/C switch to "ON" and operate the compressor for at least one minute before measurement.)

Idle speed [A/C ON and gears in neutral, "P" or "N" range]:

850±100 rpm

NOTE: Idle speed cannot be adjusted manually, because the idle speed is automatically adjusted. If the prescribed idle speed cannot be maintained, refer to the General On-board Diagnosis Table under "Engine Control System". <Ref. to **BASIC DIAGNOSTIC PROCEDURE** . >

IGNITION TIMING

INSPECTION

1. Before checking the ignition timing, check the following item:
 1. Check the air cleaner element is free from clogging, spark plugs are in good condition, and hoses are connected properly.
 2. Check the malfunction indicator light does not illuminate.
2. Warm-up the engine.
3. Stop the engine, and turn the ignition switch to OFF.

4. Connect the timing light to #1 cylinder spark plug cord, and then light the timing mark with the timing light.
5. Start the engine and check the ignition timing at idle speed as shown below.

Ignition timing [BTDC/rpm]:

$10^{\circ} \pm 8^{\circ} / 650$ (MT Model)

$15^{\circ} \pm 10^{\circ} / 700$ (AT Model)

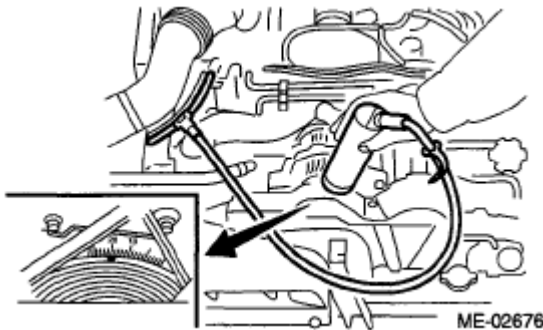


Fig. 9: Checking Ignition Timing

Courtesy of SUBARU OF AMERICA, INC.

If the timing is not correct, check the ignition control system. <Ref. to **BASIC DIAGNOSTIC PROCEDURE** . >

INTAKE MANIFOLD VACUUM

INSPECTION

1. Warm-up the engine.
2. Disconnect the brake vacuum hose from intake manifold, and then install the vacuum gauge.
3. Keep the engine at idle speed and read the vacuum gauge indication.

By observing the gauge needle movement, the internal condition of the engine can be diagnosed as described below.

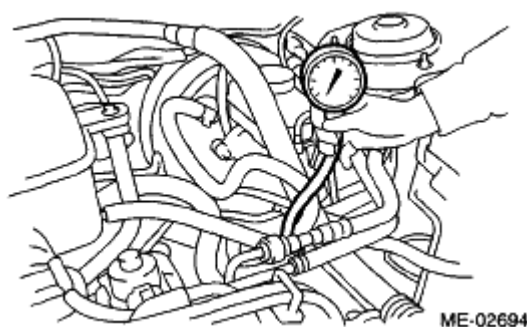


Fig. 10: Installing Vacuum Gauge
 Courtesy of SUBARU OF AMERICA, INC.

Vacuum pressure (at idling, A/C "OFF"):

Less than -60.0 kPa (-450 mmHg, -17.72 inHg)

VACUUM PRESSURE REFERENCE

Diagnosis of engine condition by measurement of intake manifold vacuum	
Vacuum gauge indication	Possible engine condition
1. Needle is steady but lower than normal position. This tendency becomes more evident as engine temperature rises.	Air leakage around intake manifold gasket, disconnection or damage of vacuum hose
2. Needle intermittently drops to position lower than normal position.	Leakage around cylinder
3. Needle drops suddenly and intermittently from normal position.	Sticky valve
4. When engine speed is gradually increased, needle begins to vibrate rapidly at certain speed, and then vibration increases as engine speed increases.	Weak or broken valve springs
5. Needle vibrates above and below normal position in narrow range.	Defective ignition system

ENGINE OIL PRESSURE

INSPECTION

1. Disconnect the ground cable from the battery.

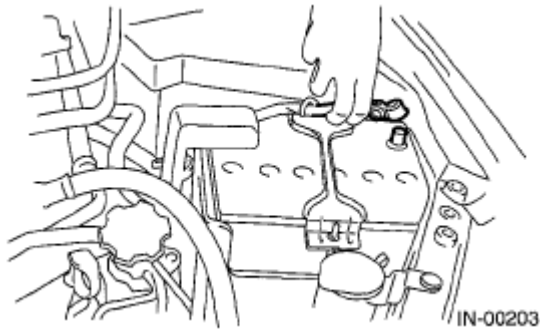


Fig. 11: Disconnecting Ground Cable From Battery
Courtesy of SUBARU OF AMERICA, INC.

2. Remove the oil pressure switch. <Ref. to **REMOVAL** , Oil Pressure Switch . >
3. Connect the oil pressure gauge to cylinder block.
4. Connect the ground cable to battery.

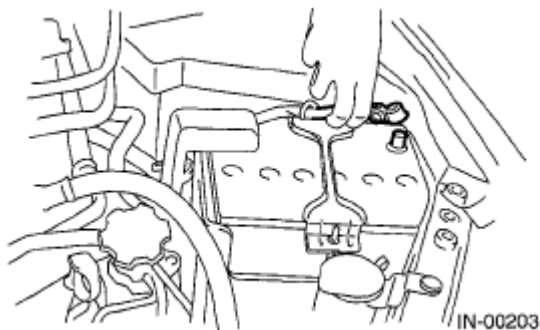


Fig. 12: Connecting Ground Cable From Battery
Courtesy of SUBARU OF AMERICA, INC.

5. Start the engine, and measure the oil pressure.

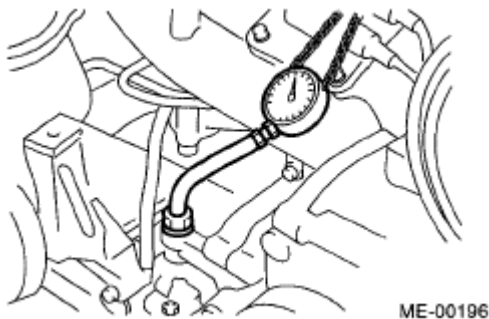


Fig. 13: Measuring Oil Pressure
Courtesy of SUBARU OF AMERICA, INC.

Oil pressure:

Standard 98 kPa (1.0 kg/cm² , 14 psi) or more at 600 rpm

294 kPa (3.0 kg/cm² , 43 psi) or more at 5, 000 rpm

- If the oil pressure is out of specification, check oil pump, oil filter and lubrication line. <Ref. to **INSPECTION** , Engine Lubrication System Trouble in General . >
- If the oil pressure warning light is ON and oil pressure is within specification, check the oil pressure switch. <Ref. to **INSPECTION** , Engine Lubrication System Trouble in General . >

NOTE: **Standard value is based on an engine oil temperature of 80°C (176°F).**

6. After measuring the oil pressure, install the oil pressure switch. <Ref. to **INSTALLATION** , Oil Pressure Switch . >

FUEL PRESSURE

INSPECTION

- CAUTION:**
- Before removing the fuel pressure gauge, release the fuel pressure.
 - Be careful not to spill fuel.
 - Catch the fuel from hoses using a container or cloth.

NOTE: **Check or replace the fuel pump and fuel delivery line if the fuel pressure is out of the standard.**

1. Release the fuel pressure.

<Ref. to **RELEASING OF FUEL PRESSURE** , PROCEDURE, Fuel . >

2. Disconnect the fuel delivery hose from the fuel damper, and connect the fuel pressure gauge.

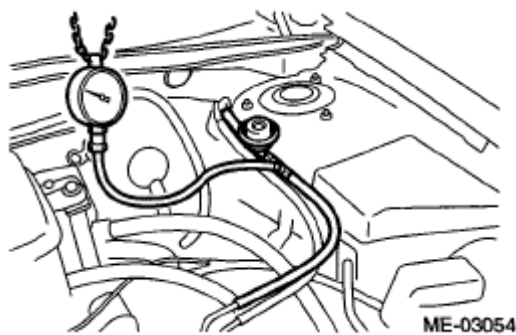


Fig. 14: Connecting Fuel Pressure Gauge
Courtesy of SUBARU OF AMERICA, INC.

3. Install the fuse of fuel pump to main fuse box.

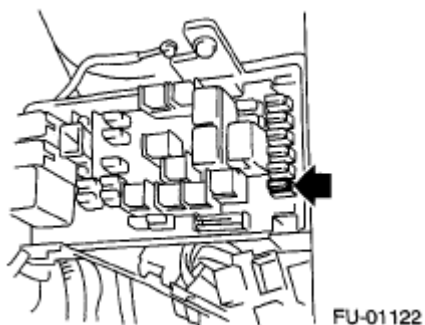


Fig. 15: Locating Fuse Of Fuel Pump
Courtesy of SUBARU OF AMERICA, INC.

4. Start the engine.
5. Measure the fuel pressure after warming up the engine.

NOTE: The fuel pressure gauge registers 10 to 20 kPa (0.1 to 0.2 kg/cm² , 1 to 3 psi) higher than standard values during high-altitude operations.

Fuel pressure:

Standard:

338 - 348 kPa (3.4 - 3.5 kg/cm² , 49 - 50 psi)

VALVE CLEARANCE

INSPECTION

NOTE: Inspection and adjustment of valve clearance should be performed while engine is cold.

1. Disconnect the ground cable from the battery.

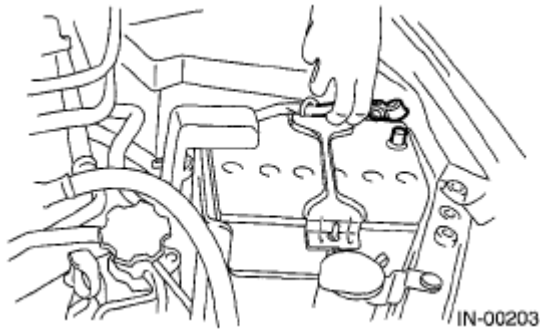


Fig. 16: Disconnecting Ground Cable From Battery
 Courtesy of SUBARU OF AMERICA, INC.

2. Remove the timing belt cover LH.

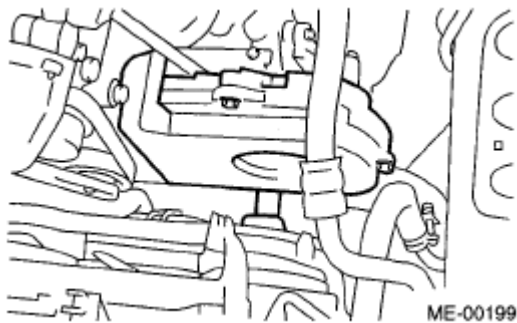


Fig. 17: Identifying Timing Belt Cover LH
 Courtesy of SUBARU OF AMERICA, INC.

3. Remove the fuel injector. <Ref. to **REMOVAL** , Fuel Injector . >
4. When inspecting #1 and #3 cylinders
 1. Disconnect the spark plug cords from spark plugs RH side. <Ref. to **RH SIDE** , REMOVAL, Spark Plug . >
 2. Place a suitable container under the vehicle.
 3. Disconnect the PCV hose from the rocker cover RH.
 4. Remove the bolts, then remove the rocker cover RH.
5. When inspecting #2 and #4 cylinders
 1. Disconnect the spark plug cords from spark plugs LH side. <Ref. to **LH SIDE** , REMOVAL, Spark Plug . >
 2. Place a suitable container under the vehicle.
 3. Disconnect the PCV hose from the rocker cover LH.
 4. Remove the bolts, then remove the rocker cover LH.
6. Set #1 cylinder piston to top dead center of compression stroke by rotating the crank pulley clockwise using the socket wrench.

NOTE: When the arrow mark (A) on cam sprocket LH is at the top position, the #1 cylinder piston is at top dead center of the compression stroke.

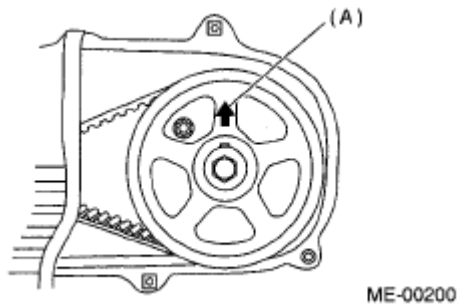


Fig. 18: Disconnecting Ground Cable From Battery
Courtesy of SUBARU OF AMERICA, INC.

7. Measure #1 cylinder valve clearance by using thickness gauge (A).

NOTE:

- Insert the thickness gauge (A) in as horizontally as possible with respect to the valve stem end face.
- Lift up the vehicle and measure the exhaust valve clearances.

Valve clearance:

Intake

$0.20 \pm 0.04 \text{ mm } (0.0079 \pm 0.0016 \text{ in})$

Exhaust

$0.25 \pm 0.04 \text{ mm } (0.0098 \pm 0.0016 \text{ in})$

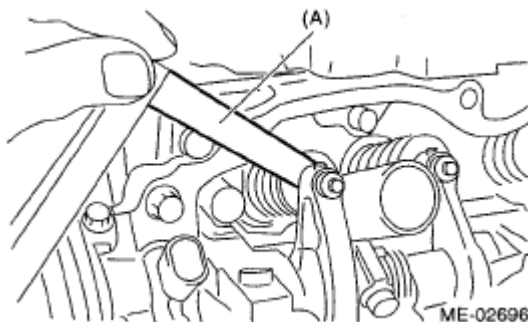


Fig. 19: Measuring Cylinder Valve Clearance
Courtesy of SUBARU OF AMERICA, INC.

8. If necessary, adjust the valve clearance. <Ref. to **ADJUSTMENT**, Valve Clearance. >
9. Measure the valve clearance in #3, #2 and #4 cylinder in the same measurement procedure as #1 cylinder

in this order.

NOTE:

- Be sure to set the cylinder pistons to their respective top dead centers on compression stroke before measuring valve clearances.
- By rotating the crank pulley clockwise every 180° from the state that #1 cylinder piston is on the top dead center of compression stroke, #3, #2 and #4 cylinder pistons come to the top dead center of compression stroke in this order.

10. After inspection, install the related parts in the reverse order of removal.

ADJUSTMENT

NOTE: Adjustment of valve clearance should be performed while engine is cold.

1. Set #1 cylinder piston to top dead center of compression stroke by rotating the crank pulley clockwise using the socket wrench.

NOTE:

When the arrow mark (A) on cam sprocket LH is at the top position, the #1 cylinder piston is at top dead center of the compression stroke.

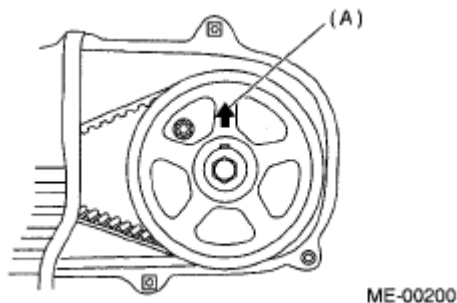


Fig. 20: Locating Arrow Mark On Cam Sprocket LH
Courtesy of SUBARU OF AMERICA, INC.

2. Adjust the #1 cylinder valve clearance.
 1. Loosen the valve rocker nut and screw.
 2. Set a suitable thickness gauge.
 3. While noting the valve clearance, tighten the valve rocker adjusting screw.
 4. When the specified valve clearance is obtained, tighten the valve rocker nut.

NOTE:

- Insert a thickness gauge in a direction as horizontal as possible with respect to the valve stem end face.
- Lift up the vehicle and adjust the exhaust valve clearances.

Valve clearance:**Intake**

0.20 ± 0.04 mm (0.0079 ± 0.0016 in)

Exhaust

0.25 ± 0.04 mm (0.0098 ± 0.0016 in)

Tightening torque:

9.75 N.m (1.0 kgf-m, 7.2 ft-lb)

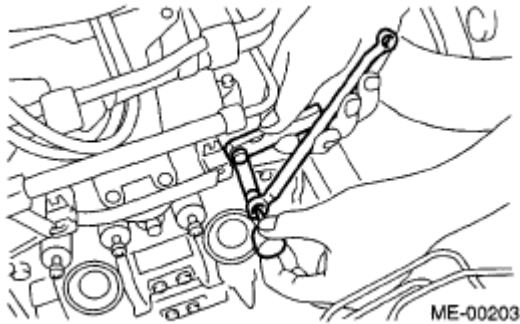


Fig. 21: Measuring Valve Clearance
Courtesy of SUBARU OF AMERICA, INC.

- Adjust the valve clearance in #3, #2 and #4 cylinder in the same adjustment procedure as #1 cylinder in this order.

NOTE:

- Be sure to set the cylinder pistons to their respective top dead centers on compression stroke before adjusting valve clearances.
 - By rotating the crank pulley clockwise every 180° from the state that #1 cylinder piston is on the top dead center of compression stroke, #3, #2 and #4 cylinder pistons come to the top dead center of compression stroke in this order.
- Ensure the valve clearances of each cylinder are within specifications. If necessary, readjust the valve clearances.

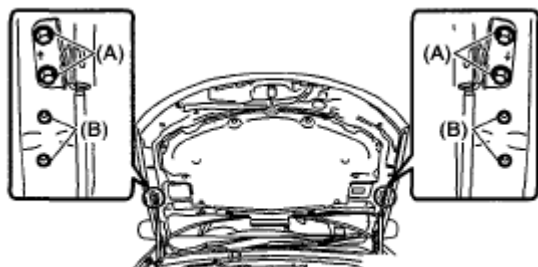
ENGINE ASSEMBLY

REMOVAL

- Set the vehicle on a lift.
- Change the bolt mounting position from (A) to (B), and completely open the front hood.

Tightening torque:

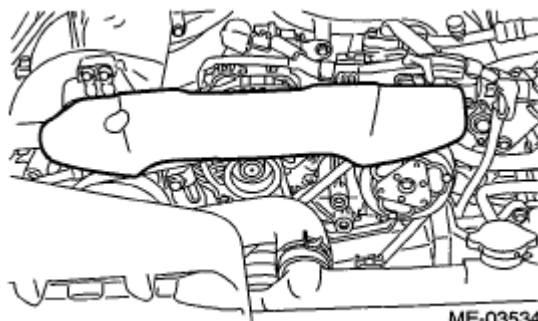
7.5 N.m (0.76 kgf-m, 5.5 ft-lb)



ME-03458

Fig. 22: Identifying Engine Assembly Mounting Bolts
 Courtesy of SUBARU OF AMERICA, INC.

3. Remove the V-belt covers.



ME-03534

Fig. 23: Identifying V-Belt Covers
 Courtesy of SUBARU OF AMERICA, INC.

4. Collect the refrigerant from the A/C system. <Ref. to **PROCEDURE** , Refrigerant Recovery Procedure . >
5. Release the fuel pressure.

<Ref. to **RELEASING OF FUEL PRESSURE** , PROCEDURE, Fuel . >

6. Disconnect the battery cable, and then remove the battery from the vehicle body.
7. Remove the air intake duct, air cleaner case and air intake chamber.

<Ref. to **REMOVAL** , Air Intake Duct . >

<Ref. to **REMOVAL** , Air Cleaner Case . >

<Ref. to **REMOVAL** , Air Intake Chamber . >

8. Remove the under cover.
9. Remove the radiator from the vehicle. <Ref. to **REMOVAL** , Radiator . >
10. Disconnect the A/C pressure hoses from A/C compressor.
11. Remove the air intake chamber stay.

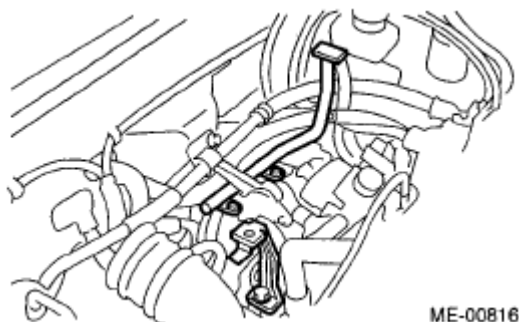
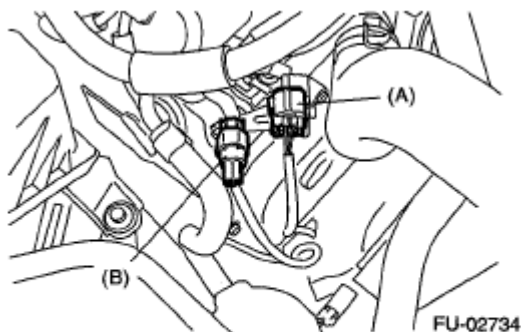


Fig. 24: Identifying Air Intake Chamber Stay
Courtesy of SUBARU OF AMERICA, INC.

12. Disconnect the following connectors and cables.
 1. Front oxygen (A/F) sensor connector
 2. Rear oxygen sensor connector



- (A) Front oxygen (A/F) sensor connector
(B) Rear oxygen sensor connector

Fig. 25: Identifying V-Belt Covers
Courtesy of SUBARU OF AMERICA, INC.

3. Engine ground terminal

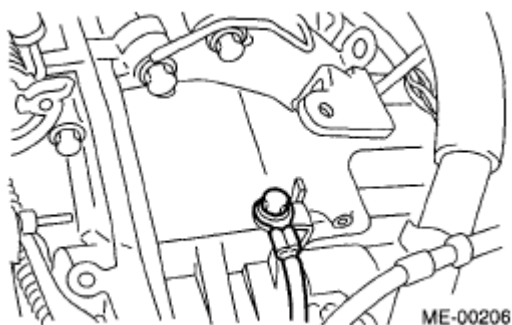


Fig. 26: Identifying Engine Ground Terminal
Courtesy of SUBARU OF AMERICA, INC.

4. Engine harness connectors

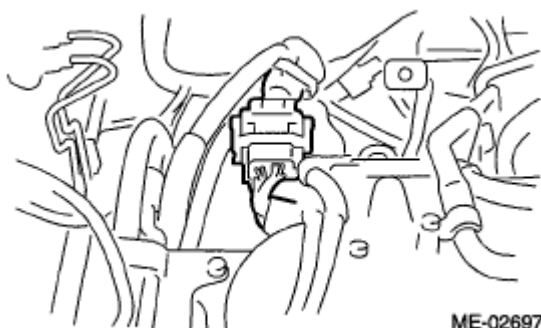
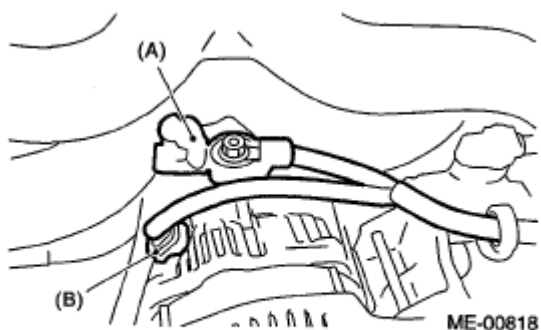


Fig. 27: Identifying Engine Harness Connectors
Courtesy of SUBARU OF AMERICA, INC.

5. Generator connector and terminal



- (A) Terminals
(B) Generator connector

Fig. 28: Identifying Generator Connector And Terminal
Courtesy of SUBARU OF AMERICA, INC.

6. A/C compressor connector

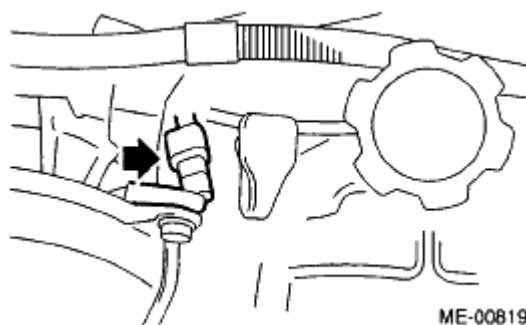


Fig. 29: Identifying A/C Compressor Connector
Courtesy of SUBARU OF AMERICA, INC.

7. Power steering switch connector

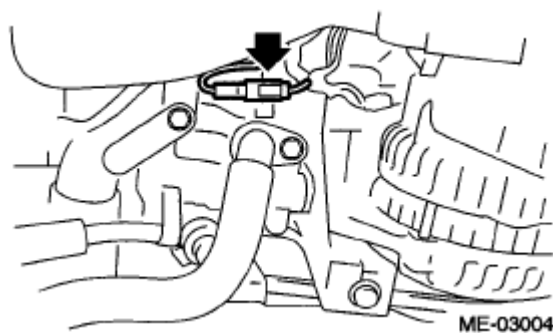


Fig. 30: Identifying Power Steering Switch Connector
Courtesy of SUBARU OF AMERICA, INC.

13. Disconnect the following hoses.
 1. Brake booster vacuum hose

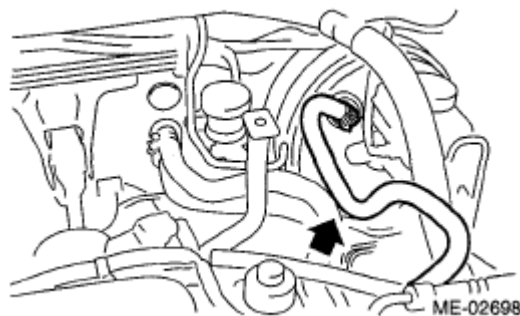


Fig. 31: Locating Brake Booster Vacuum Hose
Courtesy of SUBARU OF AMERICA, INC.

2. Heater inlet and outlet hoses
14. Remove the power steering pump.
 1. Remove the front side belts. <Ref. to **FRONT SIDE BELT**, REMOVAL, V-belt. >

2. Remove the bolts which secure the power steering pump to the bracket.

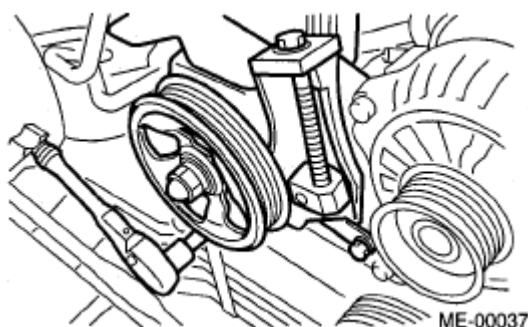


Fig. 32: Identifying Power Steering Pump Bracket Bolts
Courtesy of SUBARU OF AMERICA, INC.

3. Place the power steering pump on the right side wheel apron.
15. Lift up the vehicle.
16. Remove the front and center exhaust pipes. <Ref. to **REMOVAL** , Front Exhaust Pipe . >
17. Disconnect the engine ground terminal from the cylinder head.

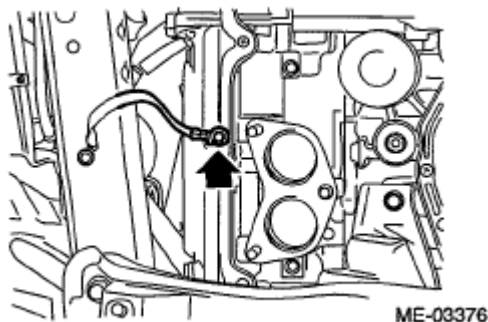


Fig. 33: Locating Engine Ground Terminal
Courtesy of SUBARU OF AMERICA, INC.

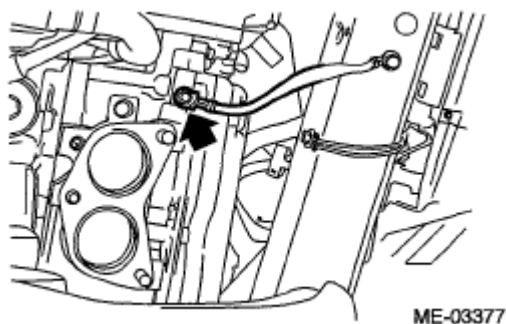


Fig. 34: Locating Engine Ground Terminal
Courtesy of SUBARU OF AMERICA, INC.

18. Remove the bolts and nuts which hold lower side of transmission to engine.
- AT model

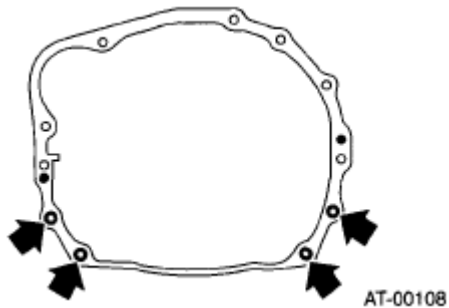


Fig. 35: Locating Lower Side Of Transmission To Engine Bolts - AT Model
Courtesy of SUBARU OF AMERICA, INC.

- MT model

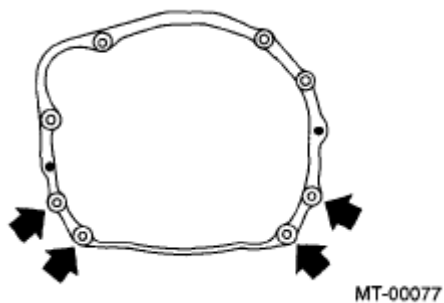


Fig. 36: Locating Lower Side Of Transmission To Engine Bolts - MT Model
Courtesy of SUBARU OF AMERICA, INC.

19. Remove the nuts which hold the engine mount to the front cross member.

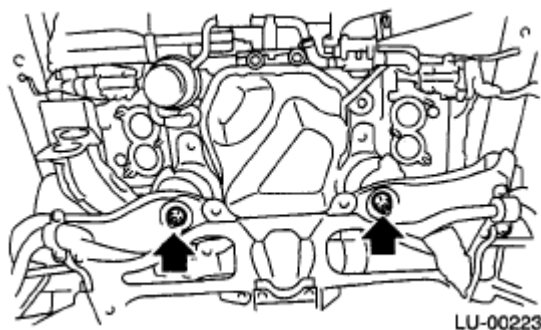


Fig. 37: Locating Front Cross Member Engine Mount Nuts
Courtesy of SUBARU OF AMERICA, INC.

20. Separate the torque converter clutch from drive plate. (AT model)
1. Lower the vehicle.

2. Remove the service hole plug.
3. Remove the bolts which hold torque converter clutch to drive plate.
4. Remove all bolts while turning the crankshaft with a socket wrench.

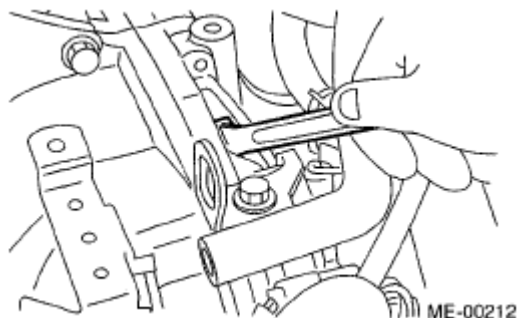


Fig. 38: Removing Bolts

Courtesy of SUBARU OF AMERICA, INC.

21. Remove the pitching stopper.

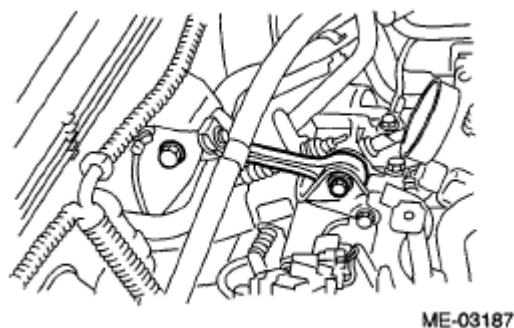


Fig. 39: Identifying Pitching Stopper

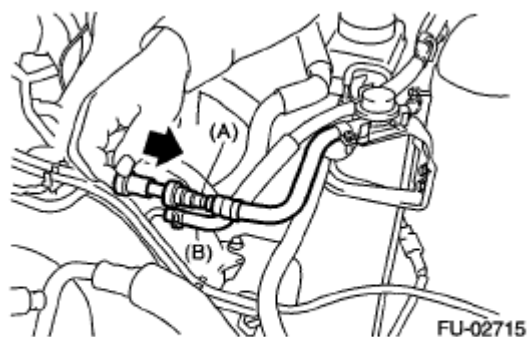
Courtesy of SUBARU OF AMERICA, INC.

22. Disconnect the fuel hoses from fuel pipe.
 1. Disconnect the quick connector on the fuel delivery line by pushing the ST in the direction of the arrow.

ST 42099AE000 QUICK CONNECTOR RELEASE
 2. Remove the clip and disconnect the evaporation hose from the pipe.

CAUTION:

- Be careful not to spill fuel.
- Catch the fuel from hoses using a container or cloth.



(A) Fuel delivery hose

(B) Evaporation hose

Fig. 40: Identifying Fuel Delivery And Evaporation Hoses
Courtesy of SUBARU OF AMERICA, INC.

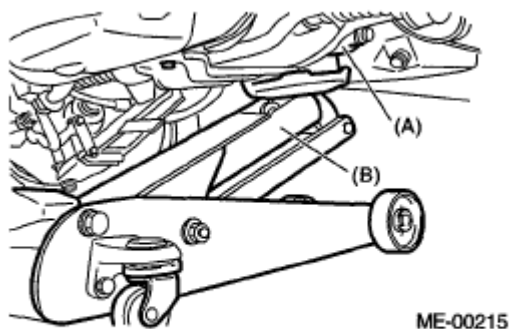
23. Support the engine with a lifting device and wire ropes.



Fig. 41: Supporting Engine
Courtesy of SUBARU OF AMERICA, INC.

24. Support the transmission with a garage jack.

CAUTION: Doing this is very important to prevent the transmission from lowering due to its own weight.



- (A) Transmission
(B) Garage jack

Fig. 42: Supporting Transmission With Garage Jack
Courtesy of SUBARU OF AMERICA, INC.

25. Separation of engine and transmission

CAUTION: Before removing the engine away from transmission, check to be sure no work has been overlooked.

1. Remove the starter. <Ref. to **REMOVAL** , Starter . >
2. Set the ST to torque converter clutch case. (AT model)

ST 498277200 STOPPER SET

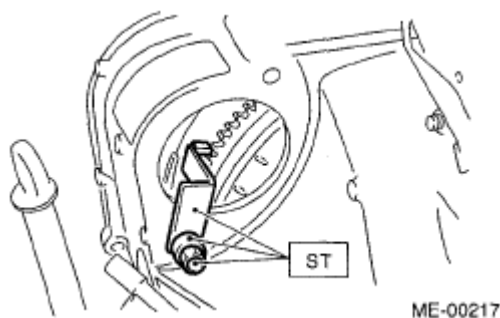
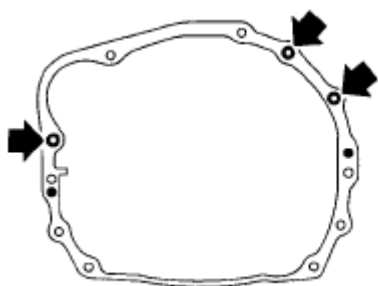


Fig. 43: Identifying Special Tool
Courtesy of SUBARU OF AMERICA, INC.

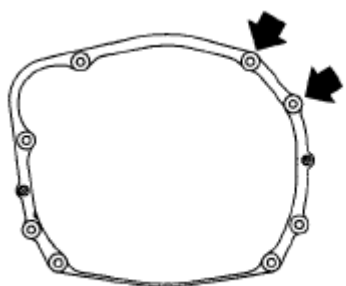
3. Remove the bolts which hold upper side of transmission to engine.
 - AT model



AT-00106

Fig. 44: Locating Upper Side Of Transmission To Engine Bolts - AT Model
Courtesy of SUBARU OF AMERICA, INC.

- MT model



MT-01524

Fig. 45: Locating Upper Side Of Transmission To Engine Bolts - MT Model
Courtesy of SUBARU OF AMERICA, INC.

26. Remove the engine from vehicle.
 1. Slightly raise the engine.
 2. Raise the transmission with garage jack.
 3. Move the engine horizontally until main shaft is withdrawn from clutch cover.
 4. Slowly move the engine away from engine compartment.

NOTE: Be careful not to damage adjacent parts or body panels with crank pulley, oil level gauge, etc.

27. Remove the engine mounting.

INSTALLATION

1. Install the engine mounting onto the engine.

Tightening torque:

35 N.m (3.6 kgf-m, 25.8 ft-lb)

2. Apply a small amount of grease to splines of main shaft. (MT model)
3. Position the engine in engine compartment and align it with transmission.

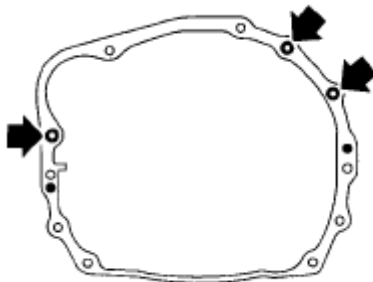
NOTE: Be careful not to damage adjacent parts or body panels with crank pulley, oil level gauge, etc.

4. Tighten the bolts which hold upper side of transmission to engine.

Tightening torque:

50 N.m (5.1 kgf-m, 36.9 ft-lb)

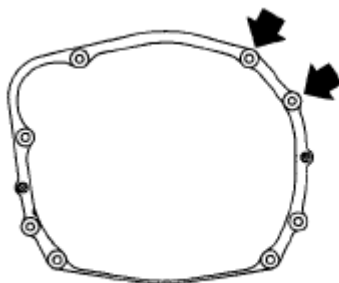
- AT model



AT-00106

Fig. 46: Locating Upper Side Of Transmission To Engine Bolts - AT Model
 Courtesy of SUBARU OF AMERICA, INC.

- MT model



MT-01524

Fig. 47: Locating Upper Side Of Transmission To Engine Bolts - MT Model
 Courtesy of SUBARU OF AMERICA, INC.

5. Remove the lifting device and wire ropes.



Fig. 48: Identifying Lifting Device And Wire Ropes
 Courtesy of SUBARU OF AMERICA, INC.

6. Remove the garage jack.
7. Install the pitching stopper.

Tightening torque:

T1:50 N.m (5.1 kgf-m, 36.9 ft-lb)

T2:58 N.m (5.9 kgf-m, 42.8 ft-lb)

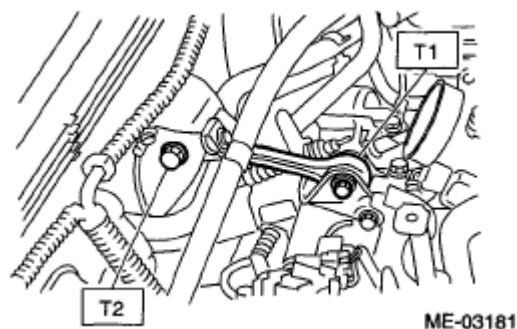


Fig. 49: Identifying Garage Jack And Pitching Stopper
 Courtesy of SUBARU OF AMERICA, INC.

8. Remove the ST from the torque converter clutch case. (AT model)

NOTE: Be careful not to drop the ST into the torque converter clutch case when removing the ST.

ST 498277200 STOPPER SET

9. Install the starter. <Ref. to **INSTALLATION** , Starter . >
10. Install the torque converter clutch to drive plate. (AT model)
 1. Tighten the bolts which hold torque converter clutch to drive plate.
 2. Tighten other bolts while rotating the crankshaft using socket wrench.

NOTE: Be careful not to drop bolts into the torque converter clutch housing.

Tightening torque:

25 N.m (2.5 kgf-m, 18.4 ft-lb)

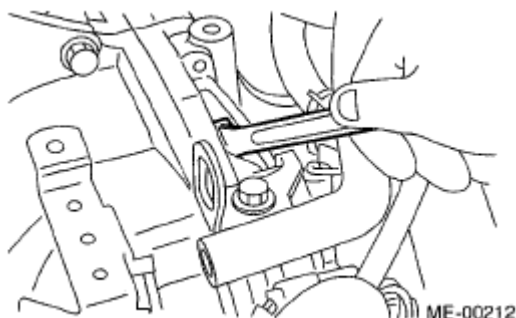


Fig. 50: Removing Bolts
Courtesy of SUBARU OF AMERICA, INC.

3. Install the service hole plug.
11. Install the power steering pump.
 1. Install the power steering pump to the bracket.

Tightening torque:

Refer to "COMPONENT" of "Power Steering" for the tightening torque. <Ref. to COMPONENT , General Description . >

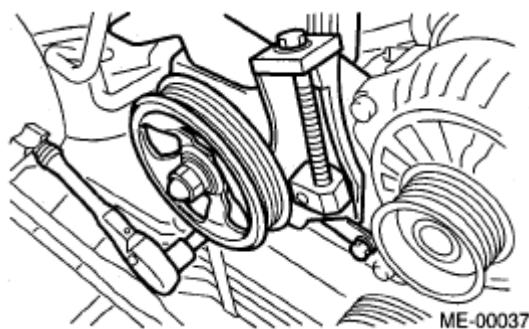


Fig. 51: Identifying Power Steering Pump Bracket Bolts
Courtesy of SUBARU OF AMERICA, INC.

2. Connect the power steering switch connector.

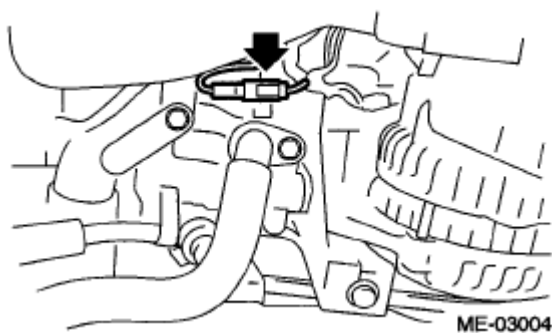


Fig. 52: Connecting Power Steering Switch Connector
Courtesy of SUBARU OF AMERICA, INC.

3. Install and adjust the front side belt. <Ref. to **FRONT SIDE BELT**, INSTALLATION, V-belt. >
12. Lift up the vehicle. >
13. Tighten the bolts and nuts which hold lower side of the transmission to engine.

Tightening torque:

50 N.m (5.1 kgf-m, 36.9 ft-lb)

- AT model

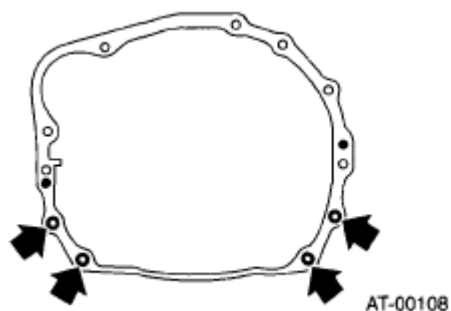


Fig. 53: Locating Lower Side Of Transmission To Engine Bolts - AT Model
Courtesy of SUBARU OF AMERICA, INC.

- MT model

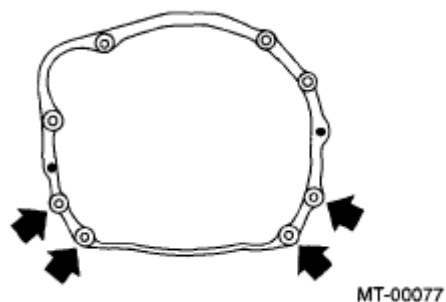


Fig. 54: Locating Lower Side Of Transmission To Engine Bolts - MT Model
Courtesy of SUBARU OF AMERICA, INC.

14. Tighten the nuts which hold the engine mounting to the cross member.

Tightening torque:

85 N.m (8.7 kgf-m, 62.7 ft-lb)

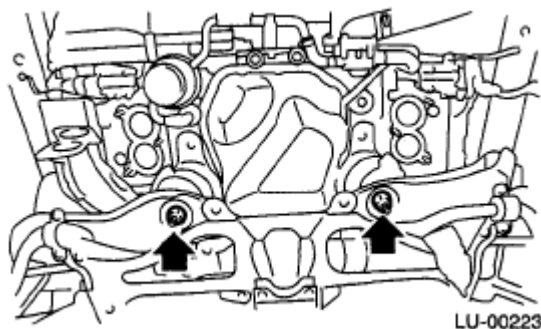


Fig. 55: Locating Front Cross Member Engine Mount Nuts
Courtesy of SUBARU OF AMERICA, INC.

15. Install the engine ground terminal to the cylinder head.

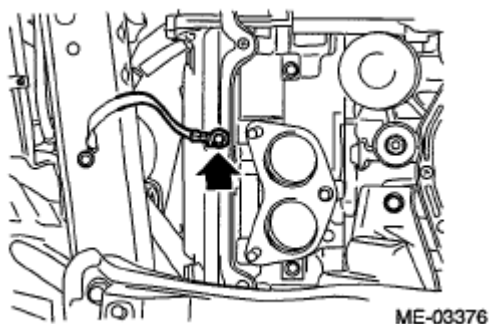


Fig. 56: Locating Engine Ground Terminal
Courtesy of SUBARU OF AMERICA, INC.

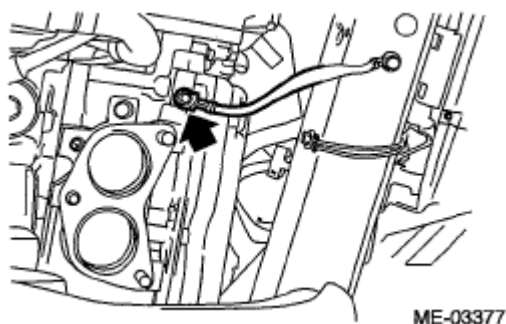


Fig. 57: Locating Engine Ground Terminal
Courtesy of SUBARU OF AMERICA, INC.

16. Install the front and center exhaust pipe.

<Ref. to **INSTALLATION** , Front Exhaust Pipe . >

17. Lower the vehicle.

18. Connect the following hoses.

1. Fuel delivery hose and evaporation hose
2. Heater inlet and outlet hoses
3. Brake booster vacuum hose

19. Connect the following connectors and terminals.

1. Front oxygen (A/F) sensor connector
2. Rear oxygen sensor connector
3. Engine harness connectors
4. Generator connector and terminal

Tightening torque:

15 N.m (1.5 kgf-m, 11.1 ft-lb)

5. A/C compressor connector

20. Install the air intake chamber stay.

Tightening torque:

16 N.m (1.6 kgf-m, 11.8 ft-lb)

21. Tighten the engine ground cable.

Tightening torque:

14 N.m (1.4 kgf-m, 10.1 ft-lb)

22. Install the A/C pressure hoses.

<Ref. to **INSTALLATION** , Hose and Tube . >

23. Install the radiator to vehicle. <Ref. to **INSTALLATION** , Radiator . >

24. install the air intake duct, air cleaner case and air intake chamber. <Ref. to **INSTALLATION** , Air Intake Duct . > <Ref. to **INSTALLATION** , Air Cleaner Case . > <Ref. to **INSTALLATION** , Air Intake Chamber . >

25. Install the under cover.

26. Install the battery in the vehicle, and connect cables.
27. Fill engine coolant.

<Ref. to **FILLING OF ENGINE COOLANT** , REPLACEMENT, Engine Coolant . >

28. Check the ATF level and replenish it if necessary. <Ref. to **INSPECTION** , Automatic Transmission Fluid . >
29. Charge the A/C system with refrigerant. <Ref. to **PROCEDURE** , Refrigerant Charging Procedure . >
30. Install the V-belt cover.

Tightening torque:

13 N.m (1.3 kgf-m, 9.6 ft-lb)

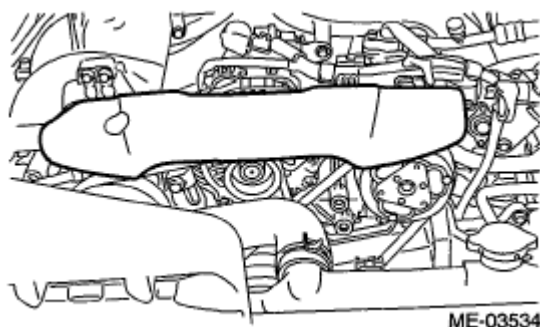


Fig. 58: Identifying V-Belt Covers
Courtesy of SUBARU OF AMERICA, INC.

31. Change the bolt mounting position from (B) to (A), and close the front hood.

Tightening torque:

7.5 N.m (0.76 kgf-m, 5.5 ft-lb)

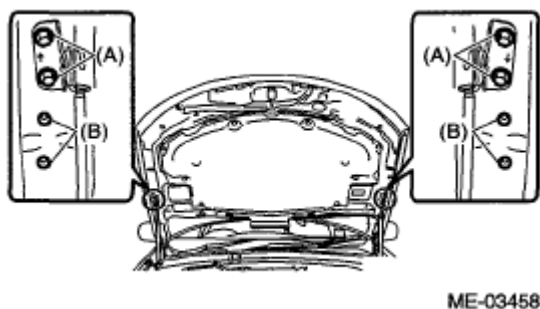


Fig. 59: Identifying Engine Assembly Mounting Bolts
Courtesy of SUBARU OF AMERICA, INC.

32. Lower the vehicle from the lift.

INSPECTION

1. Check that pipes, hoses, connectors and clamps are installed firmly.
2. Check the engine coolant is at specified level.
3. Check the ATF is at specified level. (AT model)
4. Start the engine and check for exhaust gas, engine coolant, leaks of fuel, etc. Also check for noise and vibrations.

ENGINE MOUNTING

REMOVAL

1. Remove the engine unit. <Ref. to **REMOVAL**, Engine Assembly. >
2. Remove the engine mounting from engine assembly.

INSTALLATION

Install in the reverse order of removal.

Tightening torque:

Engine mounting

35 N.m (3.6 kgf-m, 25.8 ft-lb)

INSPECTION

Make sure that no crack or other damages do not exist.

PREPARATION FOR OVERHAUL

PROCEDURE

1. After removing the engine from body, secure it to ST in the following procedure.

ST1 498457000 ENGINE STAND ADAPTER

RH

ST2 498457100 ENGINE STAND ADAPTER

LH

ST3 499817100 ENGINE STAND

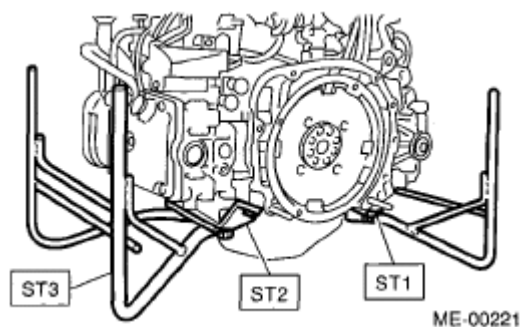


Fig. 60: Identifying Special Tools
 Courtesy of SUBARU OF AMERICA, INC.

2. In this article the procedures described under each index are all connected and stated in order. The procedure for overhauling of the engine will be completed when you go through all steps in the process.

Therefore, in this article, to conduct the particular procedure within the flow of a section, you need to go back and conduct the procedure described previously in order to do that particular procedure.

V-BELT

REMOVAL

NOTE: Perform the work with the engine installed to body when replacing a single part.

FRONT SIDE BELT

1. Remove the V-belt covers.

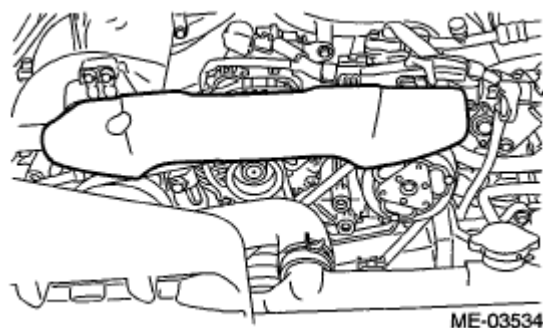


Fig. 61: Identifying V-Belt Covers
 Courtesy of SUBARU OF AMERICA, INC.

2. Remove the air intake duct. <Ref. to **REMOVAL** , Air Intake Duct . >
3. Loosen the bolt (A).
4. Loosen the slider bolt (B).
5. Remove the front side belt (C).

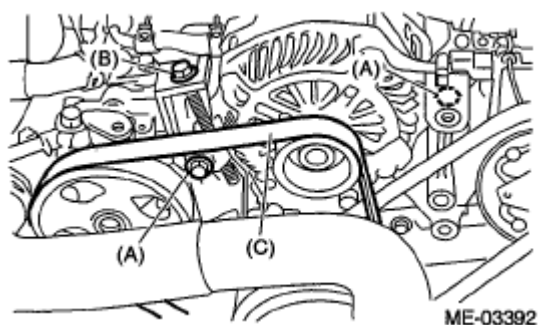


Fig. 62: Identifying Slider Bolt And Front Side Belt
 Courtesy of SUBARU OF AMERICA, INC.

REAR SIDE BELT

1. Remove the front side belts. <Ref. to **FRONT SIDE BELT**, REMOVAL, V-belt. >
2. Cut the rear side belt with a wire cutter, etc., and discard.

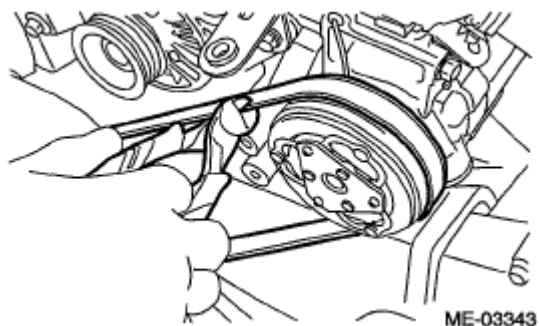


Fig. 63: Cutting Rear Side Belt
 Courtesy of SUBARU OF AMERICA, INC.

INSTALLATION

FRONT SIDE BELT

CAUTION:

- When reusing the front side belt, wipe off any sand or water with a cloth.
- Do not use the front side belt if there is any oil, grease or coolant on the belt.
- Be careful when touching the belt. If the end face of the belt is rubbed by hand, you may receive injury from bared wires.

1. Wipe off any sand, dust, oil or water from the pulley grooves with a cloth.
2. Install the front side belt (C), and adjust the slider bolt (B) so as to obtain the specified belt tension. <Ref. to **INSPECTION**, V-belt. >
3. Tighten the bolt (A).

4. Tighten the slider bolt (B).

Tightening torque:

Bolt (A)

25 N.m (2.5 kgf-m, 18.4 ft-lb)

Slider bolt (B)

8 N.m (0.8 kgf-m, 5.9 ft-lb)

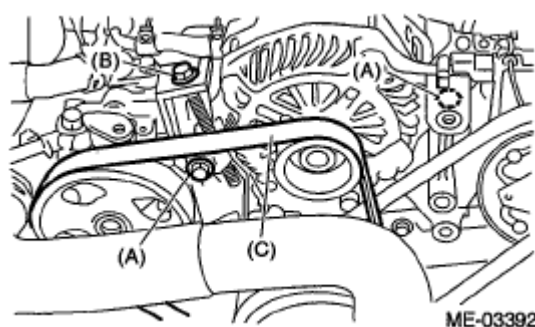


Fig. 64: Identifying Slider Bolt And Front Side Belt
Courtesy of SUBARU OF AMERICA, INC.

5. Install the air intake duct. <Ref. to **INSTALLATION** , Air Intake Duct . >
6. Install the V-belt cover.

Tightening torque:

13 N.m (1.3 kgf-m, 9.6 ft-lb)

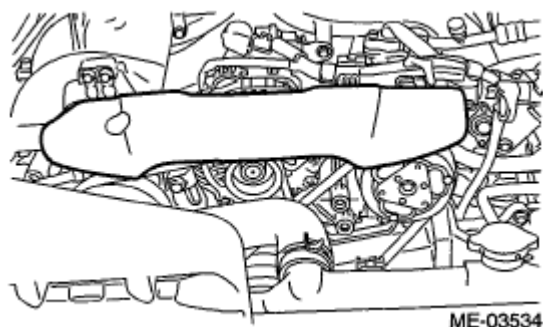


Fig. 65: Identifying V-Belt Covers
Courtesy of SUBARU OF AMERICA, INC.

REAR SIDE BELT

CAUTION:

- Always use new rear side belt.
- Be careful that the new rear side belt does not come into contact with any oil, grease or coolant.
- Be careful when touching the belt. If the end face of the belt is rubbed by hand, you may receive injury from bared wires.
- When installing the rear side belt, always use the provided tools (belt stopper, belt guide, belt guide holder and bolt).

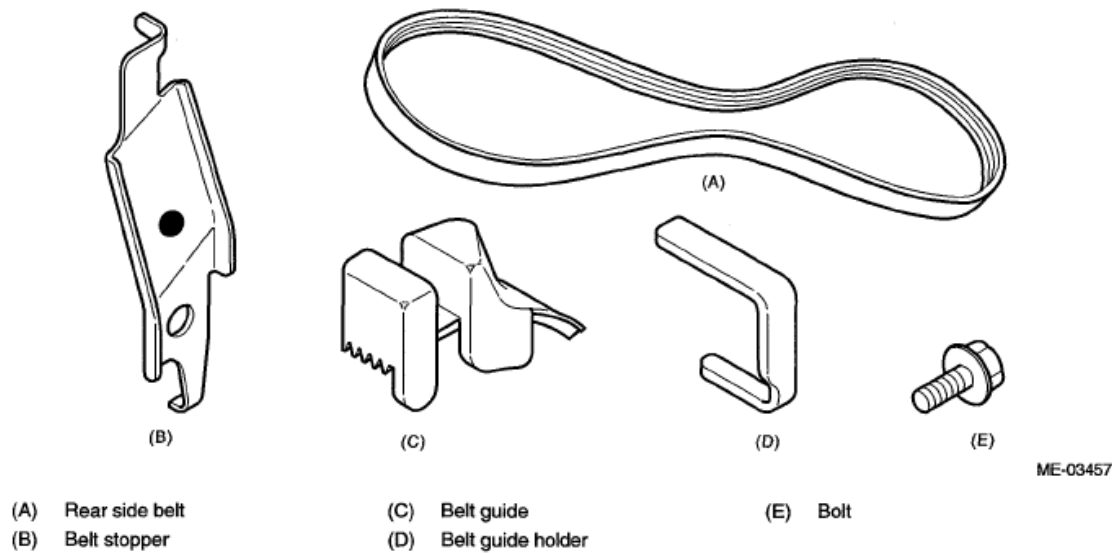


Fig. 66: Identifying Rear Side Belt

Courtesy of SUBARU OF AMERICA, INC.

1. Wipe off any sand, dust, oil or water from the pulley grooves with a cloth.
2. Wipe off any oil, water, mud or rust attached to the front side of the crank pulley with a cloth.
3. Turn the crank pulley to the right slowly, until the crank pulley service hole near the top.

CAUTION: Never turn the crank pulley to the left.

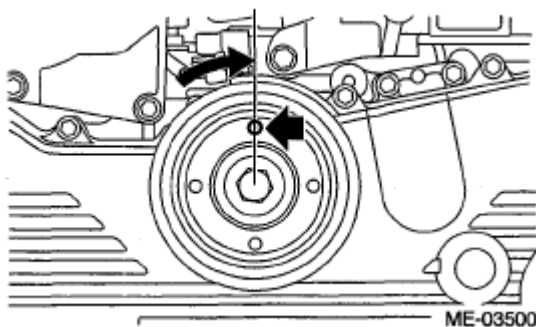


Fig. 67: Turning Crank Pulley

Courtesy of SUBARU OF AMERICA, INC.

4. Attach a new rear side belt on the A/C compressor pulley.

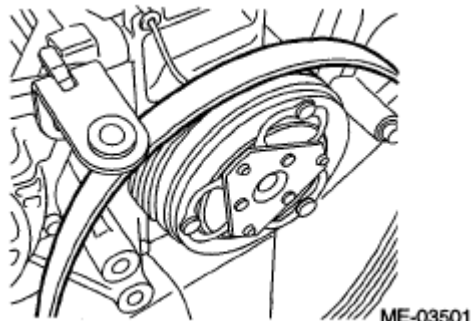


Fig. 68: Attaching Rear Side Belt On A/C Compressor Pulley
Courtesy of SUBARU OF AMERICA, INC.

5. Insert the claw of the belt stopper (A) into the lower hole (B) on the compressor bracket as shown in the figure, and attach using bolt (C).

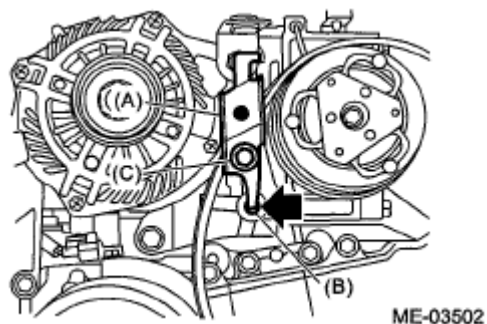


Fig. 69: Identifying Belt Stopper On Compressor Bracket
Courtesy of SUBARU OF AMERICA, INC.

6. Mount the belt guide by matching to the belt line on the front side belt of the crank pulley.

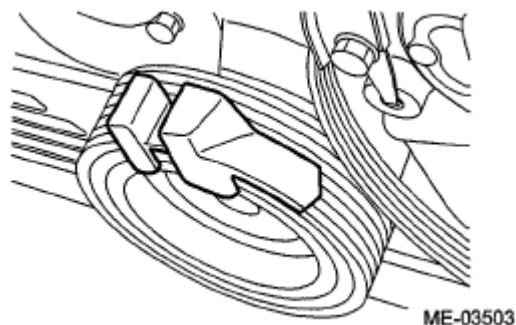


Fig. 70: Mounting Belt Guide
Courtesy of SUBARU OF AMERICA, INC.

7. Insert the belt guide holder into the crank pulley service hole so as to clamp the belt guide.

NOTE: **The longer side of the belt guide holder is the upper side.**

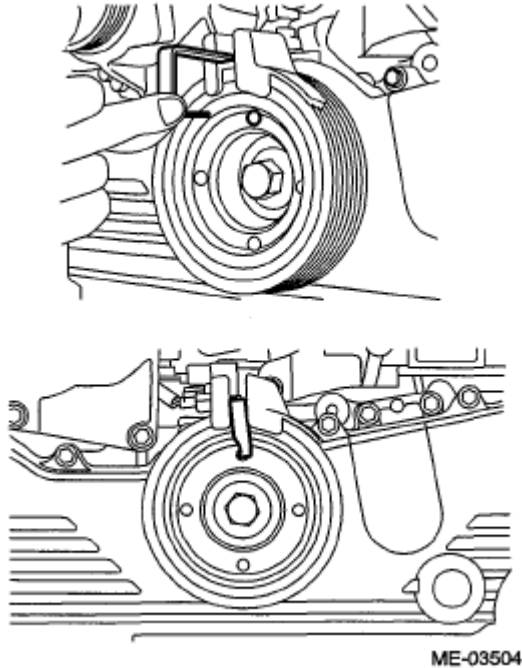


Fig. 71: Inserting Belt Guide Holder Into Crank Pulley Service Hole
Courtesy of SUBARU OF AMERICA, INC.

8. Turn the crank pulley slowly to the right, and set the belt guide at an approximately 45° position.

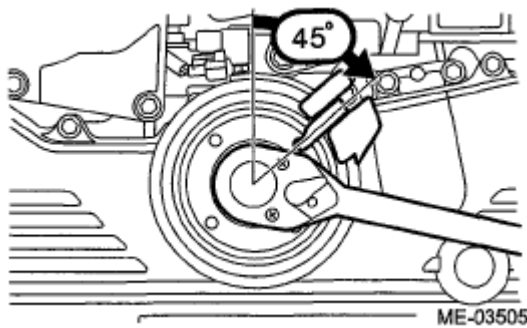


Fig. 72: Turning Crank Pulley
Courtesy of SUBARU OF AMERICA, INC.

9. Place the rib face of the rear side belt onto the grooves of the crank pulley, and sandwich the rear side belt with the belt guide holder.

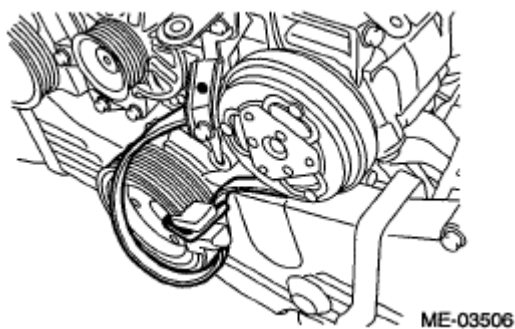


Fig. 73: Placing Rib Face Of Rear Side Belt
Courtesy of SUBARU OF AMERICA, INC.

10. Place the tool through the loop of the rear side belt, and set on the crank pulley bolt.

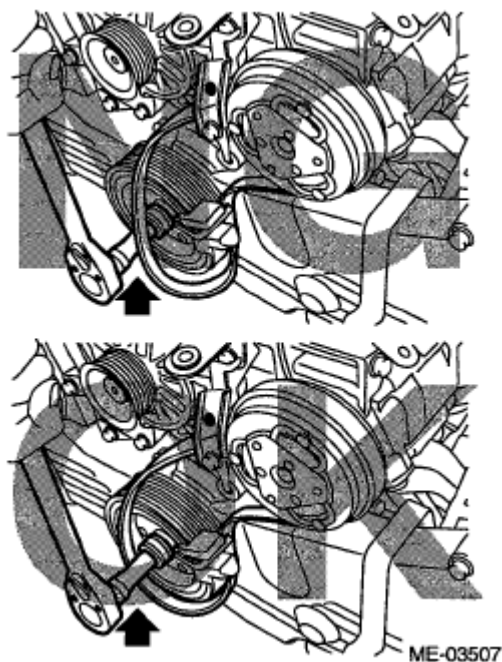
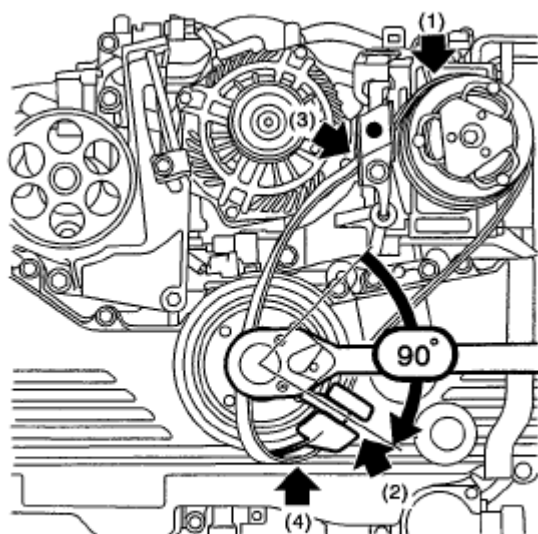


Fig. 74: Placing Tool Through Loop Of Rear Side Belt
Courtesy of SUBARU OF AMERICA, INC.

11. While checking for the following, turn the crank pulley slowly to the right by approximately 90° and set the belt guide to the position shown in the figure.



ME-03508

Fig. 75: Turning Crank Pulley

Courtesy of SUBARU OF AMERICA, INC.

1. The ribs of the rear side belt are properly riding on the grooves of the A/C compressor pulley.

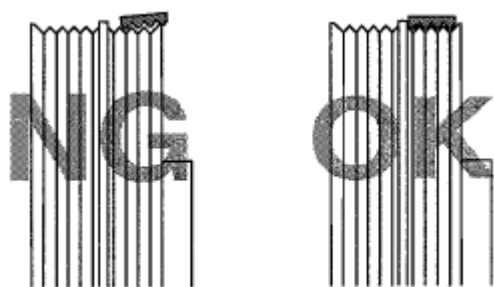


ME-03516

Fig. 76: Identifying Rear Side Belt Correct Position

Courtesy of SUBARU OF AMERICA, INC.

2. The ribs of the rear side belt are properly riding on the grooves of the crank pulley.



ME-03518

Fig. 77: Identifying Rear Side Belt Correct Position

Courtesy of SUBARU OF AMERICA, INC.

3. The surface of the rear side belt is being pressed by the belt stopper.

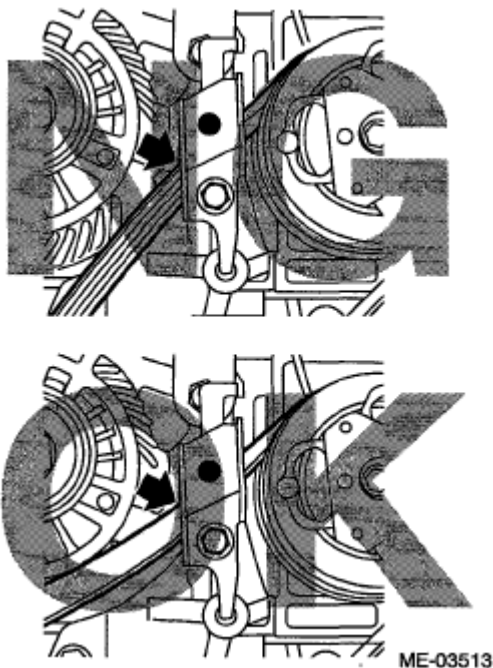


Fig. 78: Identifying Belt Stopper

Courtesy of SUBARU OF AMERICA, INC.

4. The rear side belt is riding properly on the belt guide.

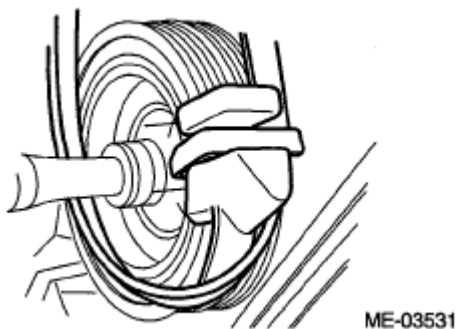
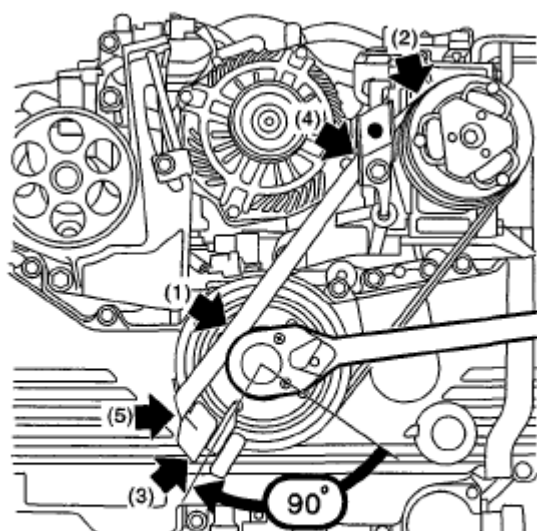


Fig. 79: Riding Rear Side Belt On Belt Guide

Courtesy of SUBARU OF AMERICA, INC.

12. While checking for the following, turn the crank pulley slowly to the right by approximately 90° and set the belt guide to the position shown in the figure.



ME-03509

Fig. 80: Turning Crank Pulley
Courtesy of SUBARU OF AMERICA, INC.

1. The rear side belt is not twisted.

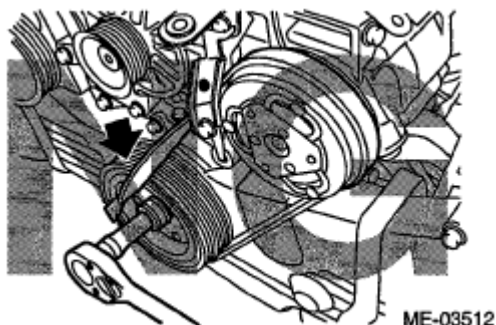


Fig. 81: Identifying Rear Side Belt
Courtesy of SUBARU OF AMERICA, INC.

2. The ribs of the rear side belt are properly riding on the grooves of the A/C compressor pulley.



ME-03516

Fig. 82: Identifying Rear Side Belt Correct Position
Courtesy of SUBARU OF AMERICA, INC.

3. The ribs of the rear side belt are properly riding on the grooves of the crank pulley.

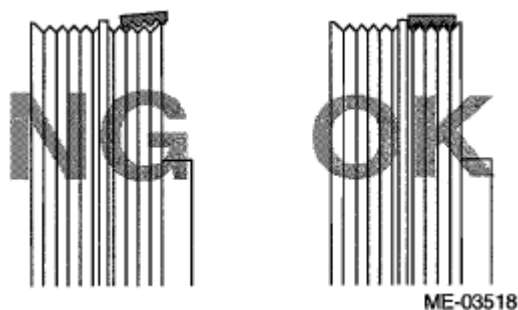


Fig. 83: Identifying Rear Side Belt Correct Position
Courtesy of SUBARU OF AMERICA, INC.

4. The surface of the rear side belt is being pressed by the belt stopper.

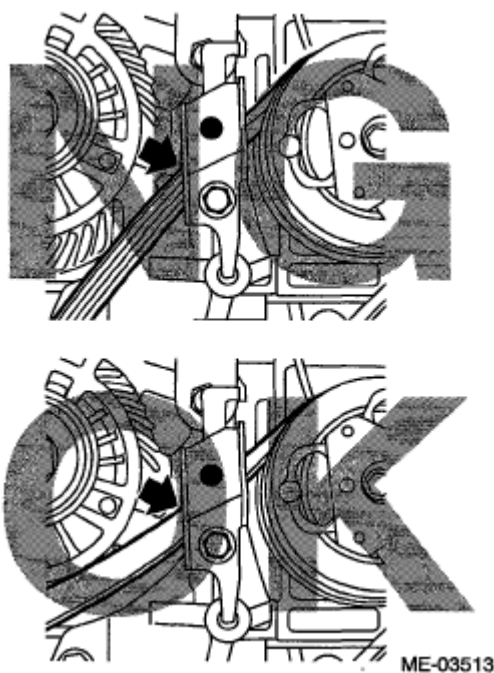


Fig. 84: Identifying Belt Stopper
Courtesy of SUBARU OF AMERICA, INC.

5. The rear side belt is riding properly on the belt guide.

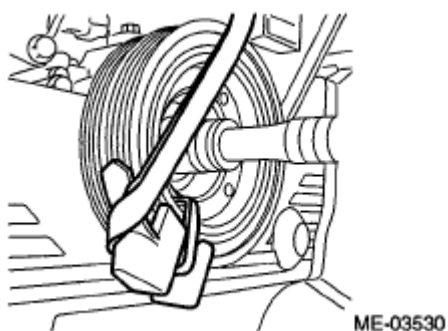


Fig. 85: Riding Rear Side Belt On Belt Guide
Courtesy of SUBARU OF AMERICA, INC.

13. Turn the crank pulley slowly to the right, and attach the rear side belt.

CAUTION: Because there is a possibility of damage to the rear side belt, and the belt guide holder falling off, care must be taken to make sure that the total of steps 8), 11), 12), and 13) does not exceed 330°.

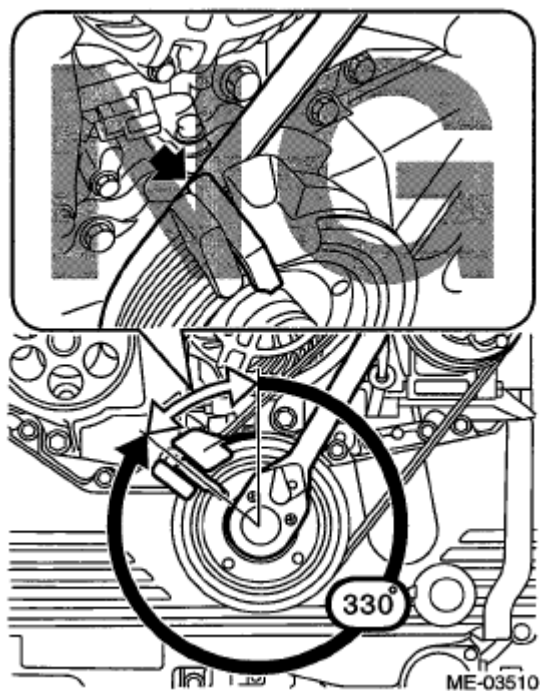


Fig. 86: Turning Crank Pulley
Courtesy of SUBARU OF AMERICA, INC.

14. Remove the belt guide and belt guide holder from the crank pulley.

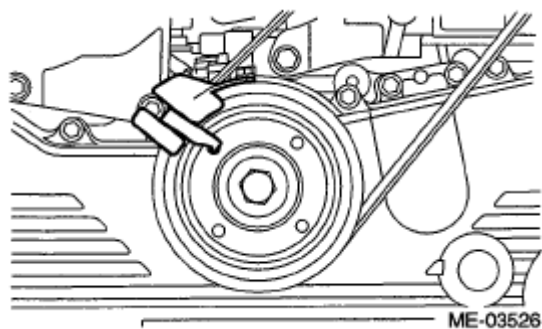


Fig. 87: Removing Belt Guide And Belt Guide Holder
Courtesy of SUBARU OF AMERICA, INC.

15. Remove the belt stopper from the compressor bracket.

CAUTION: Make sure to remove the belt stopper, as leaving it on can cause smoke, flames or belt breakage.

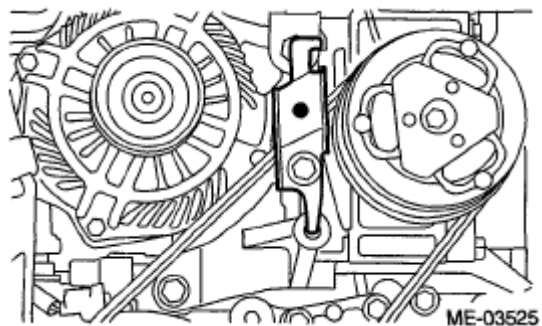


Fig. 88: Identifying Belt Stopper
Courtesy of SUBARU OF AMERICA, INC.

16. Make sure that the belt ribs are properly riding on the grooves of the pulleys, and turn the crank pulley slowly to the right twice to break in the rear side belt.

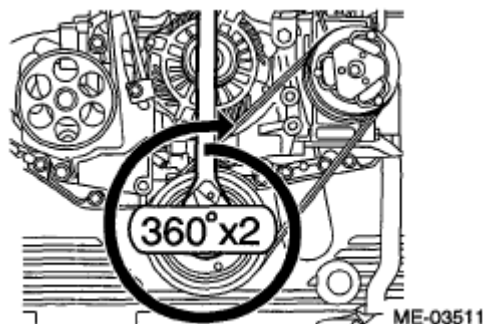


Fig. 89: Turning Crank Pulley
Courtesy of SUBARU OF AMERICA, INC.

17. Discard the provided tools (belt stopper, belt guide, belt guide holder, bolt).
18. Install the front side belt. <Ref. to **FRONT SIDE BELT**, INSTALLATION, V-belt. >

INSPECTION

FRONT SIDE BELT

1. Replace the front side belt, if cracking, fraying or wear is found.
2. Check the front side belt tension and adjust it if necessary by changing the generator installing position.

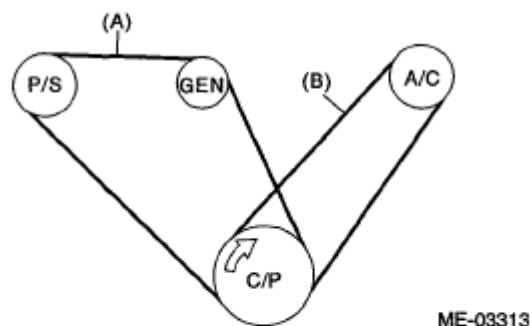
Front side belt tension

(when using a belt tension gauge): When installing new parts

640 - 780 N (65 - 80 kgf, 144 - 175 lbf)

At inspection

490 - 640 N (50 - 65 kgf, 110 - 144 lbf)



- (A) Front side belt
- (B) Rear side belt
- C/P Crank pulley
- GEN Generator
- P/S Power steering oil pump pulley
- A/C Air conditioning compressor pulley

Fig. 90: Identifying Front Side Belt Routing
 Courtesy of SUBARU OF AMERICA, INC.

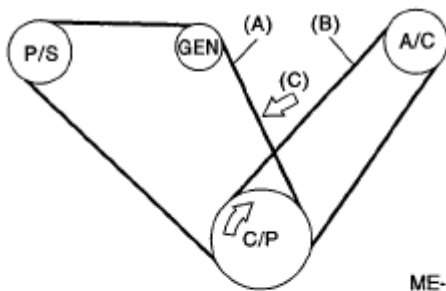
Front side belt tension (when not using a belt tension gauge):

When installing new parts:

7 - 9 mm (0.276 - 0.354 in)

At inspection

9 - 11 mm (0.354 - 0.433 in)



ME-03314

- (A) Front side belt
- (B) Rear side belt
- (C) 98 N (10 kgf, 22 lbf)
- C/P Crank pulley
- GEN Generator
- P/S Power steering oil pump pulley
- A/C Air conditioning compressor pulley

Fig. 91: Identifying Front Side Belt Routing
Courtesy of SUBARU OF AMERICA, INC.

REAR SIDE BELT

If cracks, fraying or wear is found, and when abnormal noise is produced, replace the rear side belt.

NOTE: Because the rear side belt is a stretch type belt, it is not necessary to check deflection and tension.

CRANK PULLEY

REMOVAL

NOTE: Perform the work with the engine installed to body when replacing a single part.

1. Remove the V-belts. <Ref. to **REMOVAL**, V-belt. >
2. Use the ST to lock the crank pulley, and remove the crank pulley bolts.

ST 499977100 CRANK PULLEY WRENCH

(MT model)

ST 499977400 CRANK PULLEY WRENCH

(AT model)

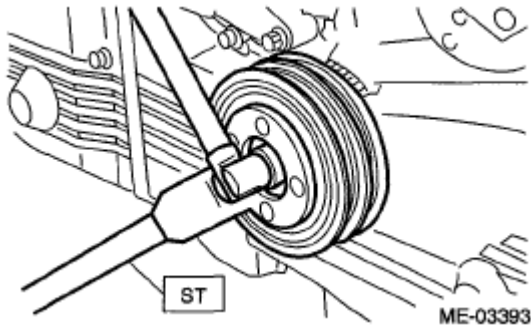


Fig. 92: Identifying Special Tools
Courtesy of SUBARU OF AMERICA, INC.

3. Remove the crank pulley.

INSTALLATION

AT MODEL

1. Install the crank pulley.
2. Use the ST to lock the crank pulley, and attach the crank pulley bolts.

ST 499977400 CRANK PULLEY WRENCH

1. Clean the crankshaft thread using compressed air.
2. Apply engine oil to the crank pulley bolt seat and thread.
3. Tighten the bolts temporarily with tightening torque of 44 N.m (4.5 kgf-m, 32.5 ft-lb).
4. Tighten the crank pulley bolts.

Tightening torque:

130 N.m (13.3 kgf-m, 95.9 ft-lb)

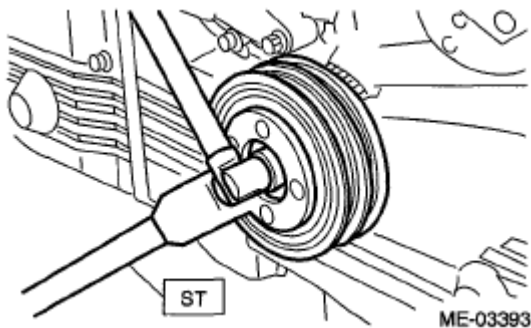


Fig. 93: Identifying Special Tools
Courtesy of SUBARU OF AMERICA, INC.

3. Check that the tightening angle of the crank pulley bolt is 45° or more. Perform the following procedure when less than 45°.

CAUTION: If the tightening angle of crank pulley bolt is less than 45°, the bolt is damaged. In this case, the bolt must be replaced.

1. Replace the crank pulley bolts and clean them.

Crank pulley bolt:

Part No. 12369AA011

2. Clean the crankshaft thread using compressed air.
3. Apply engine oil to the crank pulley bolt seat and thread.
4. Tighten the bolts temporarily with tightening torque of 44 N.m (4.5 kgf-m, 32.5 ft-lb).
5. Tighten the crank pulley bolts 45° to 60°.

NOTE: Conduct the tightening procedures by confirming the turning angle of crank pulley bolt referring to the gauge indicated on timing belt cover.

4. Install the V-belts. <Ref. to **INSTALLATION**, V-belt. >

MT MODEL

1. Install the crank pulley.
2. Use the ST to lock the crank pulley, and attach the crank pulley bolts.

ST 499977100 CRANK PULLEY WRENCH

1. Clean the crankshaft thread using compressed air.
2. Apply engine oil to the crank pulley bolt seat and thread.
3. Tighten the bolts temporarily with tightening torque of 44 N.m (4.5 kgf-m, 32.5 ft-lb).
4. Tighten the crank pulley bolts.

Tightening torque:

180 N.m (18.4 kgf-m, 132.8 ft-lb)

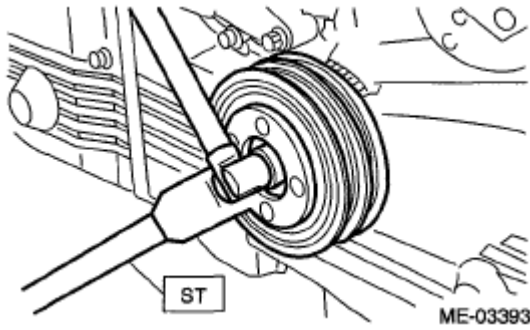


Fig. 94: Identifying Special Tools
Courtesy of SUBARU OF AMERICA, INC.

3. Check that the tightening angle of the crank pulley bolt is 65° or more. Perform the following procedure when less than 65°.

CAUTION: If the tightening angle of crank pulley bolt is less than 65°, the bolt is damaged. In this case, the bolt must be replaced.

1. Replace the crank pulley bolts and clean them.

Crank pulley bolt:

Part No. 12369AA011

2. Clean the crankshaft thread using compressed air.
3. Apply engine oil to the crank pulley bolt seat and thread.
4. Tighten the bolts temporarily with tightening torque of 44 N.m (4.5 kgf-m, 32.5 ft-lb).
5. Tighten the crank pulley bolts 65° to 75°.

NOTE: Conduct the tightening procedures by confirming the turning angle of crank pulley bolt referring to the gauge indicated on timing belt cover.

4. Install the V-belts. <Ref. to INSTALLATION, V-belt. >

INSPECTION

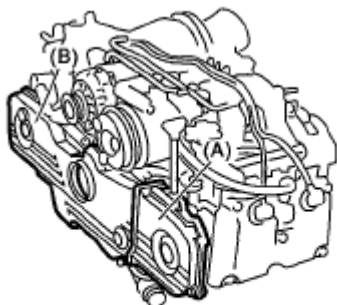
1. Make sure the V-belt is not worn or otherwise damaged.
2. Check the tension of the front side belt. <Ref. to INSPECTION, V-belt. >

TIMING BELT COVER

REMOVAL

NOTE: Perform the work with the engine installed to body when replacing a single part.

1. Remove the V-belts. <Ref. to **REMOVAL**, V-belt. >
2. Remove the crank pulley. <Ref. to **REMOVAL**, Crank Pulley. >
3. Remove the timing belt cover LH.
4. Remove the front timing belt cover.



ME-00821

- (A) Timing belt cover LH
(B) Front timing belt cover

Fig. 95: Identifying Timing Belt Cover
Courtesy of SUBARU OF AMERICA, INC.

INSTALLATION

1. Install the front timing belt cover.

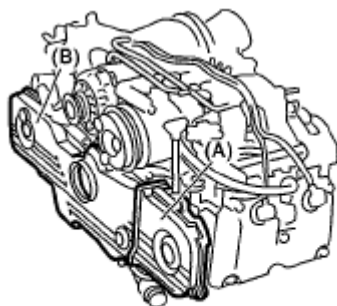
Tightening torque:

5 N.m (0.5 kgf-m, 3.7 ft-lb)

2. Install the timing belt cover LH.

Tightening torque:

5 N.m (0.5 kgf-m, 3.7 ft-lb)



ME-00821

- (A) Timing belt cover LH
(B) Front timing belt cover

Fig. 96: Identifying Timing Belt Cover LH
Courtesy of SUBARU OF AMERICA, INC.

3. Install the crank pulley. <Ref. to **INSTALLATION**, Crank Pulley. >
4. Install the V-belts. <Ref. to **INSTALLATION**, V-belt. >

INSPECTION

Check the cover for damage.

TIMING BELT

REMOVAL

NOTE: Perform the work with the engine installed to body when replacing a single part. For operation procedures, refer to "Timing Belt" in the PM article. <Ref. to **TIMING BELT** . >

TIMING BELT

1. Remove the V-belts. <Ref. to **REMOVAL**, V-belt. >
2. Remove the crank pulley. <Ref. to **REMOVAL**, Crank Pulley. >
3. Remove the timing belt cover. <Ref. to **REMOVAL**, Timing Belt Cover. >
4. Remove the timing belt guide. (MT model)

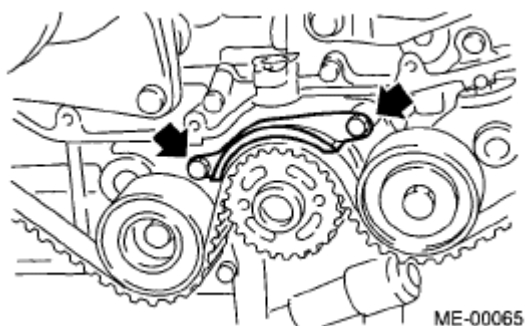


Fig. 97: Locating Timing Belt Guide Bolts
Courtesy of SUBARU OF AMERICA, INC.

5. If the alignment mark or arrow mark (which indicates the direction of rotation) on timing belt fade away, put new marks before removing the timing belt as shown in procedures below.
 1. Use the ST to turn crankshaft. Align the mark (a) of sprocket to the cylinder block notch (b), and then ensure the right side cam sprocket mark (c), cam cap and cylinder head matching surface (d) or left side cam sprocket mark (e), timing belt cover notch (f) are properly adjusted.

ST 499987500 CRANKSHAFT SOCKET

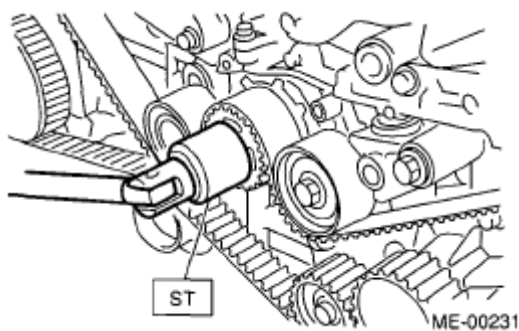
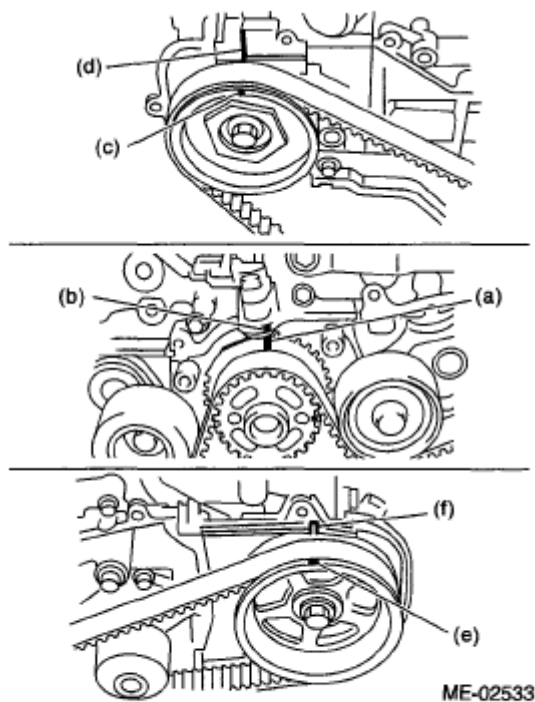


Fig. 98: Identifying Special Tools
Courtesy of SUBARU OF AMERICA, INC.



- (a) (c) (e) Notch
(b) (d) (f) Alignment mark

Fig. 99: Identifying Timing Belt Related Components
Courtesy of SUBARU OF AMERICA, INC.

2. Using white paint, put an alignment mark or an arrow mark on timing belts in relation to the crank sprocket and cam sprockets.

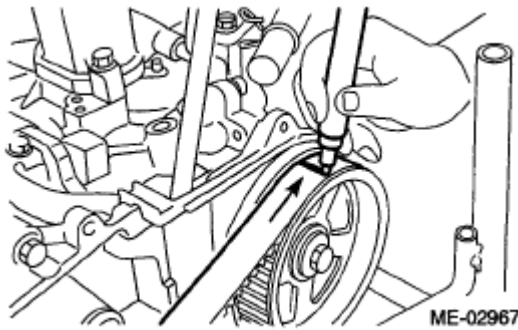


Fig. 100: Putting An Alignment Mark Or An Arrow Mark On Timing Belts
Courtesy of SUBARU OF AMERICA, INC.

Z_1 : 46.8 teeth

Z_2 : 43.7 teeth

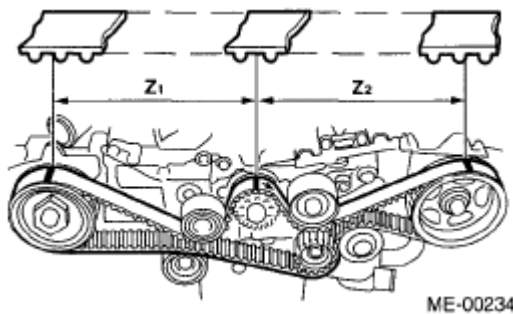


Fig. 101: Identifying Belt Teeth Dimension
Courtesy of SUBARU OF AMERICA, INC.

6. Remove the belt idler (A).
7. Remove the belt idler (B).

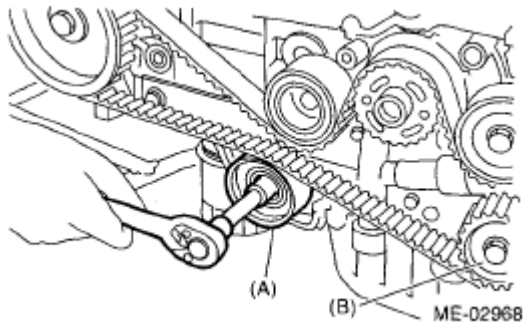


Fig. 102: Removing Belt Idler
Courtesy of SUBARU OF AMERICA, INC.

8. Remove the timing belt.

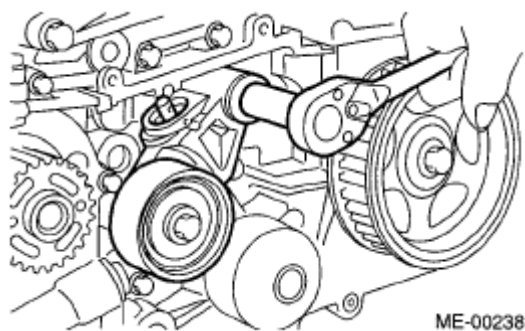


Fig. 103: Identifying Timing Belt
Courtesy of SUBARU OF AMERICA, INC.

BELT IDLER AND AUTOMATIC BELT TENSION ADJUSTER ASSEMBLY

1. Remove the belt idler No. 1.

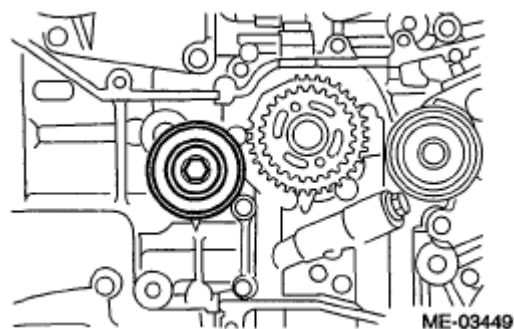


Fig. 104: Removing Belt Idler No. 1
Courtesy of SUBARU OF AMERICA, INC.

2. Remove the automatic belt tension adjuster assembly.

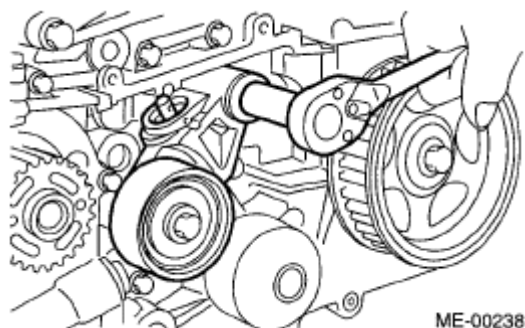


Fig. 105: Removing Automatic Belt Tension Adjuster Assembly
Courtesy of SUBARU OF AMERICA, INC.

INSTALLATION

AUTOMATIC BELT TENSION ADJUSTER ASSEMBLY AND BELT IDLER

1. Prepare for installation of automatic belt tension adjuster assembly.

CAUTION:

- Always use a vertical type pressing tool to move the adjuster rod down.
- Do not use a lateral type vise.
- Push the adjuster rod vertically.
- Press-in the push adjuster rod gradually taking three minutes or more.
- Do not allow press pressure to exceed 9, 807 N (1, 000 kgf, 2, 205 lb).
- Push in the adjuster rod to the end face of the cylinder. However, do not push in the adjuster rod below the end face of the cylinder. Doing so may damage the cylinder.
- Do not release the press pressure until stopper pin is completely inserted.

1. Attach the automatic belt tension adjuster assembly to vertical pressing tool.
2. Slowly push in the adjuster rod with a pressure of 165 N (16.8 kgf, 37.1 lb) or more until the adjuster rod is aligned with the stopper pin hole in the cylinder.

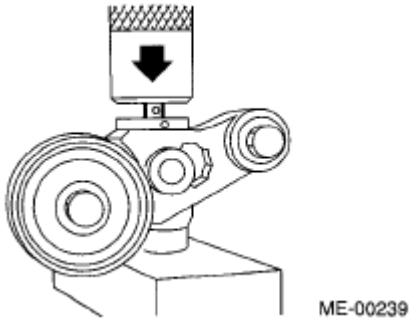


Fig. 106: Attaching Automatic Belt Tension Adjuster Assembly
Courtesy of SUBARU OF AMERICA, INC.

3. With a 2 mm (0.08 in) dia. stopper pin or a 2 mm (nominal) dia. hex wrench inserted into the stopper pin hole in cylinder, secure the adjuster rod.

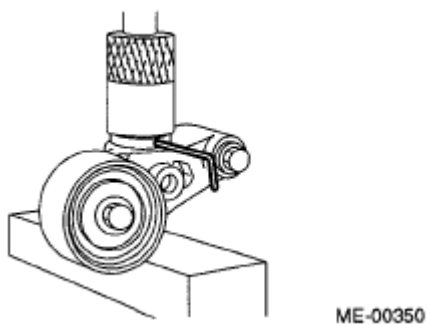


Fig. 107: Inserting Stopper Pin
Courtesy of SUBARU OF AMERICA, INC.

2. Install the automatic belt tension adjuster assembly.

Tightening torque:

39 N.m (4.0 kgf-m, 28.8 ft-lb)

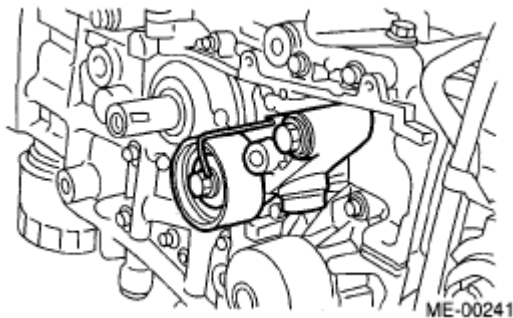


Fig. 108: Identifying Automatic Belt Tension Adjuster Assembly
Courtesy of SUBARU OF AMERICA, INC.

3. Install the belt idler No. 1.

Tightening torque:

39 N.m (4.0 kgf-m, 28.8 ft-lb)

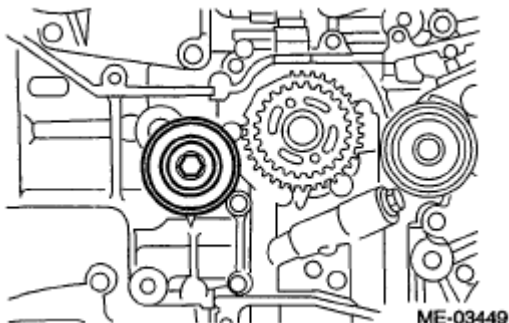
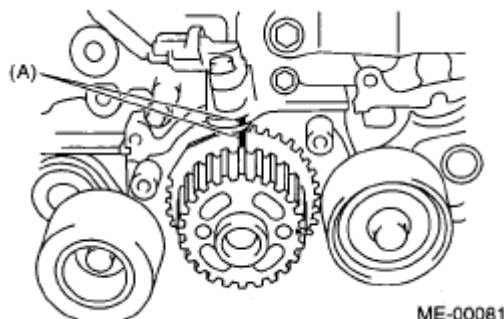


Fig. 109: Identifying Belt Idler No. 1

Courtesy of SUBARU OF AMERICA, INC.

TIMING BELT

1. Prepare for installation of the automatic belt tension adjuster assembly. <Ref. to **AUTOMATIC BELT TENSION ADJUSTER ASSEMBLY AND BELT IDLER, INSTALLATION**, Timing Belt. >
2. Align the mark (A) on crank sprocket with the mark on oil pump cover at cylinder block.

**Fig. 110: Aligning Mark On Crank Sprocket**

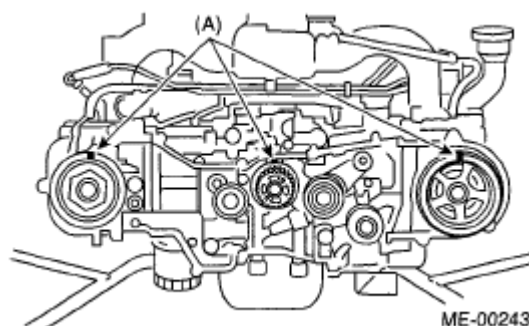
Courtesy of SUBARU OF AMERICA, INC.

3. Turn the camshaft sprocket No. 2 using ST1, and turn the camshaft sprocket No. 1 using ST2 so that their alignment marks (A) come to top positions.

ST1 18231AA010 CAM SPROCKET WRENCH

NOTE: CAM SPROCKET WRENCH (499207100) can also be used.

ST2 499207400 CAM SPROCKET WRENCH

**Fig. 111: Identifying Alignment Marks**

Courtesy of SUBARU OF AMERICA, INC.

4. While aligning the alignment mark (B) on timing belt with the mark (A) on sprockets, position the timing belt properly.

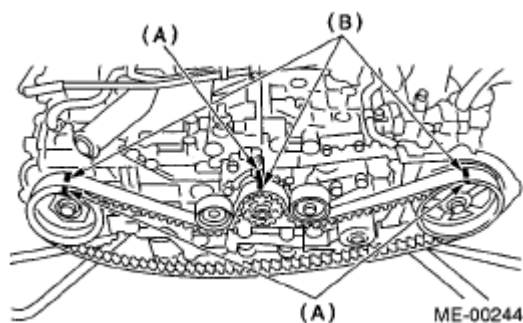


Fig. 112: Aligning Alignment Mark
Courtesy of SUBARU OF AMERICA, INC.

5. Install the belt idler (B).

Tightening torque:

39 N.m (4.0 kgf-m, 28.8 ft-lb)

6. Install the belt idler (A).

Tightening torque:

39 N.m (4.0 kgf-m, 28.8 ft-lb)

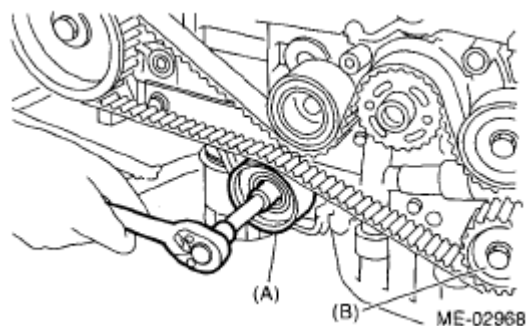


Fig. 113: Installing Belt Idler
Courtesy of SUBARU OF AMERICA, INC.

7. After ensuring the marks on timing belt and camshaft sprockets are aligned, remove the stopper pin from belt tension adjuster.

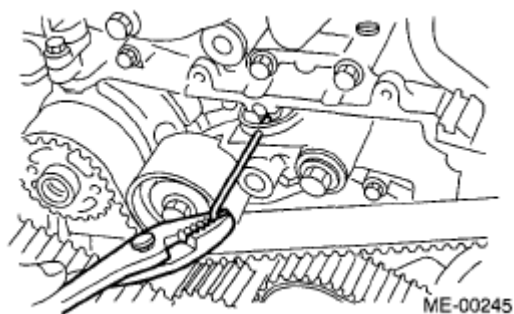


Fig. 114: Removing Stopper Pin
Courtesy of SUBARU OF AMERICA, INC.

8. Install the timing belt guide. (MT model)
 1. Temporarily tighten the bolts mounting the timing belt guide.

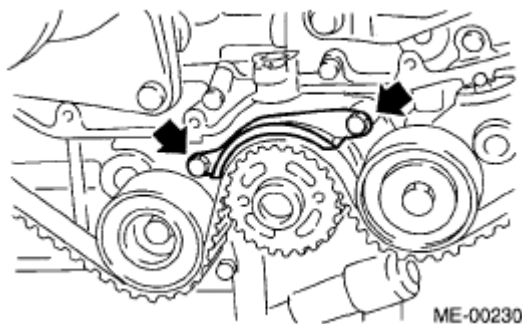


Fig. 115: Locating Timing Belt Guide Bolts
Courtesy of SUBARU OF AMERICA, INC.

2. Check and adjust the clearance between timing belt and timing belt guide by using thickness gauge.

Clearance:

1.0±0.5 mm (0.039±0.020 in)

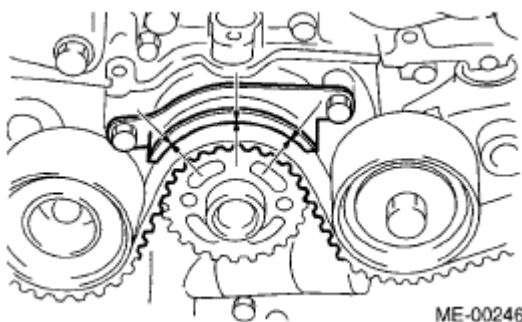


Fig. 116: Adjusting Clearance Between Timing Belt
Courtesy of SUBARU OF AMERICA, INC.

3. Tighten the bolts mounting the timing belt guide.

Tightening torque:

9.75 N.m (1.0 kgf-m, 7.2 ft-lb)

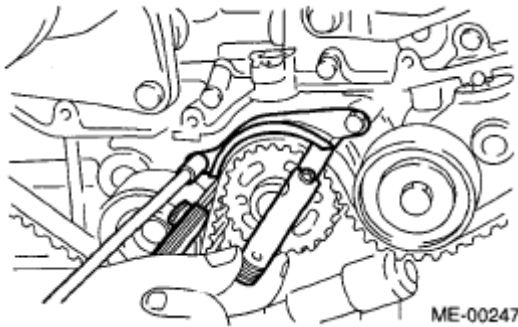


Fig. 117: Tightening Bolts Mounting Timing Belt Guide
Courtesy of SUBARU OF AMERICA, INC.

9. Install the timing belt cover.

<Ref. to **INSTALLATION**, Timing Belt Cover. >

10. Install the crank pulley. <Ref. to **INSTALLATION**, Crank Pulley. >

11. Install the V-belts. <Ref. to **INSTALLATION**, V-belt. >

INSPECTION**TIMING BELT**

1. Check the timing belt teeth for breaks, cracks or wear. If any fault is found, replace the timing belt.
2. Check the condition on the back surface of the timing belt. If cracks are found, replace the belt.

CAUTION:

- Be careful not to let oil, grease or coolant contact the timing belt. Remove quickly and thoroughly if this happens.
- Do not bend the timing belt sharply.

In radial diameter h:

60 mm (2.36 in) or more

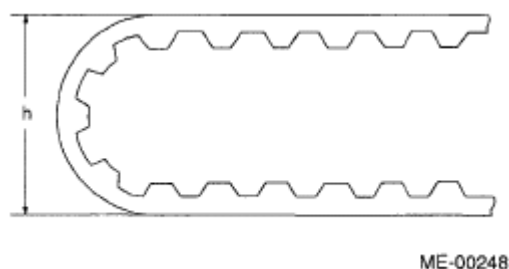


Fig. 118: Identifying Timing Belt Radial Diameter
 Courtesy of SUBARU OF AMERICA, INC.

AUTOMATIC BELT TENSION ADJUSTER

1. Visually check the oil seals for leaks, and rod ends for abnormal wear and scratches. If necessary, replace the automatic belt tension adjuster assembly.

NOTE: **Slight traces of oil at rod's oil seal does not indicate a problem.**

2. Check that the adjuster rod does not move when a pressure of 165 N (16.8 kgf, 37.1 lb) is applied to it. This is to check adjuster rod stiffness.
3. If the adjuster rod is not stiff and moves freely when applying 165 N (16.8 kgf, 37.1 lb), check it using the following procedures:
 1. Slowly press the adjuster rod down to the end surface of cylinder. Repeat this operation two to three times.
 2. With the adjuster rod moved all the way up, apply a pressure of 165 N (16.8 kgf, 37.1 lb) to it. Check the adjuster rod stiffness.
 3. If the adjuster rod is not stiff and moves down, replace the automatic belt tension adjuster assembly with a new part.

CAUTION:

- Always use a vertical type pressing tool to move the adjuster rod down.
- Do not use a lateral type vise.
- Push the adjuster rod vertically.
- Press the adjuster rod gradually taking three minutes or more.
- Do not allow press pressure to exceed 9, 807 N (1, 000 kgf, 2, 205 lb).
- Push in the adjuster rod to the end face of the cylinder. However, do not push in the adjuster rod below the end face of the cylinder. Doing so may damage the cylinder.

4. Measure the amount of rod protrusion "H" from the end surface of the body. If it is not within specified range, replace with new part.

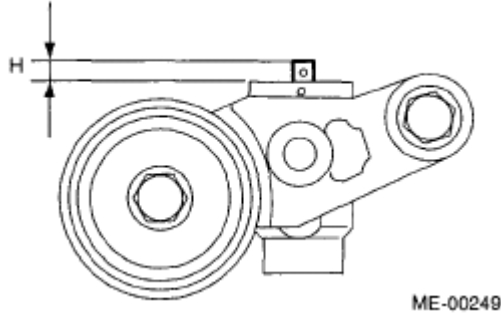
Amount of rod protrusion H:**5.2 - 6.2 mm (0.204 - 0.244 in)**

Fig. 119: Measuring Amount Of Rod Protrusion
Courtesy of SUBARU OF AMERICA, INC.

BELT TENSION PULLEY

1. Check the mating surfaces of timing belt and contact point of adjuster rod for abnormal wear or scratches. Replace the automatic belt tension adjuster assembly with a new part if faulty.
2. Check the belt tension pulley for smooth rotation. Replace if noise or excessive play occurs.
3. Check the belt tension pulley for grease leakage.

BELT IDLER

1. Check the belt idler for smooth rotation. Replace if noise or excessive play occurs.
2. Check the outer contacting surfaces of idler pulley for abnormal wear and scratches.
3. Check the belt idler for grease leakage.

CAM SPROCKET**REMOVAL**

NOTE: Perform the work with the engine installed to body when replacing a single part.

1. Remove the V-belts. <Ref. to **REMOVAL**, V-belt. >
2. Remove the crank pulley. <Ref. to **REMOVAL**, Crank Pulley. >
3. Remove the timing belt cover. <Ref. to **REMOVAL**, Timing Belt Cover. >
4. Remove the timing belt. <Ref. to **REMOVAL**, Timing Belt. >
5. Remove the camshaft position sensor. <Ref. to **REMOVAL**, Camshaft Position Sensor. >
6. Fasten the cam sprocket and remove from the cam shaft using ST.

ST 18231AA010 CAM SPROCKET WRENCH

NOTE: CAM SPROCKET WRENCH (499207100) can also be used.

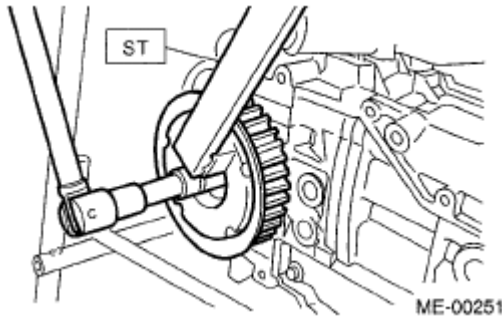


Fig. 120: Identifying Special Tools
Courtesy of SUBARU OF AMERICA, INC.

INSTALLATION

1. Fasten the cam sprocket and install to the cam shaft using ST.

NOTE: Do not confuse left and right side cam sprockets during installation. They should be distinguished by the L or R indication.

ST 18231AA010 CAM SPROCKET WRENCH

NOTE: CAM SPROCKET WRENCH (499207100) can also be used.

Tightening torque:

78 N.m (8.0 kgf-m, 57.5 ft-lb)

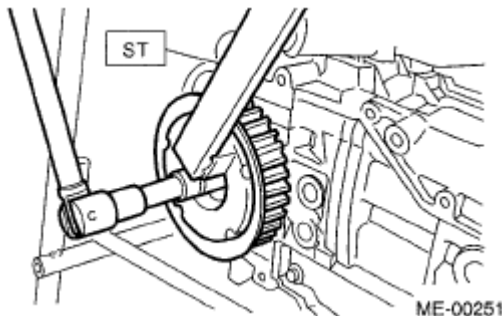


Fig. 121: Identifying Special Tools
Courtesy of SUBARU OF AMERICA, INC.

2. Install the camshaft position sensor. <Ref. to **INSTALLATION**, Camshaft Position Sensor . >
3. Install the timing belt. <Ref. to **INSTALLATION**, Timing Belt. >
4. Install the timing belt cover.

<Ref. to **INSTALLATION**, Timing Belt Cover. >

5. Install the crank pulley. <Ref. to **INSTALLATION**, Crank Pulley. >
6. Install the V-belts. <Ref. to **INSTALLATION**, V-belt. >

INSPECTION

1. Check the cam sprocket teeth for abnormal wear and scratches.
2. Make sure there is no free play between cam sprocket and key.
3. Check the cam sprocket protrusion used for sensor for damage and contamination of foreign matter.

CRANK SPROCKET

REMOVAL

NOTE: Perform the work with the engine installed to body when replacing a single part.

1. Remove the V-belts. <Ref. to **REMOVAL**, V-belt. >
2. Remove the crank pulley. <Ref. to **REMOVAL**, Crank Pulley. >
3. Remove the timing belt cover. <Ref. to **REMOVAL**, Timing Belt Cover. >
4. Remove the timing belt. <Ref. to **REMOVAL**, Timing Belt. >
5. Remove the crank sprocket.

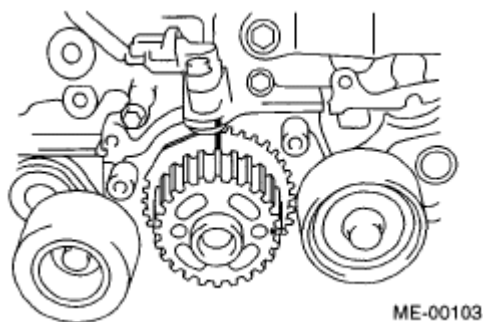


Fig. 122: Removing Crank Sprocket
Courtesy of SUBARU OF AMERICA, INC.

INSTALLATION

1. Install the crank sprocket.

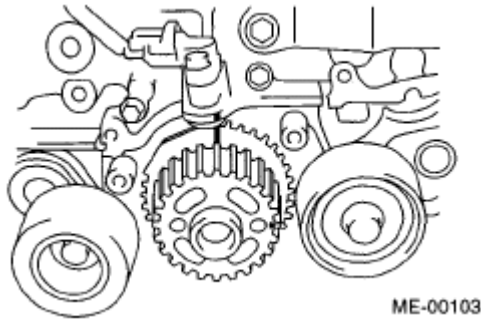


Fig. 123: Installing Crank Sprocket
Courtesy of SUBARU OF AMERICA, INC.

2. Install the timing belt. <Ref. to **INSTALLATION**, Timing Belt. >
3. Install the timing belt cover.

<Ref. to **INSTALLATION**, Timing Belt Cover. >

4. Install the crank pulley. <Ref. to **INSTALLATION**, Crank Pulley. >
5. Install the V-belts. <Ref. to **INSTALLATION**, V-belt. >

INSPECTION

1. Check the crank sprocket teeth for abnormal wear and scratches.
2. Make sure there is no free play between crank sprocket and key.
3. Check the crank sprocket protrusion used for sensor for damage and contamination of foreign matter.

VALVE ROCKER ASSEMBLY

REMOVAL

NOTE: Perform the work with the engine installed to body when replacing a single part. Refer to "**VALVE CLEARANCE**" for preparation. <Ref. to **VALVE CLEARANCE**. >

1. Remove the V-belts. <Ref. to **REMOVAL**, V-belt. >
2. Remove the crank pulley. <Ref. to **REMOVAL**, Crank Pulley. >
3. Remove the timing belt cover. <Ref. to **REMOVAL**, Timing Belt Cover. >
4. Remove the timing belt. <Ref. to **REMOVAL**, Timing Belt. >
5. Remove the cam sprocket. <Ref. to **REMOVAL**, Cam Sprocket. >
6. Remove the high tension cord.
7. Disconnect the PCV hose and remove the rocker cover.
8. Remove the valve rocker assembly.
 1. Use the ST to rotate the spring stopper in the direction of the arrow to remove it from adjuster pin.

ST 18258AA000 SPRING INSTALLER

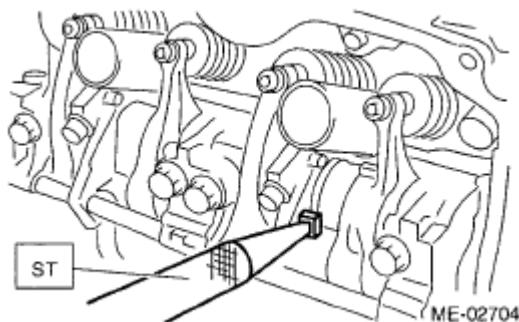
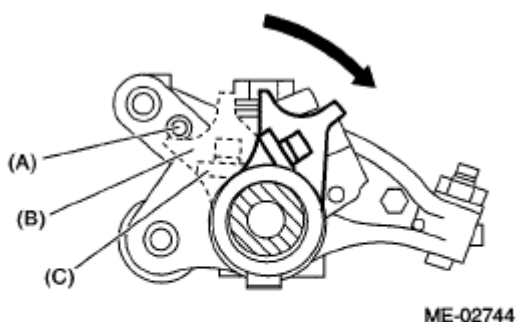


Fig. 124: Identifying Special Tool
 Courtesy of SUBARU OF AMERICA, INC.



- (A) Adjuster pin
- (B) Spring stopper
- (C) Spring

Fig. 125: Identifying Adjusting Pin, Spring Stopper And Spring
 Courtesy of SUBARU OF AMERICA, INC.

2. Remove the bolts (a) through (j) in alphabetical sequence.

NOTE: Leave two or three threads of bolts (i) and (j) engaged in order to retain the valve rocker assembly.

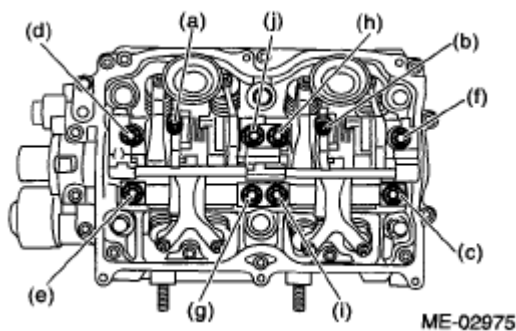


Fig. 126: Identifying Valve Rocker Assembly Bolts Torque Sequence

Courtesy of SUBARU OF AMERICA, INC.

3. Remove the valve rocker assembly.

NOTE: Set the ST in the position shown in the drawing to remove the intake valve rocker assembly.

ST 18354AA000 VALVE ROCKER HOLDER

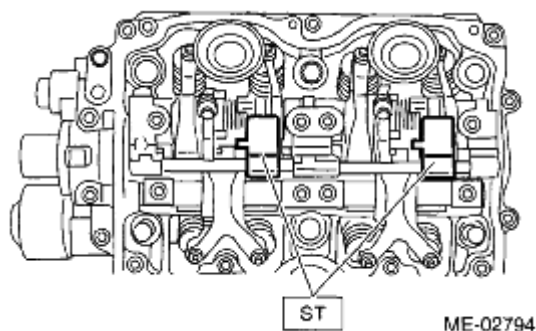


Fig. 127: Identifying Special Tool
Courtesy of SUBARU OF AMERICA, INC.

INSTALLATION

1. Install the valve rocker assembly.
 1. Temporarily tighten the bolts equally in alphabetical order as shown in the figure.

NOTE:

- Do not temporarily tighten the bolts (i) and (j).
- Set the ST in the position shown in the drawing to mount the intake valve rocker assembly.

ST 18354AA000 VALVE ROCKER HOLDER

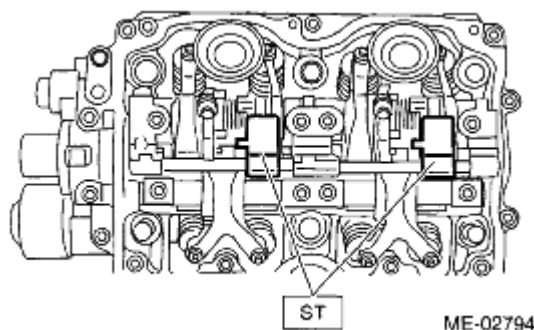


Fig. 128: Identifying Special Tool
Courtesy of SUBARU OF AMERICA, INC.

2. Tighten the bolts (a) through (h) to specified torque.

Tightening torque:

25 N.m (2.5 kgf-m, 18.4 ft-lb)

3. Tighten the bolts (i) through (j) to specified torque.

Tightening torque:

6 N.m (0.6 kgf-m, 4.3 ft-lb)

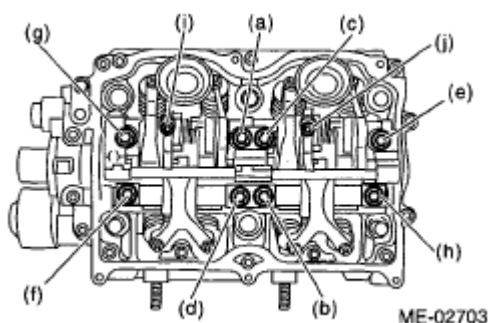


Fig. 129: Identifying Valve Rocker Assembly Bolts Torque Sequence
 Courtesy of SUBARU OF AMERICA, INC.

4. Use the ST to rotate the spring stopper in the direction of the arrow to fasten the adjuster pin.

ST 18258AA000 SPRING INSTALLER

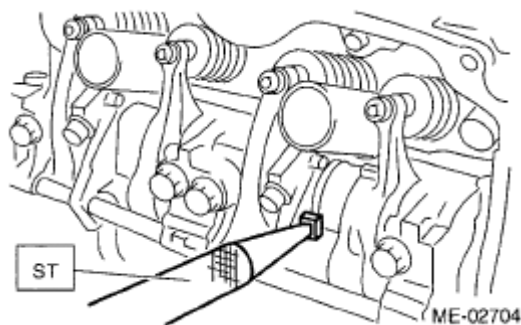
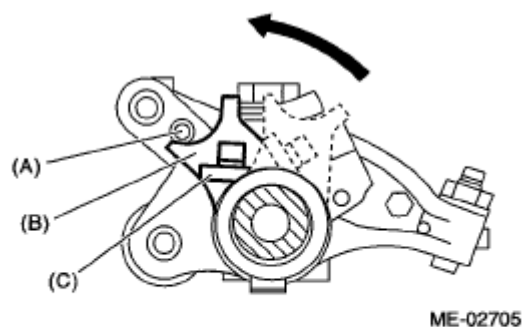


Fig. 130: Identifying Special Tool
 Courtesy of SUBARU OF AMERICA, INC.



- (A) Adjuster pin
- (B) Spring stopper
- (C) Spring

Fig. 131: Identifying Adjusting Pin, Spring Stopper And Spring
 Courtesy of SUBARU OF AMERICA, INC.

2. Install the cam sprocket. <Ref. to INSTALLATION, Cam Sprocket. >
3. Install the timing belt. <Ref. to INSTALLATION, Timing Belt. >
4. Adjust the valve clearance. <Ref. to ADJUSTMENT, Valve Clearance. >
5. Install the rocker cover.
 1. Install the rocker cover gasket to the rocker cover.

NOTE: Use a new rocker cover gasket.

2. Temporarily tighten the bolts in alphabetical sequence as shown in figure, then tighten the bolt in 2 steps.

Tightening torque:

1st

6.4 N.m (0.65 kgf-m, 4.7 ft-lb)

2nd (only (a) and (b) are tightened)

6.4 N.m (0.65 kgf-m, 4.7 ft-lb)

RH side

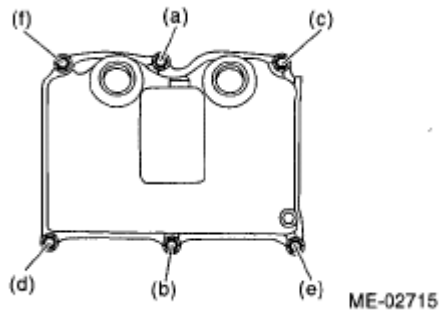


Fig. 132: Identifying Rocker Cover Gasket Bolts Torque Sequence - RH Side
 Courtesy of SUBARU OF AMERICA, INC.

LH side

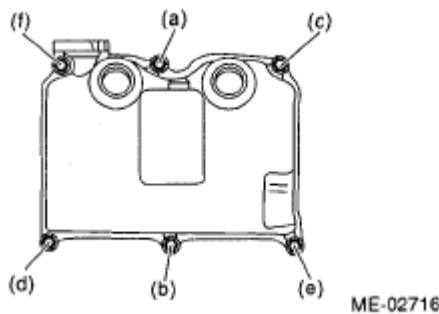


Fig. 133: Identifying Rocker Cover Gasket Bolts Torque Sequence - LH Side
 Courtesy of SUBARU OF AMERICA, INC.

6. Connect the PCV hose.
7. Install the high tension cord.
8. Install the timing belt cover.

<Ref. to **INSTALLATION**, Timing Belt Cover. >

9. Install the crank pulley. <Ref. to **INSTALLATION**, Crank Pulley. >
10. Install the V-belts. <Ref. to **INSTALLATION**, V-belt. >

DISASSEMBLY

NOTE: Intake valve rocker assembly cannot be disassembled.

1. Remove the exhaust valve rocker arm from the rocker shaft.

NOTE: Keep all the removed parts in order for re-installing in their original positions.

2. Remove the nut and adjusting screw from exhaust valve rocker.

ASSEMBLY

NOTE: Intake valve rocker assembly cannot be disassembled.

1. Install the adjusting screw and nut to the exhaust valve rocker.
2. Insert the exhaust valve rocker arm to rocker shaft.

NOTE: Valve rocker arms, and rocker shaft have identification marks. Make sure the parts with same markings are properly assembled.

INSPECTION**INTAKE VALVE ROCKER ASSEMBLY**

1. If the roller or valve contact surface of valve rocker arm is worn or dented excessively, replace the valve rocker assembly.
2. Check that the valve rocker arm roller rotates smoothly. If not, replace the valve rocker assembly.

EXHAUST VALVE ROCKER ASSEMBLY

1. Measure the inner diameter of valve rocker arm and outer diameter of valve rocker shaft, and confirm the difference (oil clearance) between the two values.

Clearance between arm and shaft:

Standard

0.020 - 0.054 mm (0.0008 - 0.0021 in)

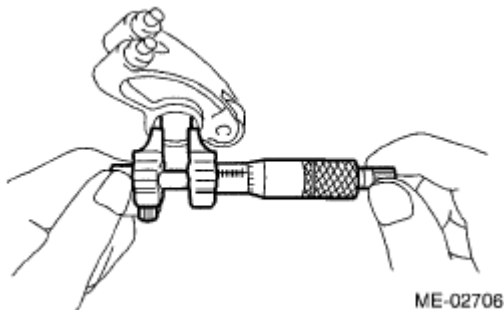


Fig. 134: Measuring Inner Diameter Of Valve Rocker Arm
Courtesy of SUBARU OF AMERICA, INC.

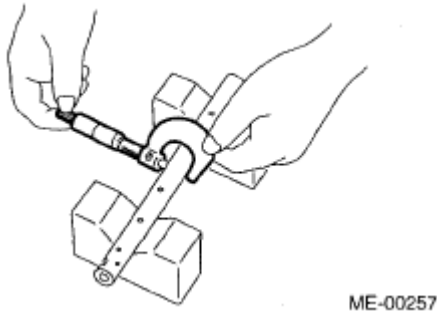


Fig. 135: Measuring Outer Diameter Of Valve Rocker Shaft
 Courtesy of SUBARU OF AMERICA, INC.

2. If the oil clearance exceeds the limit, replace the valve rocker arm or shaft, whichever shows the greater amount of wear.

Rocker arm inside diameter:

22.020 - 22.041 mm (0.8669 - 0.8678 in)

Rocker shaft diameter:

21.987 - 22.000 mm (0.8656 - 0.8661 in)

3. If the roller or valve contact surface of valve rocker arm is worn or dented excessively, replace the valve rocker arm.
4. Check that the valve rocker arm roller rotates smoothly. If not, replace the valve rocker arm.

CAMSHAFT

REMOVAL

NOTE: Perform the work with the engine installed to body when replacing a single part. Refer to "VALVE CLEARANCE" for preparation. <Ref. to VALVE CLEARANCE. >

1. Remove the V-belts. <Ref. to REMOVAL, V-belt. >
2. Remove the crank pulley. <Ref. to REMOVAL, Crank Pulley. >
3. Remove the timing belt cover. <Ref. to REMOVAL, Timing Belt Cover. >
4. Remove the timing belt. <Ref. to REMOVAL, Timing Belt. >
5. Remove the cam sprocket. <Ref. to REMOVAL, Cam Sprocket. >
6. Remove the timing belt cover No. 2 LH.
7. Remove the timing belt cover No. 2 RH.

NOTE: Do not damage or lose the seal rubber when removing the timing belt covers.

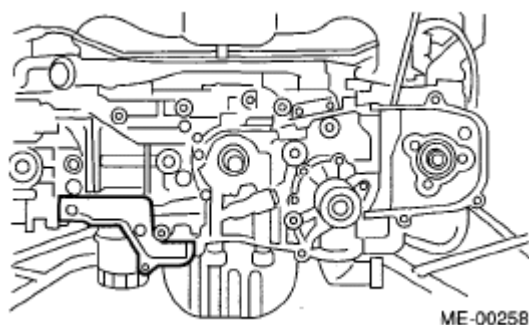


Fig. 136: Identifying Timing Belt Cover
Courtesy of SUBARU OF AMERICA, INC.

8. Remove the tensioner bracket.

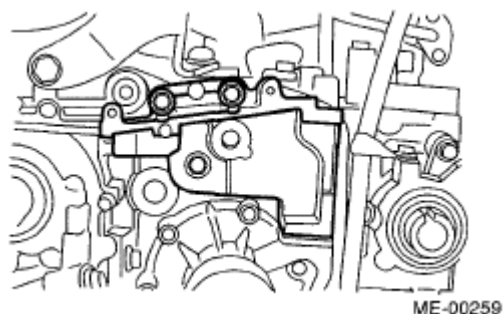


Fig. 137: Identifying Tensioner Bracket
Courtesy of SUBARU OF AMERICA, INC.

9. Remove the camshaft position sensor support. (LH side only)
10. Remove the valve rocker assembly. <Ref. to **REMOVAL**, Valve Rocker Assembly. >
11. Remove the camshaft cap.
 1. Remove the bolts (a) and (b) in alphabetical sequence.

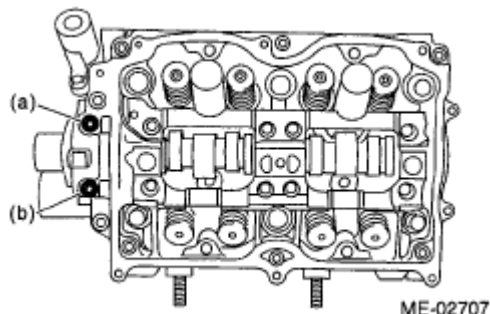


Fig. 138: Identifying Camshaft Cap Bolts
Courtesy of SUBARU OF AMERICA, INC.

2. Equally loosen the bolts (c) through (j) all the way in alphabetical sequence.

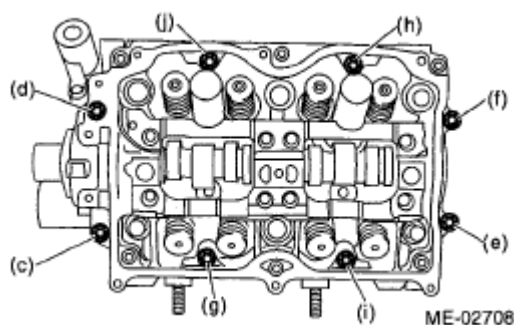


Fig. 139: Identifying Bolts Torque Sequence
Courtesy of SUBARU OF AMERICA, INC.

3. Remove the bolts (k) through (p) in alphabetical sequence using ST.

ST 499497000 TORX® PLUS

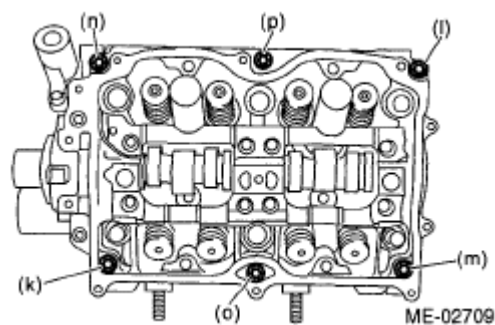


Fig. 140: Identifying Camshaft Cap Bolts Torque Sequence
Courtesy of SUBARU OF AMERICA, INC.

4. Remove the camshaft cap.
12. Remove the camshaft.
13. Remove the oil seal.
14. Remove the plug from rear side of camshaft.

CAUTION: Do not scratch the journal surface when removing the oil seal.

15. Similarly, remove the camshaft RH and related parts.

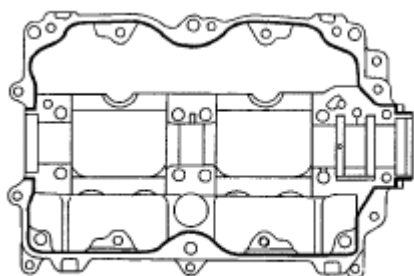
INSTALLATION

1. Apply a thin coat of engine oil to camshaft journals, and install the camshaft.
2. Install the camshaft cap.
 1. Apply liquid gasket to the mating surfaces of camshaft cap.

NOTE: Install within 5 min. after applying liquid gasket.

Liquid gasket:

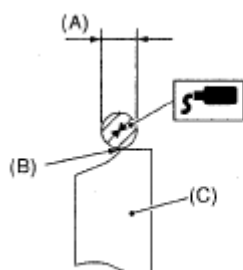
THREE BOND 1217G (Part No. K0877Y0100) or equivalent



ME-02710

Fig. 141: Applying Liquid Gasket To Mating Surfaces
Courtesy of SUBARU OF AMERICA, INC.

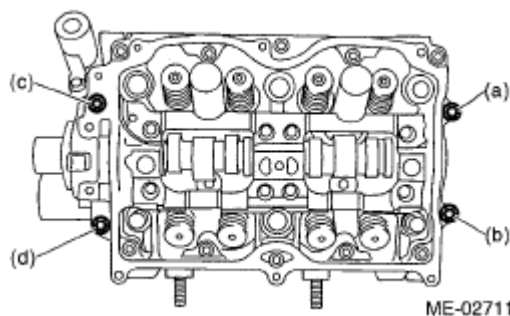
NOTE: Apply a coat of liquid gasket of 3 mm (0.12 in) in diameter (A) along the edge (B) of camshaft cap (C) mating surface.



ME-00265

Fig. 142: Identifying Liquid Gasket Applying Location
Courtesy of SUBARU OF AMERICA, INC.

2. Temporarily tighten the bolts (a) through (d) in alphabetical sequence.



ME-02711

Fig. 143: Identifying Valve Rocker Assembly Bolts Torque Sequence
Courtesy of SUBARU OF AMERICA, INC.

3. Install the valve rocker assembly.

<Ref. to **INSTALLATION**, Valve Rocker Assembly. >

4. Tighten the TORX® bolts (e) through (l) in alphabetical sequence using the ST.

ST 499497000 TORX® PLUS

Tightening torque:

18 N.m (1.8 kgf-m, 13.3 ft-lb)

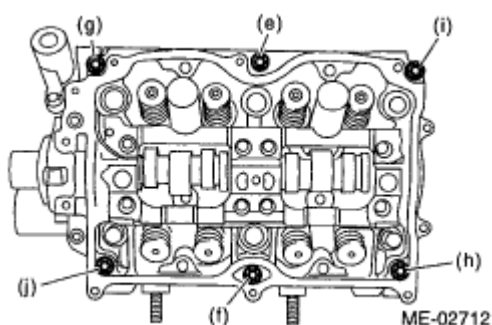


Fig. 144: Identifying Valve Rocker Assembly Bolts Torque Sequence
Courtesy of SUBARU OF AMERICA, INC.

5. Tighten the bolts (k) through (r) in alphabetical sequence.

Tightening torque:

9.75 N.m (1.0 kgf-m, 7.2 ft-lb)

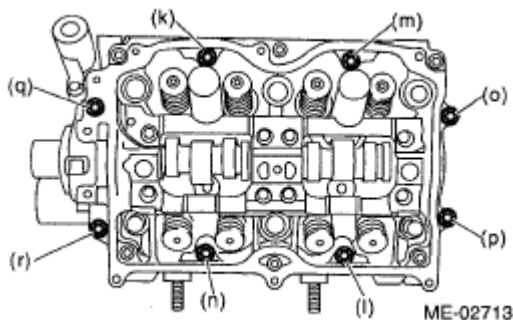


Fig. 145: Identifying Valve Rocker Assembly Bolts Torque Sequence
Courtesy of SUBARU OF AMERICA, INC.

6. Tighten the bolts (s) and (t) in alphabetical sequence.

NOTE:

- Use a new seal washer.

- Install and tighten the seal washer to the bolt.

Tightening torque:

9.75 N.m (1.0 kgf-m, 7.2 ft-lb)

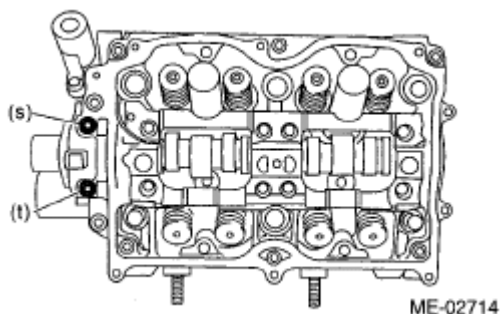


Fig. 146: Identifying Camshaft Cap Bolts Torque Sequence
Courtesy of SUBARU OF AMERICA, INC.

3. Apply a coat of engine oil to camshaft oil seal periphery and oil seal lips and install the oil seal (A) on camshaft using ST1 and ST2.

NOTE: Use a new oil seal.

ST1 499597000 OIL SEAL GUIDE

ST2 499587500 OIL SEAL INSTALLER

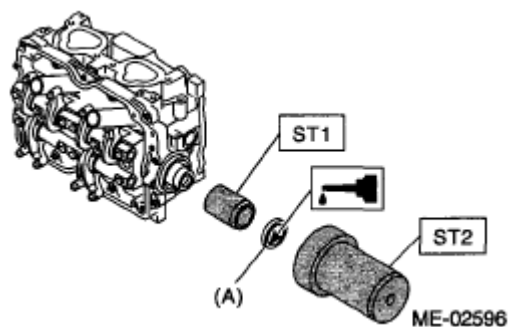


Fig. 147: Identifying Special Tools
Courtesy of SUBARU OF AMERICA, INC.

4. Apply a coat of engine oil to plug periphery and Install the plug (A) using ST.

ST 499587700 CAMSHAFT OIL SEAL INSTALLER

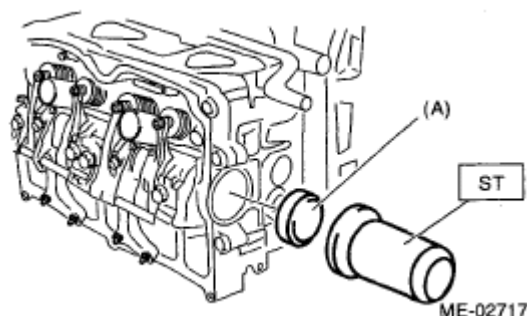


Fig. 148: Identifying Special Tools
Courtesy of SUBARU OF AMERICA, INC.

5. Install the camshaft position sensor support. (LH side only)

Tightening torque:

6.4 N.m (0.65 kgf-m, 4.7 ft-lb)

6. Similarly, install the parts on right-hand side.
7. Install the tensioner bracket.

Tightening torque:

24.5 N.m (2.5 kgf-m, 18.1 ft-lb)

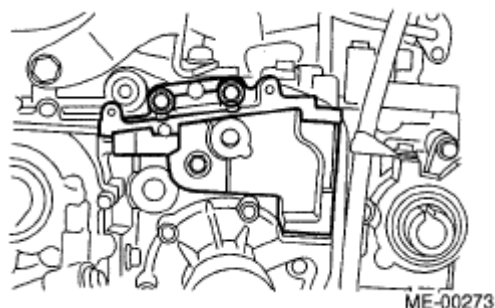


Fig. 149: Identifying Tensioner Bracket
Courtesy of SUBARU OF AMERICA, INC.

8. Install the timing belt cover No. 2 RH.

Tightening torque:

5 N.m (0.5 kgf-m, 3.7 ft-lb)

9. Install the timing belt cover No. 2 (LH).

Tightening torque:

5 N.m (0.5 kgf-m, 3.7 ft-lb)

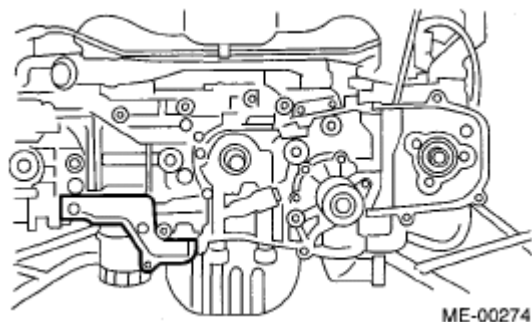


Fig. 150: Identifying Timing Belt Cover
Courtesy of SUBARU OF AMERICA, INC.

10. Install the cam sprocket. <Ref. to INSTALLATION, Cam Sprocket. >
11. Install the timing belt. <Ref. to INSTALLATION, Timing Belt. >
12. Adjust the valve clearance. <Ref. to ADJUSTMENT, Valve Clearance. >
13. Install the rocker cover.
 1. Install the rocker cover gasket to the rocker cover.

NOTE: Use a new rocker cover gasket.

2. Temporarily tighten the bolts in alphabetical sequence as shown in figure, then tighten the bolt in 2 steps.

Tightening torque:

1st

6.4 N.m (0.65 kgf-m, 4.7 ft-lb)

2nd (only (a) and (b) are tightened)

6.4 N.m (0.65 kgf-m, 4.7 ft-lb)

RH side

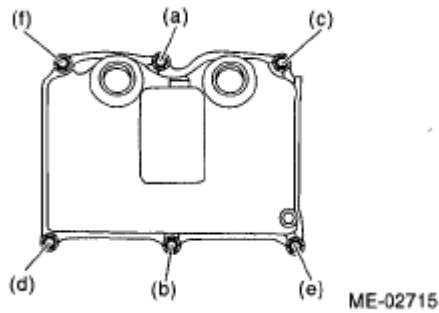


Fig. 151: Identifying Rocker Cover Gasket Bolts Torque Sequence - RH Side
 Courtesy of SUBARU OF AMERICA, INC.

LH side

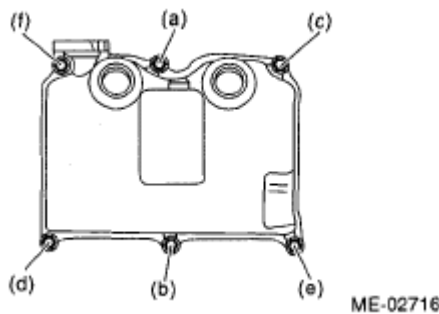


Fig. 152: Identifying Rocker Cover Gasket Bolts Torque Sequence - LH Side
 Courtesy of SUBARU OF AMERICA, INC.

14. Connect the PCV hose.
15. Install the high tension cord.
16. Install the timing belt cover.

<Ref. to **INSTALLATION**, Timing Belt Cover. >

17. Install the crank pulley. <Ref. to **INSTALLATION**, Crank Pulley. >
18. Install the V-belts. <Ref. to **INSTALLATION**, V-belt. >

INSPECTION

CAMSHAFT

1. Measure the bend, and repair or replace if necessary.

Service limit:

0.025 mm (0.00098 in)

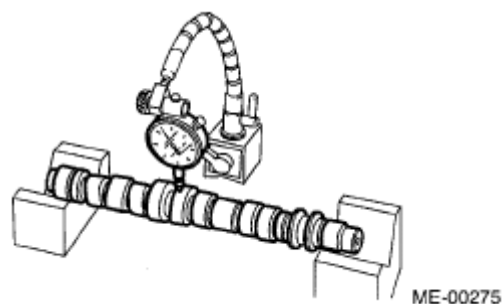


Fig. 153: Measuring Camshaft Bend
 Courtesy of SUBARU OF AMERICA, INC.

2. Check the journal for damage and wear. Replace if faulty.
3. Measure the outer diameter of camshaft journal and inner diameter of cylinder head journal, and check the difference (oil clearance) between the two values. If the oil clearance is not within the standard, replace the camshaft or cylinder head as necessary.

CAMSHAFT JOURNAL DIAMETER SPECIFICATION

Unit: mm (in)		
Oil clearance	Standard	0.055 - 0.090 (0.0022 - 0.0035)
Camshaft journal O.D.		31.928 - 31.945 (1.2570 - 1.2577)
Journal hole I.D.		32.000 - 32.018 (1.2598 - 1.2605)

4. Check the cam face condition, and remove the minor faults by grinding with oil stone. Measure the cam height H. If it is not within the standard or offset wear occurs, replace it.

Cam height H:

CAM HEIGHT SPECIFICATION

Unit: mm (in)			
Intake	Constant	Standard	40.075 - 40.175 (1.5778 - 1.5817)
	Low speed	Standard	35.496 - 35.596 (1.3975 - 1.4014)
	High speed	Standard	40.315 - 40.415 (1.5872 - 1.5911)
Exhaust		Standard	39.289 - 39.389 (1.5468 - 1.5507)

Cam base circle diameter A:

Intake

34.00 mm (1.3386 in)

Exhaust

34.00 mm (1.3386 in)

Base circle step of adjacent intake cams (low speed and high speed):

0.03 mm (0.001 in) or less

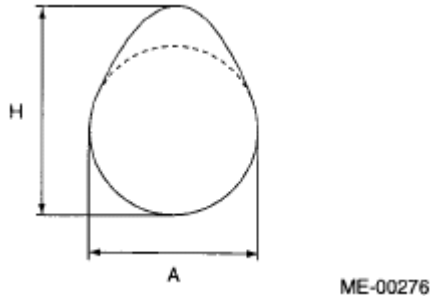


Fig. 154: Identifying Cam Height And Base Circle Diameter
Courtesy of SUBARU OF AMERICA, INC.

5. Measure the thrust clearance of camshaft with setting the dial gauge at end of camshaft. If the thrust clearance is not within the standard or there is offset wear, replace the camshaft caps and cylinder head as a set. If necessary, replace the camshaft.

Standard:

0.030 - 0.090 mm (0.0012 - 0.0035 in)

CYLINDER HEAD

REMOVAL

NOTE: Perform the work with the engine installed to body when replacing a single part. Refer to "VALVE CLEARANCE" for preparation. <Ref. to VALVE CLEARANCE. >

1. Remove the V-belts. <Ref. to **REMOVAL**, V-belt. >
2. Remove the intake manifold. <Ref. to **REMOVAL**, Intake Manifold. >
3. Remove the crank pulley. <Ref. to **REMOVAL**, Crank Pulley. >
4. Remove the timing belt cover. <Ref. to **REMOVAL**, Timing Belt Cover. >
5. Remove the timing belt. <Ref. to **REMOVAL**, Timing Belt. >
6. Remove the cam sprocket. <Ref. to **REMOVAL**, Cam Sprocket. >
7. Remove the bolt which installs the A/C compressor bracket on cylinder head.
8. Remove the valve rocker assembly. <Ref. to **REMOVAL**, Valve Rocker Assembly. >
9. Remove the camshaft. <Ref. to **REMOVAL**, Camshaft. >
10. Remove the oil level gauge guide. (LH side)
11. Remove the cylinder head bolts in alphabetical sequence as shown in the figure.

NOTE: Leave bolts (a) and (c) engaged by three or four threads to prevent the

cylinder head from falling.

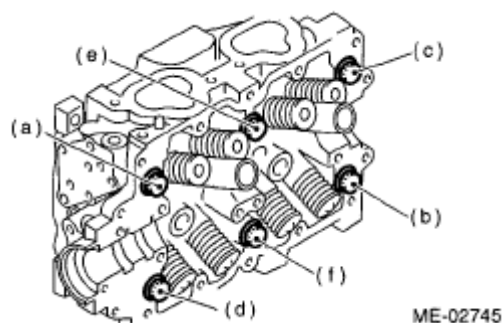


Fig. 155: Identifying Cylinder Head Bolt Torque Sequence
Courtesy of SUBARU OF AMERICA, INC.

12. While tapping the cylinder head with a plastic hammer, separate it from cylinder block. Remove the bolts (a) and (c) to remove cylinder head.

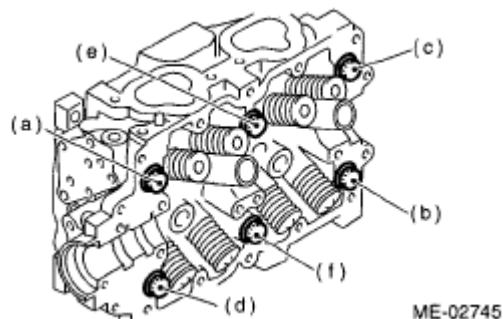


Fig. 156: Identifying Cylinder Head Bolt Torque Sequence
Courtesy of SUBARU OF AMERICA, INC.

13. Remove the cylinder head gasket.

CAUTION: Be careful not to scratch the mating surface of cylinder head and cylinder block.

14. Similarly, remove the right side cylinder head.

INSTALLATION

1. Install the cylinder head and gaskets on cylinder block.

CAUTION: Be careful not to scratch the mating surface of cylinder block and cylinder head.

NOTE: Use a new cylinder head gasket.

2. Tighten the cylinder head bolts.
 1. Apply a thin coat of engine oil to washer and bolt thread.
 2. Tighten all bolts to 29 N.m (3.0 kgf-m, 21.4 ft-lb) in alphabetical order.
 3. Tighten all bolts to 69 N.m (7.0 kgf-m, 50.9 ft-lb) in alphabetical order.
 4. Loosen all the bolts by 180° in the reverse order of installing, and loosen them further by 180°.
 5. Tighten all bolts to 42 N.m (4.3 kgf-m, 31.0 ft-lb) in alphabetical order.
 6. Tighten all bolts by 80 to 90° in alphabetical order.
 7. Tighten all bolts by 40 to 45° in alphabetical order.

CAUTION: The tightening angle of the bolt should not exceed 45°.

8. Further tighten the bolts (a) and (b) by 40 - 45°.

CAUTION: Make sure the total "re-tightening angle" of the step (7) and (8) does not exceed 90°.

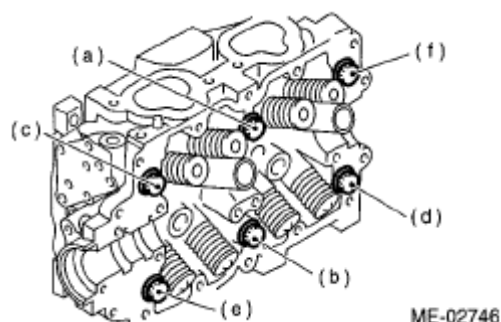


Fig. 157: Identifying Cylinder Head Bolt Torque Sequence
Courtesy of SUBARU OF AMERICA, INC.

3. Install the oil level gauge guide. (LH side)

Tightening torque:

6.4 N.m (0.65 kgf-m, 4.7 ft-lb)

4. Install the camshaft. <Ref. to INSTALLATION, Camshaft. >
5. Install the valve rocker assembly. <Ref. to INSTALLATION, Valve Rocker Assembly. >
6. Install the A/C compressor bracket on cylinder head.

Tightening torque:

36 N.m (3.7 kgf-m, 26.6 ft-lb)

7. Install the cam sprocket. <Ref. to INSTALLATION, Cam Sprocket. >
8. Install the timing belt. <Ref. to INSTALLATION, Timing Belt. >
9. Adjust the valve clearance. <Ref. to ADJUSTMENT, Valve Clearance. >
10. Install the rocker cover.
 1. Install the rocker cover gasket to the rocker cover.

NOTE: Use a new rocker cover gasket.

2. Temporarily tighten the bolts in alphabetical sequence as shown in figure, then tighten the bolt in 2 steps.

Tightening torque:

1st

6.4 N.m (0.65 kgf-m, 4.7 ft-lb)

2nd (only (a) and (b) are tightened)

6.4 N.m (0.65 kgf-m, 4.7 ft-lb)

RH side

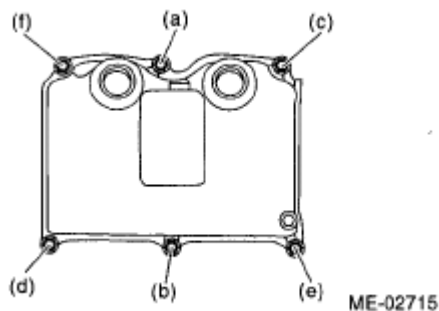


Fig. 158: Identifying Rocker Cover Gasket Bolts Torque Sequence - RH Side
Courtesy of SUBARU OF AMERICA, INC.

LH side

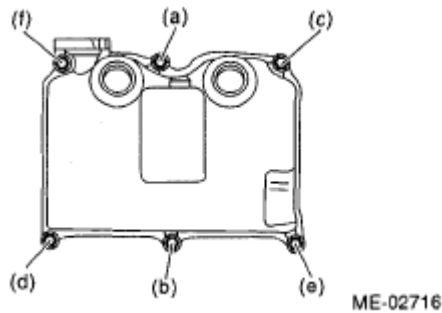


Fig. 159: Identifying Rocker Cover Gasket Bolts Torque Sequence - LH Side
Courtesy of SUBARU OF AMERICA, INC.

11. Install the timing belt cover. <Ref. to **INSTALLATION**, Timing Belt Cover. >
12. Install the crank pulley. <Ref. to **INSTALLATION**, Crank Pulley. >
13. Install the intake manifold. <Ref. to **INSTALLATION**, Intake Manifold. >
14. Install the V-belts. <Ref. to **INSTALLATION**, V-belt. >

DISASSEMBLY

1. Place the cylinder head on the ST.

ST 498267800 CYLINDER HEAD TABLE

2. Compress the valve spring and remove the valve spring retainer key using ST. Remove each valve and valve spring.

ST 499718000 VALVE SPRING REMOVER

NOTE:

- Keep all the removed parts in order for re-installing in their original positions.
- Mark each valve to prevent confusion.
- Pay careful attention not to damage the lips of intake valve oil seals and exhaust valve oil seals.

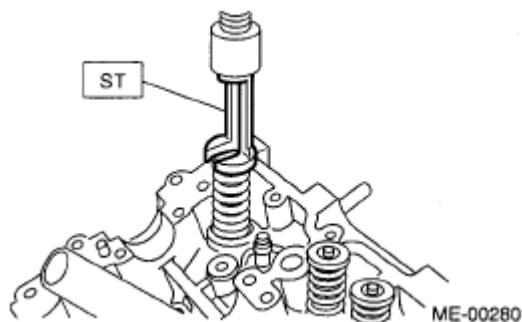
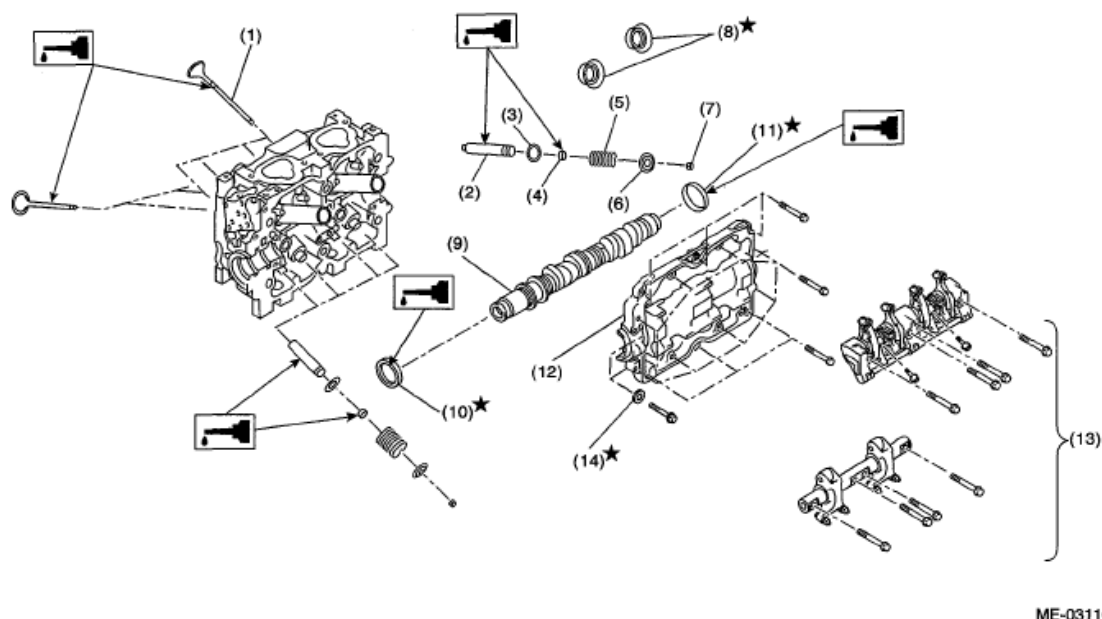


Fig. 160: Identifying Special Tool

Courtesy of SUBARU OF AMERICA, INC.

ASSEMBLY



ME-03110

- | | | |
|-----------------------|-----------------------|------------------------|
| (1) Valve | (6) Retainer | (11) Plug |
| (2) Valve guide | (7) Retainer key | (12) Camshaft cap |
| (3) Valve spring seat | (8) Spark plug gasket | (13) Valve rocker ASSY |
| (4) Oil seal | (9) Camshaft | (14) Seal washer |
| (5) Valve spring | (10) Oil seal | |

Fig. 161: Identifying Cylinder Head Assembly Components
Courtesy of SUBARU OF AMERICA, INC.

1. Install the valve spring and valve.
 1. Coat the stem of each valve with engine oil and insert the valve into the valve guide.

NOTE: When inserting the valve into valve guide, use special care not to damage the oil seal lip.

2. Set the cylinder head on ST.

ST 498267800 CYLINDER HEAD TABLE

3. Install the valve spring and retainer.

NOTE: Be sure to install the valve spring with its close-coiled end facing the seat on cylinder head.

4. Set the ST on valve spring.

ST 499718000 VALVE SPRING REMOVER

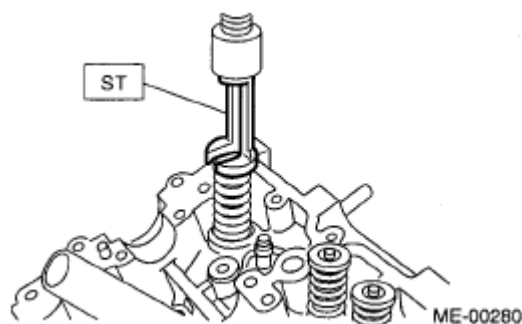
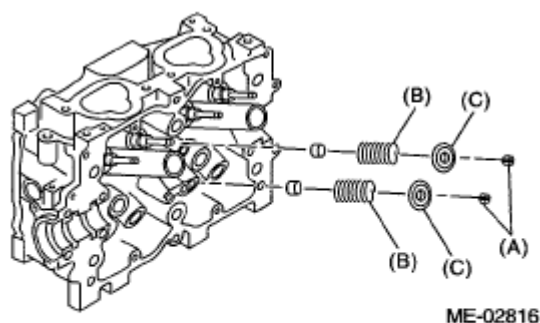


Fig. 162: Identifying Special Tool
Courtesy of SUBARU OF AMERICA, INC.

5. Compress the valve spring and fit the valve spring retainer key.



- (A) Retainer key
(B) Valve spring
(C) Retainer

Fig. 163: Identifying Retainer Key, Valve Spring And Retainer
Courtesy of SUBARU OF AMERICA, INC.

6. After installing, tap the valve spring retainers lightly with a plastic hammer for better seating.

INSPECTION

CYLINDER HEAD

1. Check for cracks or damage. Use liquid penetrant tester on the important sections to check for fissures. Check that there are no marks of gas leaking or water leaking on gasket installing surface.
2. Place the cylinder head on the ST.

ST 498267800 CYLINDER HEAD TABLE

3. Measure the warping of the cylinder head surface that mates with cylinder block using a straight edge (A) and thickness gauge (B).

If the warping exceeds the limit, correct the surface by grinding it with a surface grinder.

Warping limit:

0.035 mm (0.0014 in)

Grinding limit:

0.1 mm (0.004 in)

Standard height of cylinder head:

97.5 mm (3.839 in)

NOTE: Uneven torque for the cylinder head bolts can cause warping. When reassembling, pay special attention to the torque so as to tighten evenly.

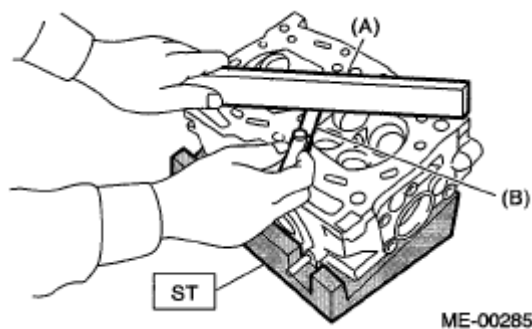


Fig. 164: Measuring Warping Of Cylinder Head Surface
Courtesy of SUBARU OF AMERICA, INC.

VALVE SEAT

Inspect the intake and exhaust valve seats, and correct the contact surfaces with a valve seat cutter if they are defective or when valve guides are replaced.

Valve seat width W:

Standard:

Intake (A)

0.8 - 1.4 mm (0.03 - 0.055 in)

Exhaust (B)

1.2 - 1.8 mm (0.047 - 0.077 in)

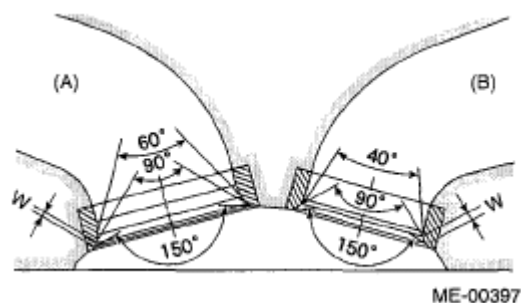


Fig. 165: Identifying Valve Seat Width And Angle
 Courtesy of SUBARU OF AMERICA, INC.

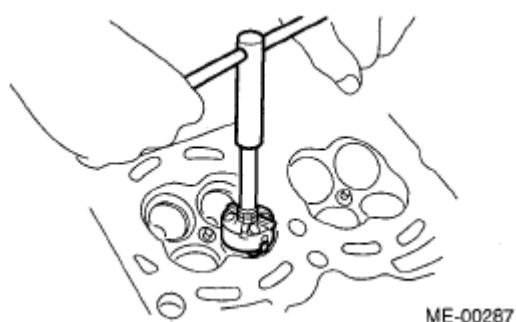


Fig. 166: Reaming Valve Seat
 Courtesy of SUBARU OF AMERICA, INC.

VALVE GUIDE

1. Check the clearance between valve guide and valve stem. The clearance can be checked by measuring respectively the outer diameter of valve stem with a micrometer and the inner diameter of valve guide with a caliper gauge.

Clearance between the valve guide and valve stem:

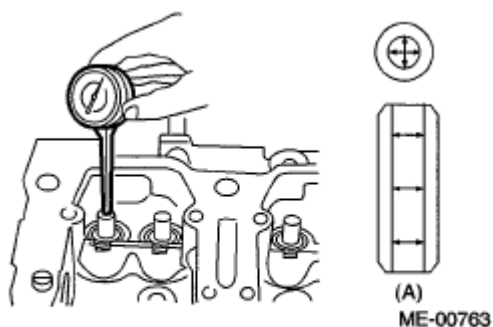
Standard:

Intake

0.035 - 0.062 mm (0.0014 - 0.0024 in)

Exhaust

0.040 - 0.067 mm (0.0016 - 0.0026 in)



(A) Valve guide

Fig. 167: Checking Clearance Between Valve Guide And Valve Stem
 Courtesy of SUBARU OF AMERICA, INC.

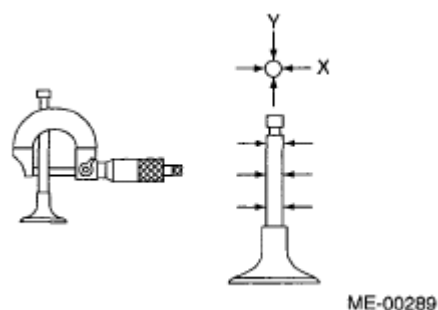


Fig. 168: Measuring Valve Stem
 Courtesy of SUBARU OF AMERICA, INC.

- If the clearance between the valve guide and valve stem exceeds the standard, replace the valve guide or valve itself, whichever shows greater amount of wear or damage. See the following procedure for valve guide replacement.

Valve guide inner diameter:

6.000 - 6.012 mm (0.2362 - 0.2367 in)

Valve stem outer diameters:

Intake

5.950 - 5.965 mm (0.2343 - 0.2348 in)

Exhaust

5.945 - 5.960 mm (0.2341 - 0.2346 in)

- Place the cylinder head on ST1 with the combustion chamber upward so that valve guides fit the holes in ST1.

2. Insert the ST2 into valve guide and press it down to remove the valve guide.

ST1 498267800 CYLINDER HEAD TABLE

ST2 499767200 VALVE GUIDE REMOVER

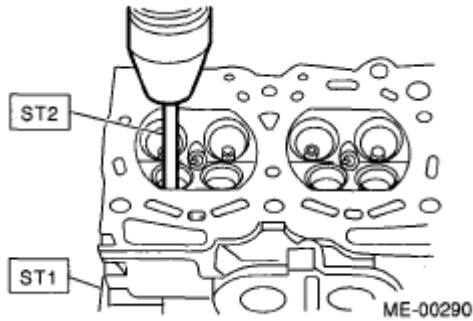


Fig. 169: Identifying Special Tools
Courtesy of SUBARU OF AMERICA, INC.

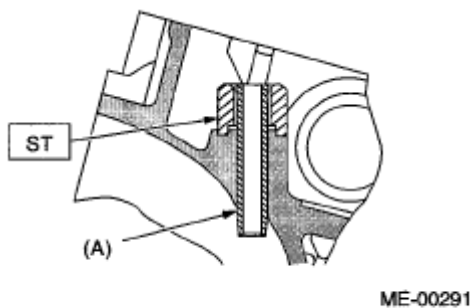
3. Turn the cylinder head upside down and place the ST as shown in the figure.

Intake side

ST 499767700 VALVE GUIDE ADJUSTER

Exhaust side

ST 499767800 VALVE GUIDE ADJUSTER



(A) Valve guide

Fig. 170: Identifying Special Tool And Valve Guide
Courtesy of SUBARU OF AMERICA, INC.

4. Before installing a new valve guide, make sure that neither scratches nor damages exist on the inner surface of valve guide holes in cylinder head.
5. Put a new valve guide, coated with sufficient oil, in cylinder, and insert the ST1 into valve guide. Press in until the valve guide upper end is flush with the upper surface of ST2.

ST1 499767200 VALVE GUIDE REMOVER

Intake side

ST2 499767700 VALVE GUIDE ADJUSTER

Exhaust side

ST2 499767800 VALVE GUIDE ADJUSTER

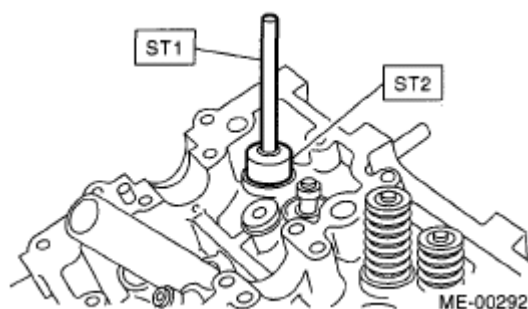


Fig. 171: Identifying Special Tools
Courtesy of SUBARU OF AMERICA, INC.

6. Check the valve guide protrusion.

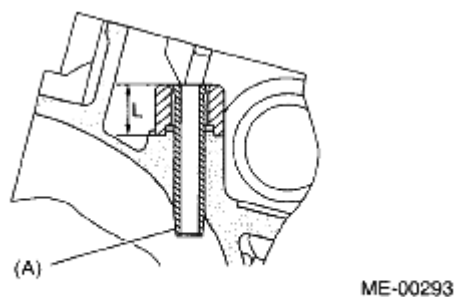
Valve guide protrusion L:

Intake

20.0 - 21.0 mm (0.787 - 0.827 in)

Exhaust

16.5 - 22.5 mm (0.650 - 0.886 in)



(A) Valve guide

Fig. 172: Identifying Valve Guide And Valve Guide Protrusion
Courtesy of SUBARU OF AMERICA, INC.

7. Ream the inside of valve guide using ST. Put the ST in valve guide, and rotate the ST slowly clockwise while pushing it lightly. Bring the ST back while rotating it clockwise.

NOTE:

- Apply engine oil to the ST when reaming.
- If the inner surface of valve guide is damaged, the edge of ST should be slightly ground with oil stone.
- If the inner surface of valve guide becomes lustrous and the ST does not chip, use a new ST or remedy the ST.

ST 499767400 VALVE GUIDE REAMER



Fig. 173: Reaming Valve Guide
Courtesy of SUBARU OF AMERICA, INC.

8. After reaming, clean the valve guide to remove chips.
9. Recheck the contact condition between valve and valve seat after replacing the valve guide.

INTAKE AND EXHAUST VALVE

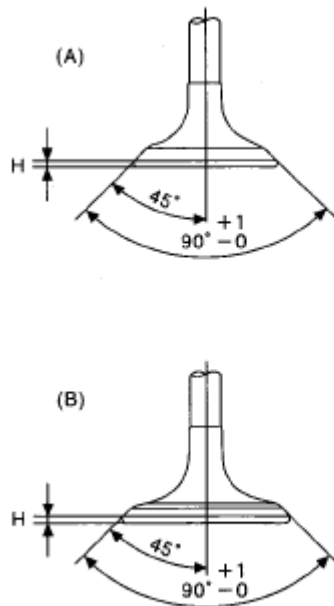
1. Inspect the flange and stem of valve, and replace the valve with a new part if damaged, worn, deformed, or if dimension "H" in the figure is outside of the specified limit.

Head edge thickness H:***Intake (A)******Standard:***

0.8 - 1.2 mm (0.03 - 0.047 in)

Exhaust (B)***Standard:***

1.0 - 1.4 mm (0.039 - 0.055 in)



ME-00758

Fig. 174: Identifying Head Edge Thickness
 Courtesy of SUBARU OF AMERICA, INC.

- Put a small amount of grinding compound on the seat surface, and lap the valve and seat surface. Replace with a new valve oil seal after lapping.

NOTE: It is possible to differentiate between the intake valve and the exhaust valve by their overall length.

Valve overall length:

Intake

120.6 mm (4.75 in)

Exhaust

121.7 mm (4.79 in)

VALVE SPRING

- Check the valve springs for damage, free length, and tension. Replace the valve spring if it is not within the standard value presented in the table.
- To measure the squareness of the valve spring, stand the spring on a surface plate and measure its deflection at the top of spring using a try square.

VALVE SPRING SPECIFICATION

	mm	
--	----	--

Free length	(in)	55.2 (2.173)
Tension/spring height N (kgf, lbf)/mm (in)	Set	235.3 - 270.7 (24 - 27.6, 52.9 - 60.8)/45.0 (1.772)
	Lift	578.9 - 639.9 (59.1 - 65.3, 130.3 - 143.9)/34.7 (1.366)
Squareness		2.5°, 2.4 mm (0.094 in) or less

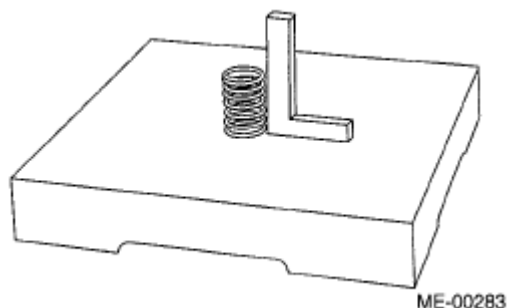


Fig. 175: Measuring Valve Spring
Courtesy of SUBARU OF AMERICA, INC.

INTAKE AND EXHAUST VALVE OIL SEAL

- For the following, replace the oil seal with a new part.
 - When the lip is damaged.
 - When the spring is out of the specified position.
 - When readjusting the surfaces of valve and valve seat.
 - When replacing the valve guide.
- Place the cylinder head on ST1, and use ST2 to press-fit the oil seal.

ST1 498267800 CYLINDER HEAD TABLE

ST2 498857100 VALVE OIL SEAL GUIDE

NOTE:

- Apply engine oil to oil seal before press-fitting.
- When press-fitting the oil seal, do not use a hammer or strike in.
- The intake valve oil seal and exhaust valve oil seal can be distinguished by colors.

Color of rubber part:

Intake [Gray]

Exhaust [Green]

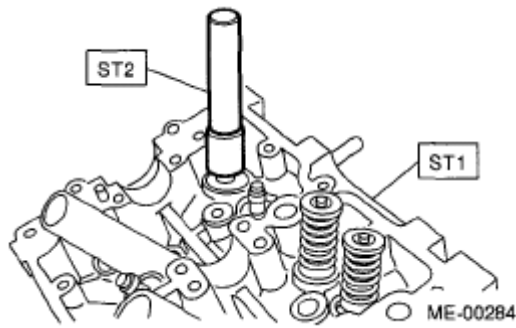


Fig. 176: Identifying Special Tools
 Courtesy of SUBARU OF AMERICA, INC.

CYLINDER BLOCK

REMOVAL

NOTE: Before conducting this procedure, drain the engine oil completely.

1. Remove the V-belts. <Ref. to **REMOVAL**, V-belt. >
2. Remove the intake manifold. <Ref. to **REMOVAL**, Intake Manifold. >
3. Remove the crank pulley. <Ref. to **REMOVAL**, Crank Pulley. >
4. Remove the timing belt cover. <Ref. to **REMOVAL**, Timing Belt Cover. >
5. Remove the timing belt. <Ref. to **REMOVAL**, Timing Belt. >
6. Remove the cam sprocket. <Ref. to **REMOVAL**, Cam Sprocket. >
7. Remove the crank sprocket. <Ref. to **REMOVAL**, Crank Sprocket. >
8. Remove the valve rocker assembly. <Ref. to **REMOVAL**, Valve Rocker Assembly. >
9. Remove the camshaft. <Ref. to **REMOVAL**, Camshaft. >
10. Remove the generator and A/C compressor with their brackets.
11. Remove the cylinder head. <Ref. to **REMOVAL**, Cylinder Head. >
12. Remove the clutch disc and cover. (MT model) <Ref. to **REMOVAL**, Clutch Disc and Cover. >
13. Remove the flywheel. (MT model) <Ref. to **REMOVAL**, Flywheel. >
14. Remove the drive plate. (AT model) Using the ST, lock the crankshaft.

ST 498497100 CRANKSHAFT STOPPER

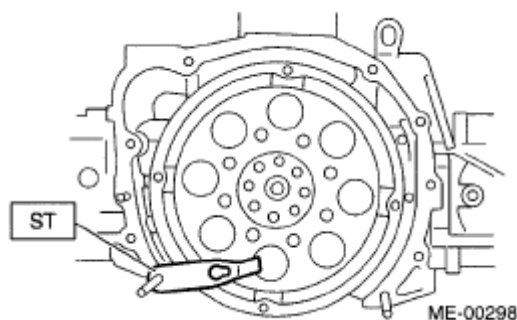


Fig. 177: Identifying Special Tool
Courtesy of SUBARU OF AMERICA, INC.

15. Remove the oil separator cover.
16. Remove the water by-pass pipe for heater.
17. Remove the water pump. <Ref. to **REMOVAL** , Water Pump . >
18. Remove the bolts which install oil pump onto cylinder block.

NOTE: When disassembling and checking the oil pump, loosen the relief valve plug before removing the oil pump.

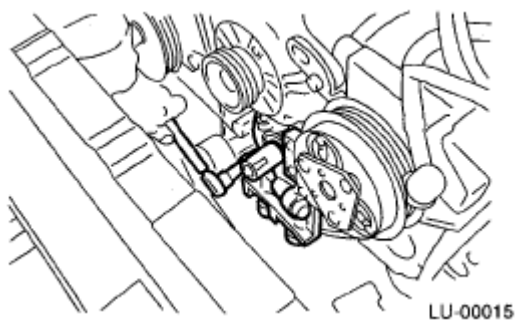


Fig. 178: Removing Oil Pump
Courtesy of SUBARU OF AMERICA, INC.

19. Remove the oil pump from cylinder block using a flat tip screwdriver.

CAUTION: Be careful not to scratch the mating surface of cylinder block and oil pump.

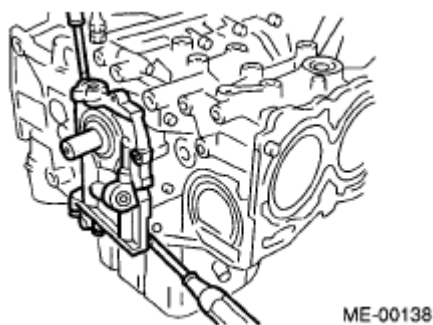


Fig. 179: Removing Oil Pump From Cylinder Block
Courtesy of SUBARU OF AMERICA, INC.

20. Remove the front oil seal from the oil pump.
21. Remove the oil pan.
 1. Set the part so that the cylinder block LH is on the upper side.
 2. Remove the bolts which secure oil pan to cylinder block.
 3. Insert an oil pan cutter blade between cylinder block-to-oil pan clearance and remove the oil pan.

CAUTION: Do not use a screwdriver or similar tools in place of oil pan cutter.

22. Remove the oil strainer.
23. Remove the baffle plate.
24. Remove the oil filter. <Ref. to **REMOVAL** , Engine Oil Filter . >
25. Remove the water pipe.

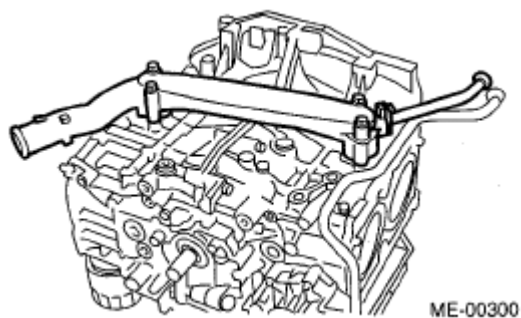
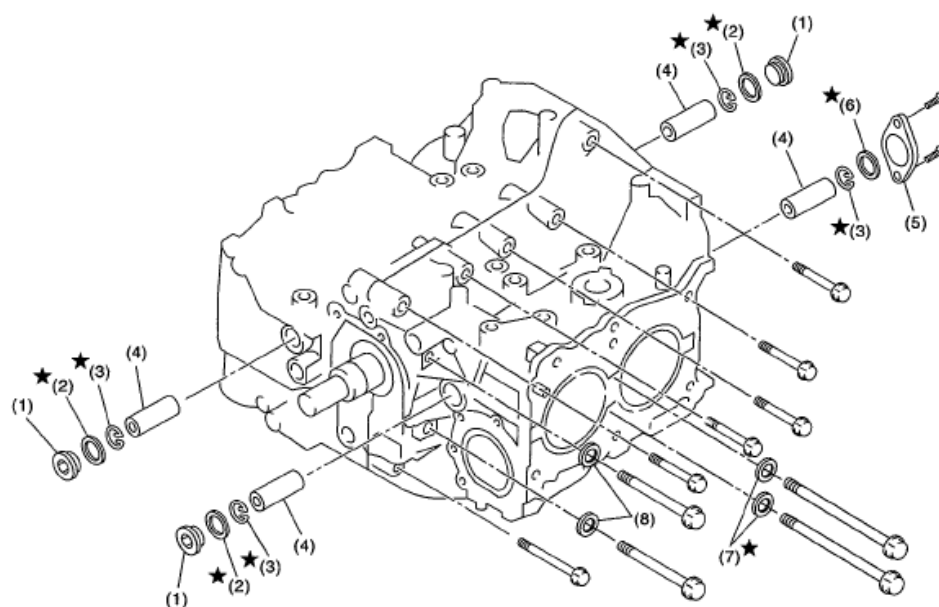


Fig. 180: Identifying Water Pipe
Courtesy of SUBARU OF AMERICA, INC.



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- | | | |
|-----------------------|------------------------|-----------------|
| (1) Service hole plug | (4) Piston pin | (7) Seal washer |
| (2) Gasket | (5) Service hole cover | (8) Washer |
| (3) Snap ring | (6) O-ring | |

Fig. 181: Identifying Cylinder Block Components
Courtesy of SUBARU OF AMERICA, INC.

26. Remove the service hole plugs using a hexagon wrench [14 mm].

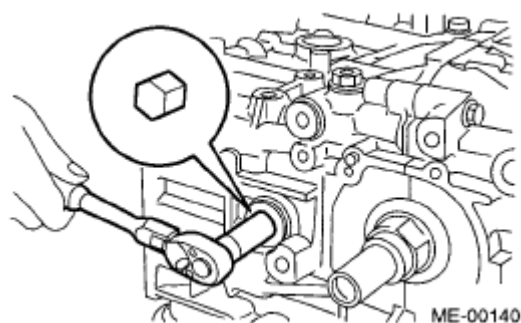


Fig. 182: Removing Service Hole Plugs
Courtesy of SUBARU OF AMERICA, INC.

27. Remove the service hole cover.
28. Rotate the crankshaft to bring #1 and #2 pistons to bottom dead center position, then remove the piston snap ring through service hole of #1 and #2 cylinders.

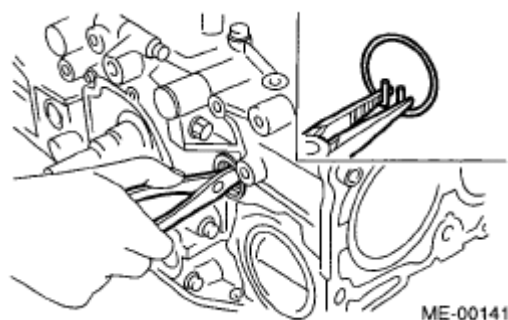


Fig. 183: Removing Piston Snap Ring
Courtesy of SUBARU OF AMERICA, INC.

29. Draw out the piston pin from #1 and #2 pistons using ST.

ST 499097700 PISTON PIN REMOVER

NOTE: Be careful not to confuse the original combination of piston, piston pin and cylinder.

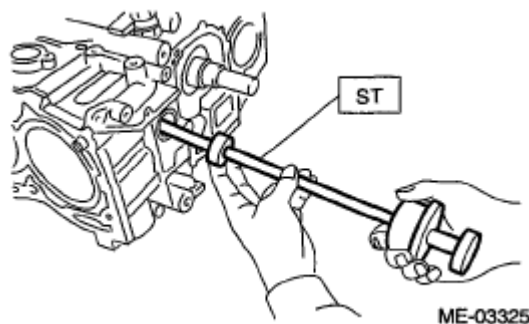
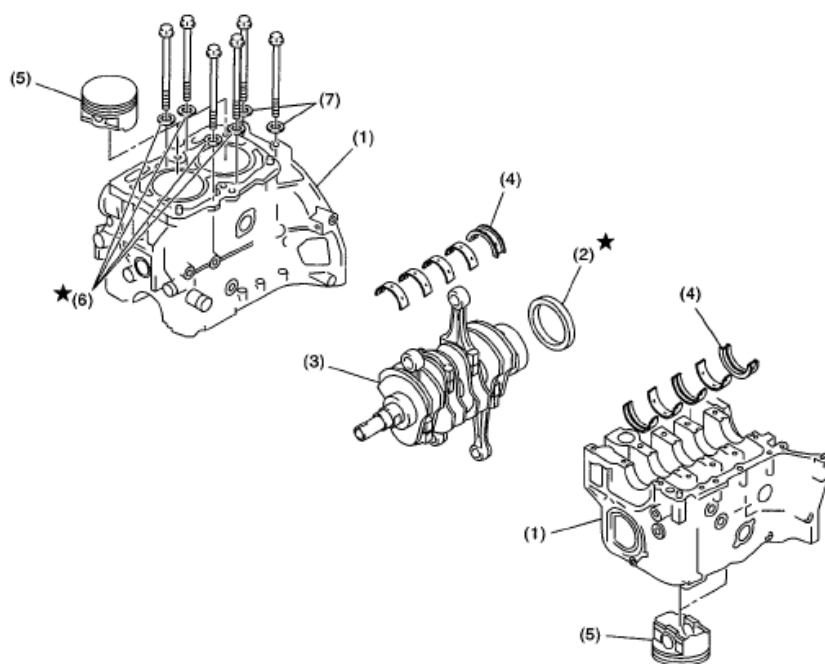


Fig. 184: Drawing Out Piston Pin
Courtesy of SUBARU OF AMERICA, INC.

30. Similarly draw out the piston pins from #3 and #4 pistons.
31. Remove the cylinder block connecting bolt on the RH side.
32. Loosen the cylinder block connecting bolt on the LH side by 2-3 turns.
33. Set the part so that the cylinder block LH is on the upper side, and remove the cylinder block connecting bolt.
34. Separate the cylinder block LH and RH.

NOTE: When separating the cylinder block, do not allow the connecting rod to fall and damage the cylinder block.



ME-02890

- (1) Cylinder block
- (2) Rear oil seal
- (3) Crankshaft

- (4) Crankshaft bearing
- (5) Piston

- (6) Seal washer
- (7) Washer

Fig. 185: Identifying Cylinder Block Components
 Courtesy of SUBARU OF AMERICA, INC.

35. Remove the rear oil seal.
36. Remove the crankshaft together with connecting rod.
37. Remove the crankshaft bearings from cylinder block using a hammer handle.

NOTE:

- Push the opposite side of the crank shaft bearing locking lip to remove.
- Be careful not to confuse the crankshaft bearing combination.

38. Remove each piston from cylinder block using wooden bar or hammer handle.

NOTE:

Be careful not to confuse the original combination of piston and cylinder.

INSTALLATION

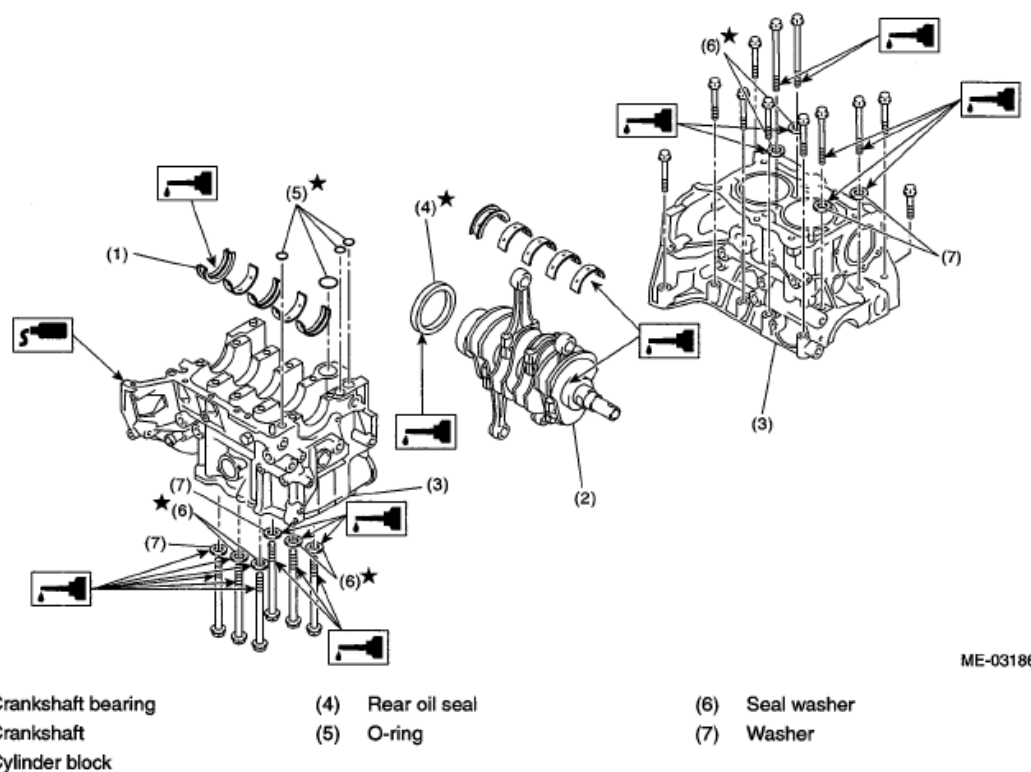


Fig. 186: Identifying Cylinder Block Components
 Courtesy of SUBARU OF AMERICA, INC.

1. Remove oil on the mating surface of cylinder block before installation. Apply a coat of engine oil to the bearing and crankshaft journal.
2. Position the crankshaft and O-ring on cylinder block RH.
3. Apply liquid gasket to the mating surfaces of cylinder block RH, and position cylinder block LH.

NOTE:

- Install within 5 min. after applying liquid gasket.
- Do not allow liquid gasket to jut into O-ring grooves, oil passages, bearing grooves, etc.

Liquid gasket:

THREE BOND 1217G (Part No. K0877Y0100) or equivalent

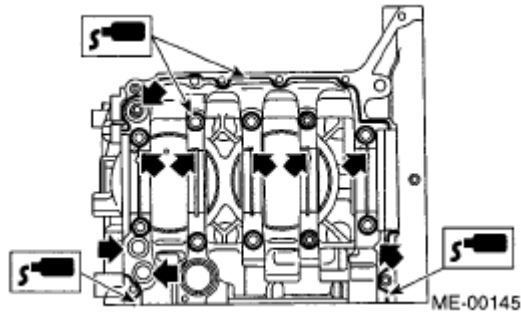


Fig. 187: Identifying Liquid Gasket Applying Area
Courtesy of SUBARU OF AMERICA, INC.

4. Apply a coat of engine oil to the washer and bolt thread.

NOTE: Use a new seal washer.

5. Tighten the 10 mm cylinder block connecting bolts on the LH side (A - D) in alphabetical order.

Tightening torque:

10 N.m (1.0 kgf-m, 7.2 ft-lb)

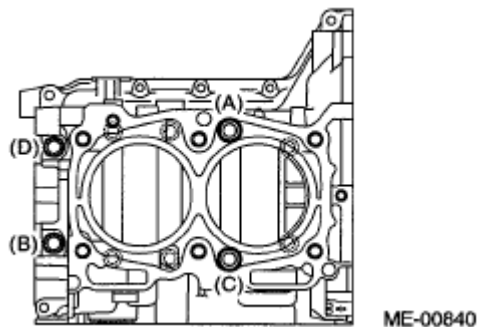


Fig. 188: Identifying Cylinder Block Connecting Bolts Torque Sequence - LH
Courtesy of SUBARU OF AMERICA, INC.

6. Tighten the 10 mm cylinder block connecting bolts on the RH side (E - J) in alphabetical order.

Tightening torque:

10 N.m (1.0 kgf-m, 7.2 ft-lb)

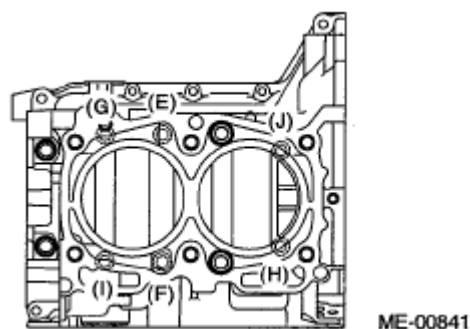


Fig. 189: Identifying Cylinder Block Connecting Bolts Torque Sequence - RH
 Courtesy of SUBARU OF AMERICA, INC.

7. Tighten the LH side cylinder block connecting bolts (A - D) further in alphabetical order.

Tightening torque:

18 N.m (1.8 kgf-m, 13.3 ft-lb)

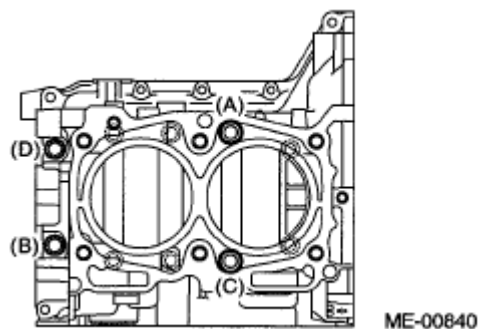


Fig. 190: Identifying Cylinder Block Connecting Bolts Torque Sequence - LH
 Courtesy of SUBARU OF AMERICA, INC.

8. Tighten the RH side cylinder block connecting bolts (E - J) further in alphabetical order.

Tightening torque:

18 N.m (1.8 kgf-m, 13.3 ft-lb)

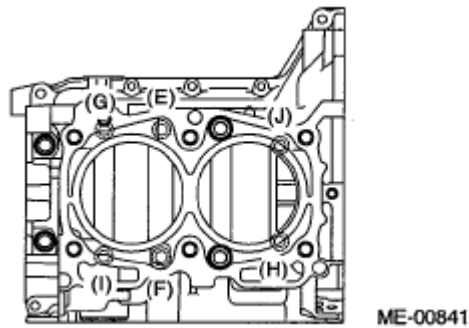


Fig. 191: Identifying Cylinder Block Connecting Bolts Torque Sequence - RH
 Courtesy of SUBARU OF AMERICA, INC.

9. Tighten the LH side cylinder block connecting bolts (A - D) further in alphabetical order.
 - (A), (C): Angle tightening

Tightening angle:

90°

- (B), (D): Torque tightening

Tightening torque:

40 N.m (4.1 kgf-m, 29.6 ft-lb)

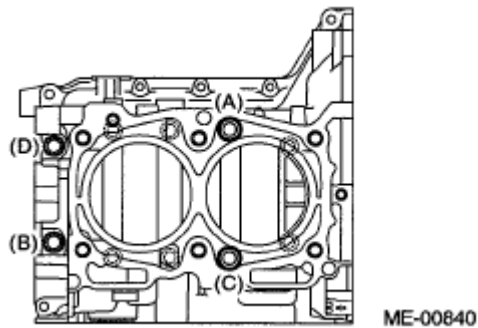


Fig. 192: Identifying Cylinder Block Connecting Bolts Torque Sequence - LH
 Courtesy of SUBARU OF AMERICA, INC.

10. Tighten the RH side cylinder block connecting bolts (E - J) in alphabetical order.

Tightening angle:

90°

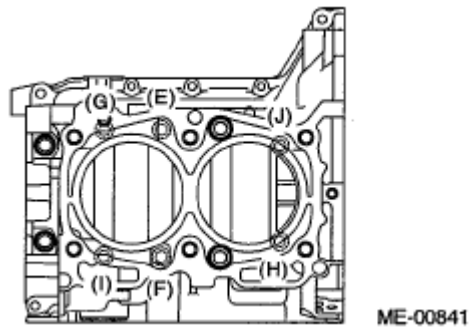


Fig. 193: Identifying Cylinder Block Connecting Bolts Torque Sequence - RH
 Courtesy of SUBARU OF AMERICA, INC.

11. Tighten the 8 mm and 6 mm cylinder block connecting bolts on LH side (A - H) in alphabetical sequence.

Tightening torque:

(A) - (G): 25 N.m (2.5 kgf-m, 18.4 ft-lb)

(H): 6.4 N.m (0.65 kgf-m, 4.7 ft-lb)

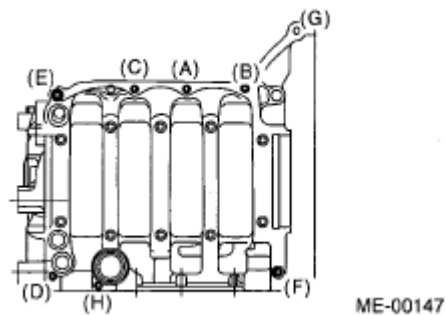


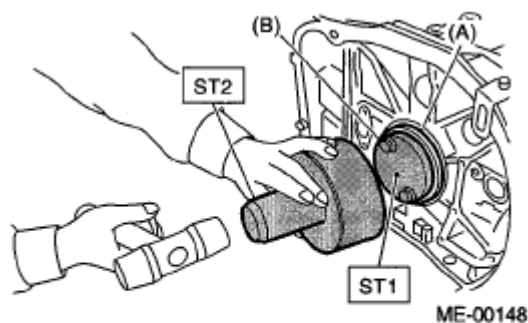
Fig. 194: Identifying Cylinder Block Connecting Bolts Torque Sequence - LH Side
 Courtesy of SUBARU OF AMERICA, INC.

12. Apply a coat of engine oil to the oil seal periphery, then install the rear oil seal using ST1 and ST2.

NOTE: Use new rear oil seal.

ST1 499597100 CRANKSHAFT OIL SEAL GUIDE

ST2 499587200 CRANKSHAFT OIL SEAL INSTALLER



(A) Rear oil seal

(B) Flywheel attaching bolt

Fig. 195: Installing Rear Oil Seal

Courtesy of SUBARU OF AMERICA, INC.

13. Position the top ring gap at (A) or (B) in the figure.
14. Position the second ring gap at 180° on the reverse side the top ring gap.

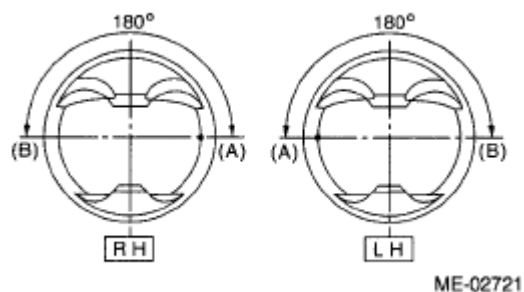


Fig. 196: Positioning Top Ring Gap

Courtesy of SUBARU OF AMERICA, INC.

15. Position the upper rail gap at (C) in the figure.

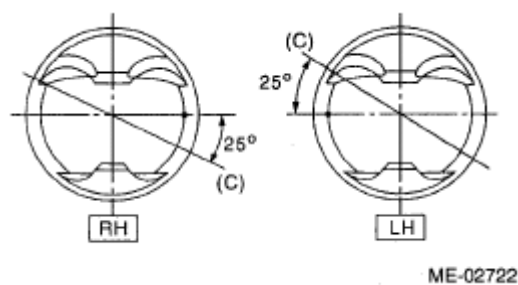


Fig. 197: Positioning Upper Rail Gap

Courtesy of SUBARU OF AMERICA, INC.

16. Align the upper rail spin stopper (E) to the side hole (D) on the piston.

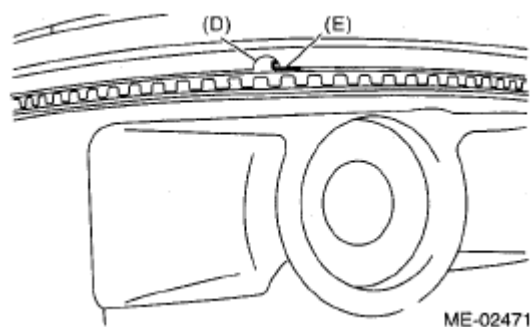


Fig. 198: Aligning Upper Rail Spin Stopper
Courtesy of SUBARU OF AMERICA, INC.

17. Position the expander gap at (F) in the figure.

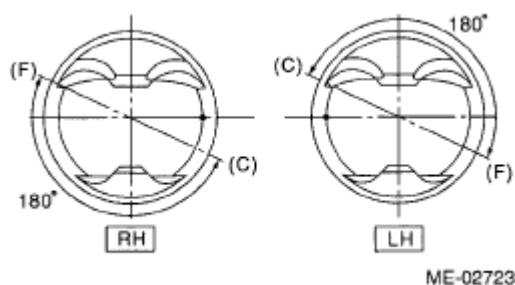


Fig. 199: Positioning Expander Gap
Courtesy of SUBARU OF AMERICA, INC.

18. Position the lower rail gap at (G) in the figure.

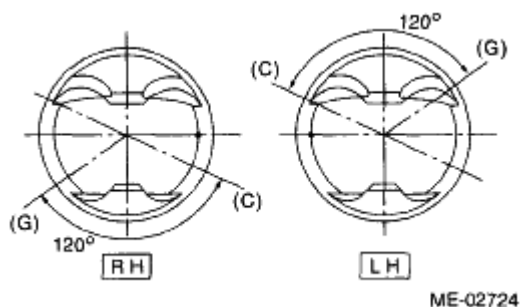


Fig. 200: Positioning Lower Rail Gap
Courtesy of SUBARU OF AMERICA, INC.

NOTE:

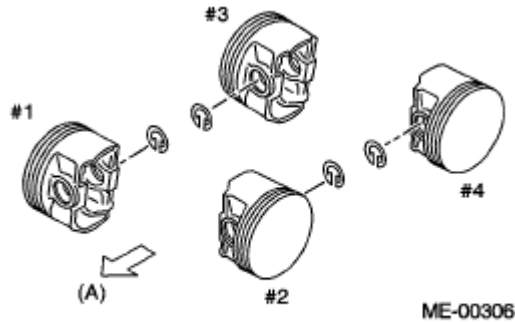
- Make sure ring gaps do not face the same direction.
- Make sure ring gaps are not within the piston skirt area.

19. Install the snap ring.

Before positioning the piston on the cylinder block, attach the snap ring in the service hole of the cylinder

block, and the piston hole on the opposite side.

NOTE: Use new snap rings.



(A) Front side

Fig. 201: Identifying Snap Ring
Courtesy of SUBARU OF AMERICA, INC.

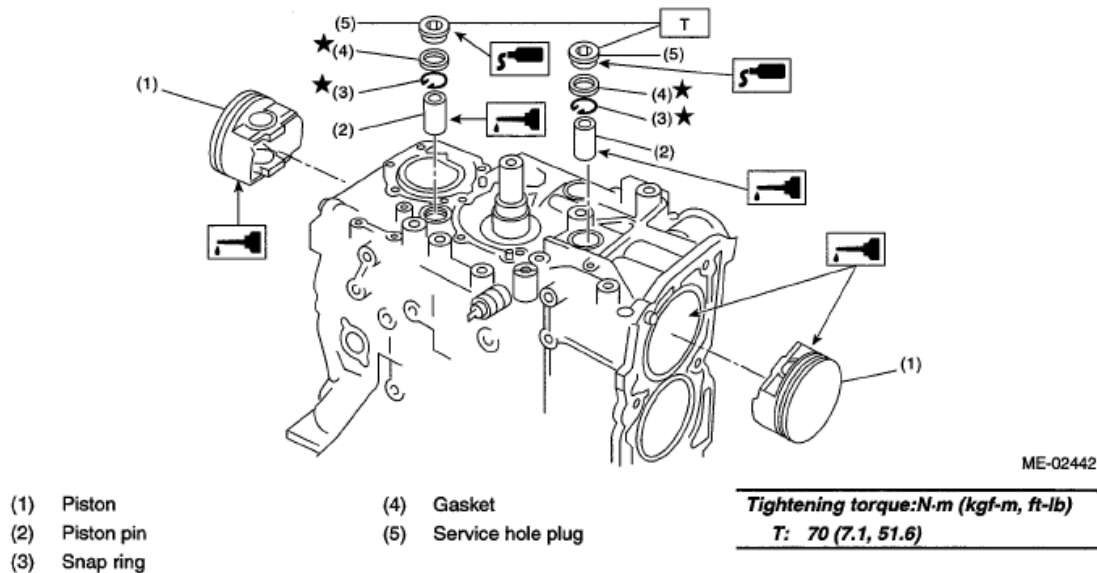


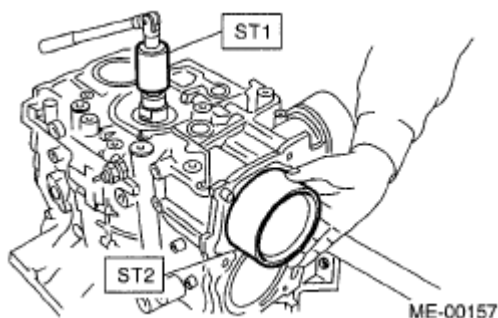
Fig. 202: Identifying Piston Components With Torque Specifications
Courtesy of SUBARU OF AMERICA, INC.

20. Install the piston.
 1. Set the parts so that the #1 and #2 cylinders are on the upper side.
 2. Using the ST1, turn the crankshaft so that #1 and #2 connecting rods are set at bottom dead center.

ST1 499987500 CRANKSHAFT SOCKET

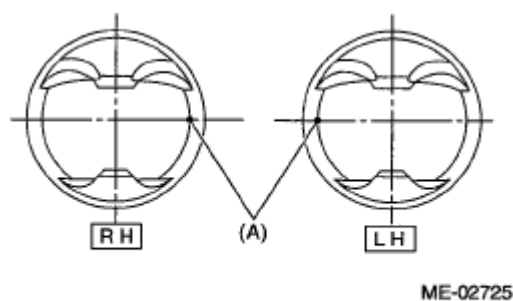
3. Apply a coat of engine oil to the pistons and cylinders and insert pistons in their cylinders using ST2.

ST2 498747300 PISTON GUIDE

**Fig. 203: Installing Piston**

Courtesy of SUBARU OF AMERICA, INC.

NOTE: Face the piston front mark towards the front of the engine.



(A) Front mark

Fig. 204: Aligning Piston Front Mark

Courtesy of SUBARU OF AMERICA, INC.

21. Install piston pin.

1. Apply a coat of engine oil to ST3.
2. Insert ST3 into the service hole to align piston pin hole with connecting rod small end.

ST3 499017100 PISTON PIN GUIDE

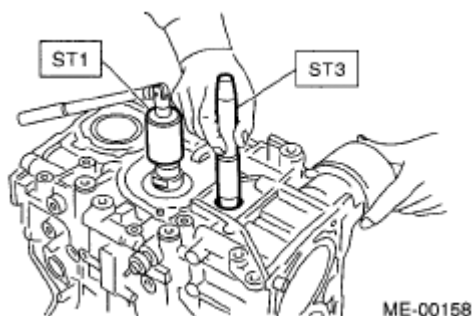
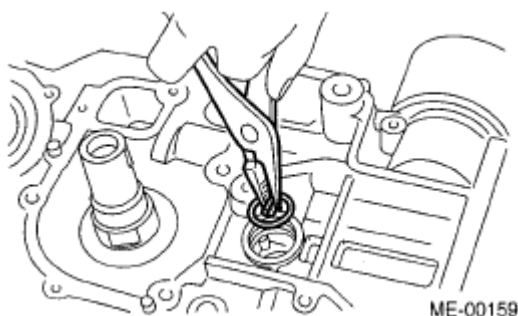


Fig. 205: Installing Piston Pin

Courtesy of SUBARU OF AMERICA, INC.

3. Apply a coat of engine oil to piston pin, and insert the piston pin into piston and connecting rod through service hole.
4. Install the snap ring.

NOTE: **Use new snap rings.**

**Fig. 206: Installing Snap Ring**

Courtesy of SUBARU OF AMERICA, INC.

5. Apply liquid gasket to the threaded portion of the service hole plug.

Liquid gasket:

THREE BOND 1105 (Part No. 004403010) or equivalent

**Fig. 207: Applying Liquid Gasket To Threaded Portion Of Service Hole Plug**

Courtesy of SUBARU OF AMERICA, INC.

6. Install the water pump and gasket.

NOTE: **Use a new gasket.**

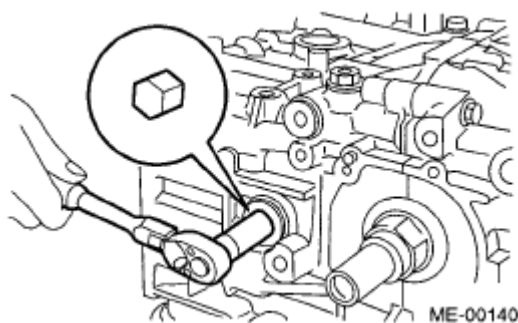


Fig. 208: Installing Water Pump And Gasket
Courtesy of SUBARU OF AMERICA, INC.

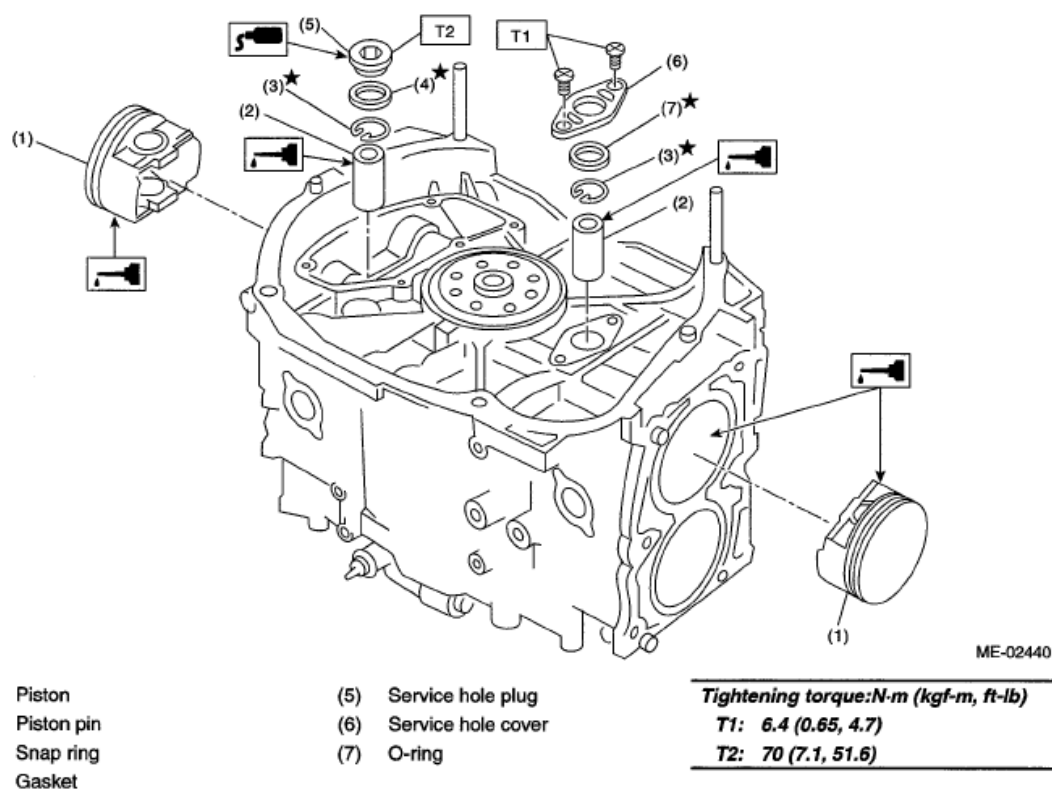


Fig. 209: Identifying Piston Components
Courtesy of SUBARU OF AMERICA, INC.

7. Set the parts so that the #3 and #4 cylinders are on the upper side. Following the same procedures as used for #1 and #2 cylinders, install the pistons and piston pins.
8. Install the service hole cover.

NOTE: Use new O-rings.

22. Install the water pipe.

NOTE: Use new O-rings.

Tightening torque:

6.4 N.m (0.65 kgf-m, 4.7 ft-lb)

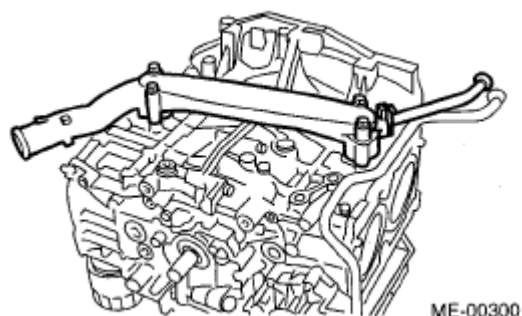


Fig. 210: Installing Water Pipe
Courtesy of SUBARU OF AMERICA, INC.

23. Install the baffle plate.

Tightening torque:

6.4 N.m (0.65 kgf-m, 4.7 ft-lb)

24. Install the oil strainer.

NOTE: Use new O-rings.

Tightening torque:

10 N.m (1.0 kgf-m, 7.4 ft-lb)

25. Tighten the oil strainer stay together with the baffle plate.

Tightening torque:

6.4 N.m (0.65 kgf-m, 4.7 ft-lb)

26. Apply liquid gasket to the mating surfaces of the oil pan, and install the oil pan.

NOTE: Install within 5 min. after applying liquid gasket.

Liquid gasket:

THREE BOND 1217G (Part No. K0877Y0100) or equivalent

Tightening torque:

5 N.m (0.5 kgf-m, 3.7 ft-lb)

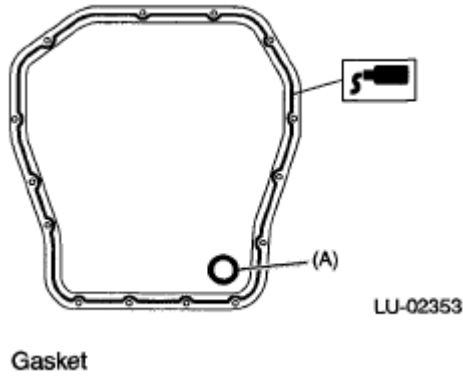


Fig. 211: Identifying Liquid Gasket Apply Area
 Courtesy of SUBARU OF AMERICA, INC.

27. Apply liquid gasket to the mating surfaces of the oil separator cover and the threaded portion of bolt (A) shown in the figure (when reusing the bolt), and then install the oil separator cover.

NOTE:

- Install within 5 min. after applying liquid gasket.
- Use a new separator cover.

Liquid gasket:

- Mating surface

THREE BOND 1217G (Part No. K0877Y0100) or equivalent

- Bolt thread area (A) (when reusing the bolt)

THREE BOND 1324 (Part No. 004403042) or equivalent

Tightening torque:

6.4 N.m (0.65 kgf-m, 4.7 ft-lb)

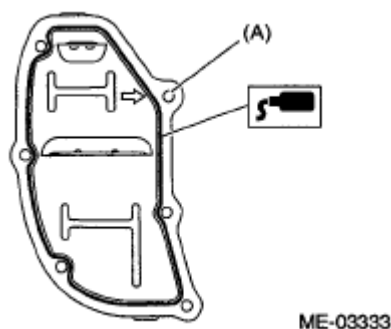


Fig. 212: Identifying Liquid Gasket Apply Area
 Courtesy of SUBARU OF AMERICA, INC.

28. Install the flywheel. (MT model)

<Ref. to **INSTALLATION** , Flywheel . >

29. Install the clutch disc and cover. (MT model) <Ref. to **INSTALLATION** , Clutch Disc and Cover . >
 30. Install the drive plate. (AT model) To lock the crankshaft, use the ST.

ST 498497100 CRANKSHAFT STOPPER

Tightening torque:

72 N.m (7.3 kgf-m, 53.1 ft-lb)

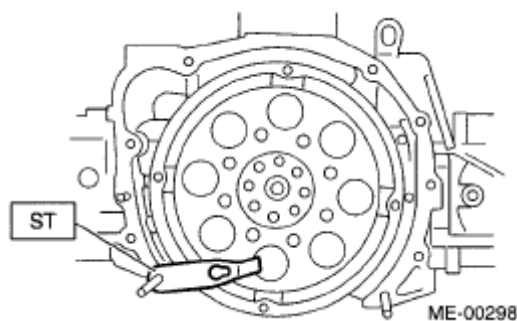


Fig. 213: Identifying Special Tool
 Courtesy of SUBARU OF AMERICA, INC.

31. Install the oil pump.
 1. Using the ST, install the front oil seal.

ST 499587100 OIL SEAL INSTALLER

NOTE: Use a new front oil seal.

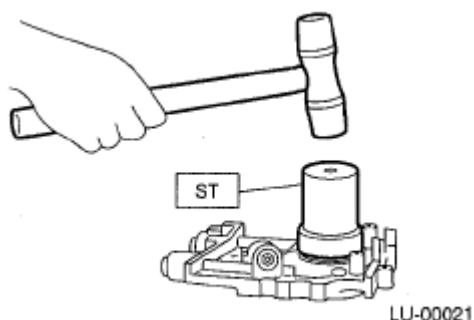


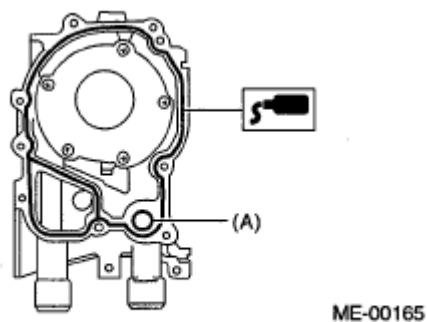
Fig. 214: Installing Front Oil Seal
Courtesy of SUBARU OF AMERICA, INC.

2. Apply liquid gasket to the matching surface of oil pump.

NOTE: Install within 5 min. after applying liquid gasket.

Liquid gasket:

THREE BOND 1217G (Part No. K0877Y0100) or equivalent



(A) O-ring

Fig. 215: Identifying Liquid Gasket Applying Area
Courtesy of SUBARU OF AMERICA, INC.

3. Apply a coat of engine oil to the inside of oil seal.

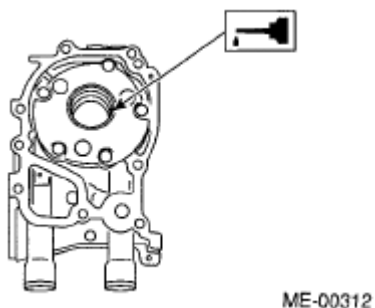


Fig. 216: Identifying Engine Oil Applying Area
Courtesy of SUBARU OF AMERICA, INC.

4. Install the oil pump to cylinder block. Be careful not to damage the oil seal during installation.

NOTE:

- Make sure the oil seal lip is not folded.
- Align the flat surface of oil pump's inner rotor with crankshaft before installation.
- Use new O-rings and oil seals.
- Do not forget to assemble O-rings.

5. Apply liquid gasket to the three bolts thread shown in figure, (when reusing bolts)

Liquid gasket:

THREE BOND 1324 (Part No. 004403042) or equivalent

Tightening torque:

T: 6.4 N.m (0.65 kgf-m, 4.7 ft-lb)

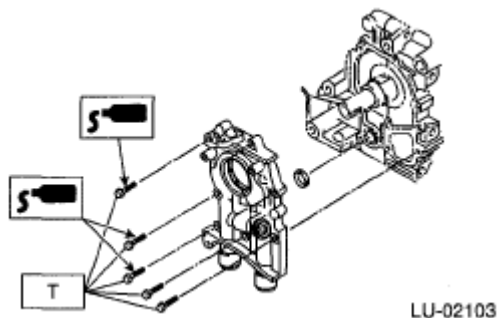


Fig. 217: Identifying Liquid Gasket Applying Area
Courtesy of SUBARU OF AMERICA, INC.

32. Install the service hole plug and gasket.

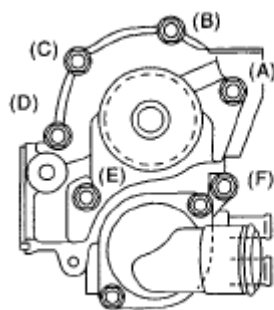
NOTE:

- When installing the water pump, tighten bolts in two stages in alphabetical order as shown in the figure.
- Use a new gasket.

Tightening torque:

First: 12 N.m (1.2 kgf-m, 8.7 ft-lb)

Second: 12 N.m (1.2 kgf-m, 8.7 ft-lb)



ME-02463

Fig. 218: Identifying Service Hole Plug And Gasket
Courtesy of SUBARU OF AMERICA, INC.

33. Install the water by-pass pipe for heater.

Tightening torque:

6.4 N.m (0.65 kgf-m, 4.7 ft-lb)

34. Install the oil filter. <Ref. to **INSTALLATION**, Engine Oil Filter. >
35. Install the cylinder head. <Ref. to **INSTALLATION**, Cylinder Head. >
36. Install the camshaft. <Ref. to **INSTALLATION**, Camshaft. >
37. Install the valve rocker assembly. <Ref. to **INSTALLATION**, Valve Rocker Assembly. >
38. Install the generator and A/C compressor with their brackets.

Tightening torque:

36 N.m (3.7 kgf-m, 26.6 ft-lb)

39. Install the crank sprocket. <Ref. to **INSTALLATION**, Crank Sprocket. >
40. Install the cam sprocket. <Ref. to **INSTALLATION**, Cam Sprocket. >
41. Install the timing belt. <Ref. to **INSTALLATION**, Timing Belt. >
42. Adjust the valve clearance. <Ref. to **ADJUSTMENT**, Valve Clearance. >
43. Install the rocker cover.

1. Install the rocker cover gasket to the rocker cover.

NOTE: Use a new rocker cover gasket.

2. Temporarily tighten the bolts in alphabetical sequence as shown in figure, then tighten the bolt in 2 steps.

Tightening torque:

1st

6.4 N.m (0.65 kgf-m, 4.7 ft-lb)

2nd (only (a) and (b) are tightened)

6.4 N.m (0.65 kgf-m, 4.7 ft-lb)

RH side

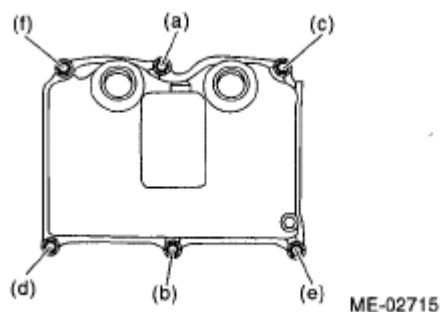


Fig. 219: Identifying Rocker Cover Gasket Bolts Torque Sequence - RH Side
Courtesy of SUBARU OF AMERICA, INC.

LH side

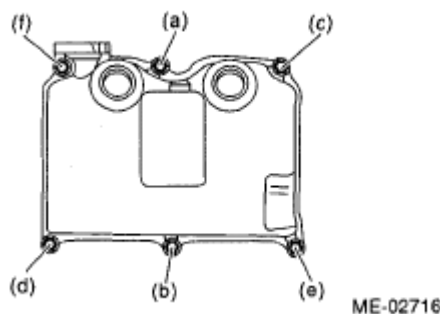
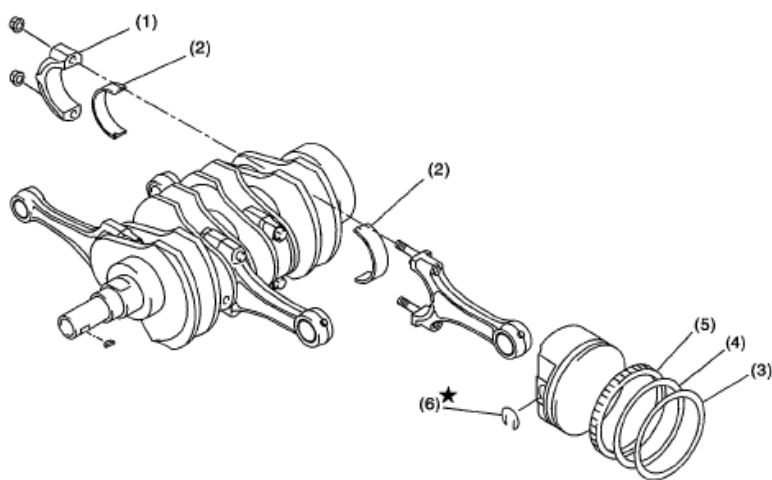


Fig. 220: Identifying Rocker Cover Gasket Bolts Torque Sequence - LH Side
Courtesy of SUBARU OF AMERICA, INC.

44. Install the timing belt cover. <Ref. to **INSTALLATION**, Timing Belt Cover. >
45. Install the crank pulley. <Ref. to **INSTALLATION**, Crank Pulley. >
46. Install the intake manifold. <Ref. to **INSTALLATION**, Intake Manifold. >
47. Install the V-belts. <Ref. to **INSTALLATION**, V-belt. >

DISASSEMBLY



ME-02411

- (1) Connecting rod cap
- (2) Connecting rod bearing

- (3) Top ring
- (4) Second ring

- (5) Oil ring
- (6) Snap ring

Fig. 221: Identifying Connecting Rod Components
 Courtesy of SUBARU OF AMERICA, INC.

1. Remove the connecting rod cap.
2. Remove the connecting rod bearing.

NOTE: Keep the removed connecting rods, connecting rod caps and bearings in order so that they are kept in their original combinations/groups, and not mixed together.

3. Remove the piston rings using piston ring expander.
4. Remove the oil ring by hand.

NOTE: Arrange the removed piston rings in proper order, to prevent confusion.

5. Remove the snap ring.

ASSEMBLY

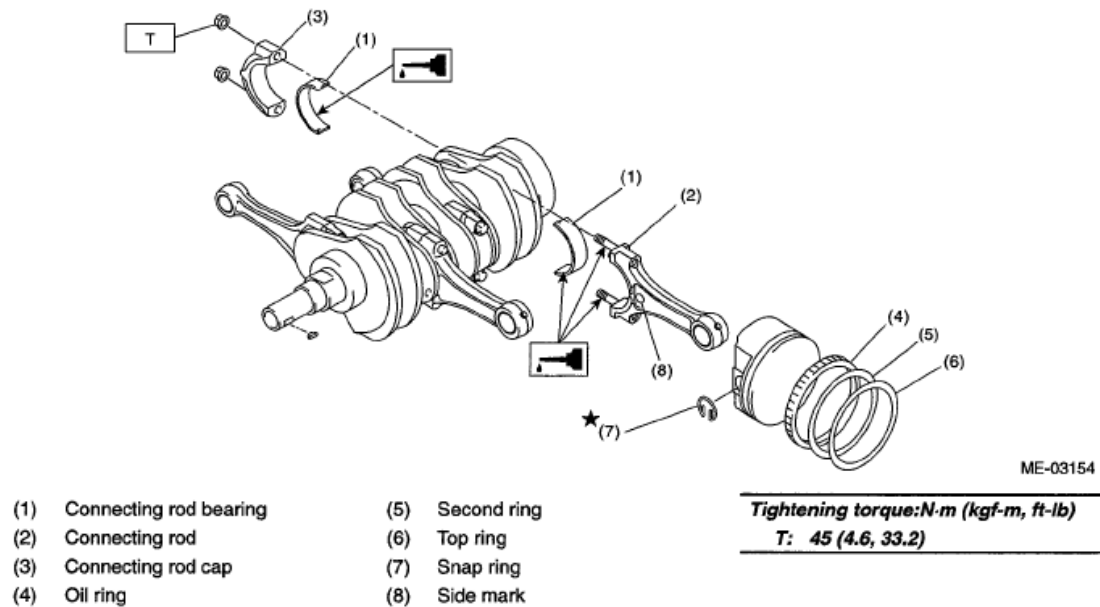


Fig. 222: Identifying Connecting Rod Components With Torque Specifications
 Courtesy of SUBARU OF AMERICA, INC.

1. Apply oil to the surface of the connecting rod bearings, and install the connecting rod bearings on connecting rods and connecting rod caps.
2. Position each connecting rod with the side with a side mark facing forward, and install it.
3. Attach the connecting rod cap, and tighten with connecting rod nut. Make sure the arrow mark on connecting rod cap facing front during installation.

NOTE:

- Each connecting rod has its own mating cap. Make sure that they are assembled correctly by checking their matching number.
- When tightening the connecting rod nuts, apply oil on the threads.

Tightening torque:

45 N·m (4.6 kgf-m, 33.2 ft-lb)

4. Install the oil ring upper rail, expander and lower rail by hand.
5. Install the second ring and top ring using piston ring expander.

NOTE: Assemble so that the piston ring mark "R" faces the top side of the piston.

INSPECTION

CYLINDER BLOCK

1. Check for cracks or damage. Use liquid penetrant tester on the important sections to check for fissures. Check that there are no marks of gas leaking or water leaking on gasket installing surface.

2. Check the oil passages for clogging.
3. Inspect the cylinder head to cylinder block mating surface for warpage by using a straight edge, and correct by grinding if necessary.

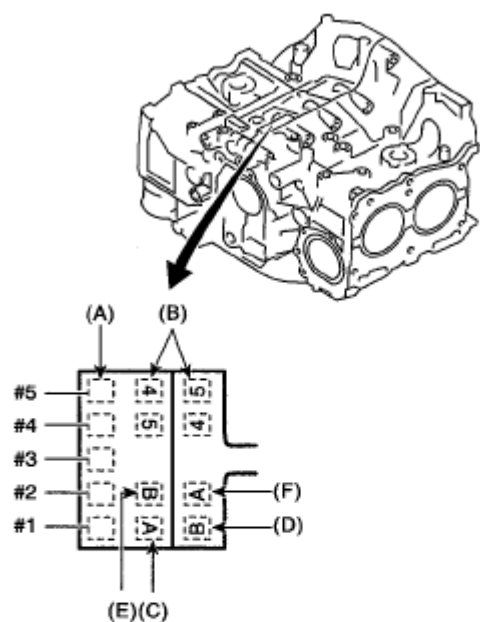
Warping limit:***0.025 mm (0.00098 in)******Grinding limit:******0.1 mm (0.004 in)******Standard height of cylinder block:******201.0 mm (7.91 in)*****CYLINDER AND PISTON**

1. The cylinder bore size is stamped on the front upper face of the cylinder block.

NOTE:

- Measurement should be performed at a temperature of 20°C (68°F).
- Standard sized pistons are classified into two grades, "A" and "B". These grades should be used as guide lines in selecting a standard piston.

Standard diameter:***A: 99.505 - 99.515 mm (3.9175 - 3.9179 in)******B: 99.495 - 99.505 mm (3.9171 - 3.9175 in)***



ME-00170

- (A) Main journal size mark
- (B) Cylinder block (RH) — (LH) combination mark
- (C) #1 cylinder bore size mark
- (D) #2 cylinder bore size mark
- (E) #3 cylinder bore size mark
- (F) #4 cylinder bore size mark

Fig. 223: Identifying Piston Classified Grades
 Courtesy of SUBARU OF AMERICA, INC.

2. Measure the inner diameters of the cylinders. Measure the inner diameter of each cylinder in both the thrust and piston pin directions at the heights as shown in the figure, using a cylinder bore gauge.

NOTE: Measurement should be performed at a temperature of 20°C (68°F).

Taper:

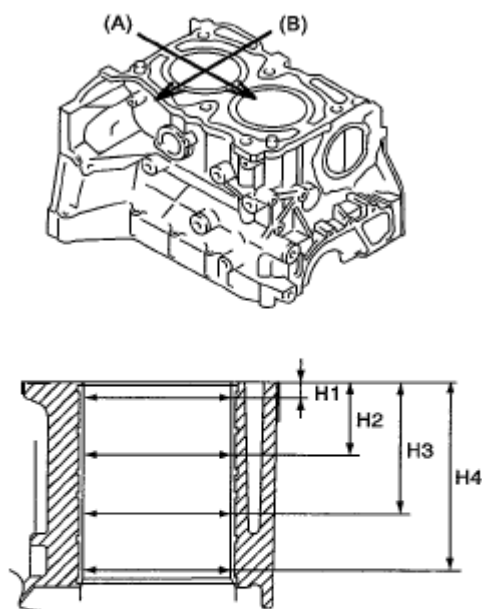
Standard:

0.015 mm (0.0006 in)

Out-of-roundness:

Standard:

0.010 mm (0.0004 in)



ME-00171

(A) Piston pin direction

(B) Thrust direction

H1 10 mm (0.39 in)

H2 45 mm (1.77 in)

H3 80 mm (3.15 in)

H4 115 mm (4.53 in)

Fig. 224: Measuring Inner Diameters Of Cylinders

Courtesy of SUBARU OF AMERICA, INC.

3. When the piston is to be replaced due to general or cylinder wear, determine a suitable sized piston by measuring the piston clearance.
4. Measure the outer diameters of the pistons. Measure the outer diameter of each piston at the height as shown in the figure. (Thrust direction)

NOTE: Measurement should be performed at a temperature of 20°C (68°F).

Piston grade point H:

38.2 mm (1.504 in)

Standard:

A: 99.505 - 99.515 mm (3.9175 - 3.9179 in)

B: 99.495 - 99.505 mm (3.9171 - 3.9175 in)

0.25 mm (0.0098 in) oversize:

99.745 - 99.765 mm (3.9270 - 3.9278 in)

0.50 mm (0.0197 in) oversize:

99.995 - 100.015 mm (3.9368 - 3.9376 in)

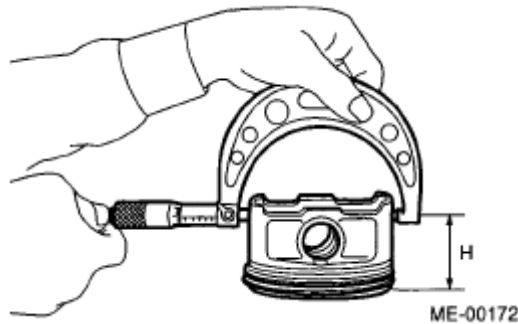


Fig. 225: Measuring Outer Diameters Of Pistons
Courtesy of SUBARU OF AMERICA, INC.

5. Calculate the clearance between cylinder and piston.

NOTE: Measurement should be performed at a temperature of 20°C (68°F).

Cylinder to piston clearance at 20°C (68°F):

Standard:

-0.010 - 0.010 mm (-0.00039 - 0.00039 in)

6. Boring and honing

1. If any of the measured value of taper, out-of-roundness or cylinder-to-piston clearance is out of standard or if there is any damage on the cylinder wall, rebore it to replace with an oversize piston.

CAUTION: When any of the cylinders needs reboring, other cylinders must be bored at the same time, and replaced with oversize pistons.

2. If the cylinder inner diameter exceeds the limit after boring and honing, replace the cylinder block.

NOTE: Immediately after reboring, the cylinder diameter may differ from its real diameter due to temperature rise. Thus, when measuring the cylinder diameter, wait until it has cooled to room temperature.

Cylinder inner diameter boring limit (diameter):

To 100.005 mm (3.9372 in)

PISTON AND PISTON PIN

1. Check the piston and piston pin for breaks, cracks or wear. Replace if faulty.
2. Check the piston ring groove for wear and damage. Replace if faulty.
3. Make sure that the piston pin can be inserted into the piston pin hole with a thumb at 20°C (68°F). Replace if faulty.

Clearance between piston hole and piston pin:

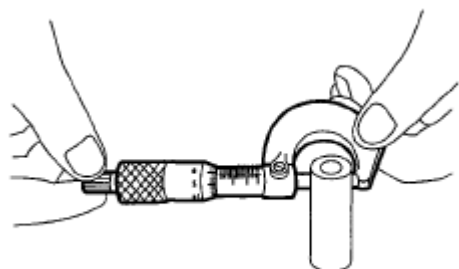
Standard

0.004 - 0.008 mm (0.0002 - 0.0003 in)



ME-00173

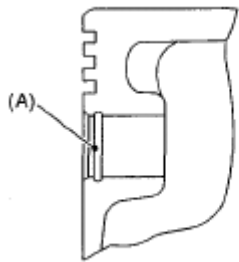
Fig. 226: Measuring Piston Hole Diameter
Courtesy of SUBARU OF AMERICA, INC.



ME-00174

Fig. 227: Measuring Piston Pin Diameter
Courtesy of SUBARU OF AMERICA, INC.

4. Check the snap ring installation groove (A) on the piston for burr. If necessary, remove burr from the groove so that the piston pin can lightly move.



ME-00175

Fig. 228: Identifying Snap Ring Groove
 Courtesy of SUBARU OF AMERICA, INC.

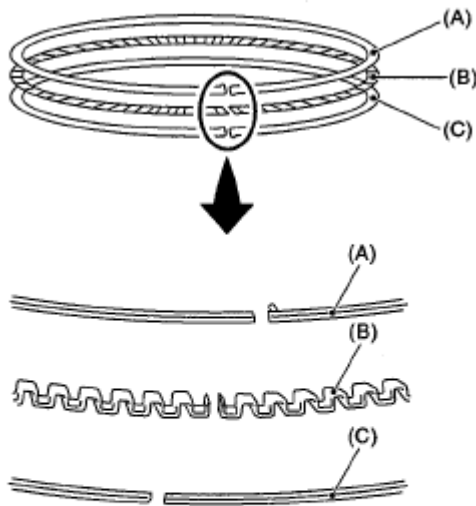
5. Check the piston pin snap ring for distortion, cracks and wear.

PISTON RING

1. If the piston ring is broken, damaged and worn, or if its tension is insufficient, or when the piston is replaced, replace the piston ring with a new part of the same size as the piston.

NOTE:

- The top ring and second ring have the mark to determine the direction to install on them. When installing them to piston, face this mark to the top side.
- Oil ring consists of the upper rail, expander and lower rail. Be careful about the direction of rail when installing the oil ring to piston.



ME-02480

- (A) Upper rail
 (B) Expander
 (C) Lower rail

Fig. 229: Identifying Piston Ring Grooves
 Courtesy of SUBARU OF AMERICA, INC.

2. Squarely place the piston ring and oil ring in cylinder using the piston, and measure the piston ring gap with a thickness gauge.

PISTON RING GAP SPECIFICATION

		Standard mm (in)
Piston ring gap	Top ring	0.20 - 0.35 (0.0079 - 0.0138)
	Second ring	0.37 - 0.52 (0.0144 - 0.0203)
	Oil ring rail	0.20 - 0.50 (0.0079 - 0.0197)

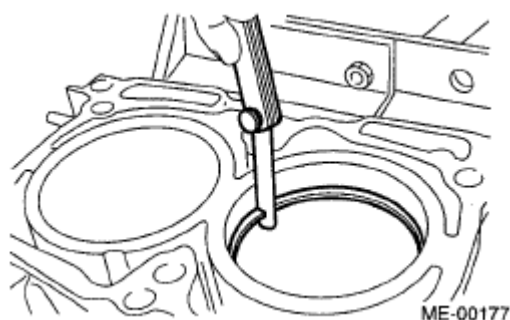


Fig. 230: Measuring Piston Ring Gap
 Courtesy of SUBARU OF AMERICA, INC.

3. Fit the piston ring straight into the piston ring groove, then measure the clearance between piston ring and piston ring groove with a thickness gauge.

NOTE: Before measuring the clearance, clean the piston ring groove and piston ring.

PISTON RING AND GROOVE CLEARANCE SPECIFICATION

		Standard mm (in)
Clearance between piston ring and piston ring groove	Top ring	0.040 - 0.080 (0.0016 - 0.0031)
	Second ring	0.030 - 0.070 (0.0012 - 0.0028)

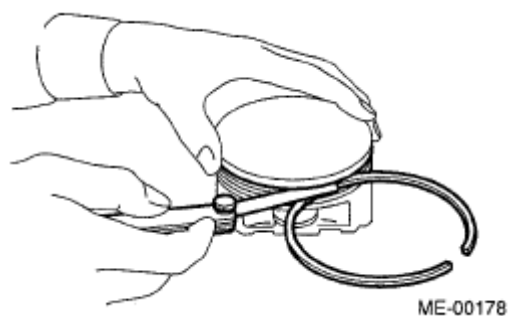


Fig. 231: Measuring Clearance Between Piston Ring And Piston Ring Groove

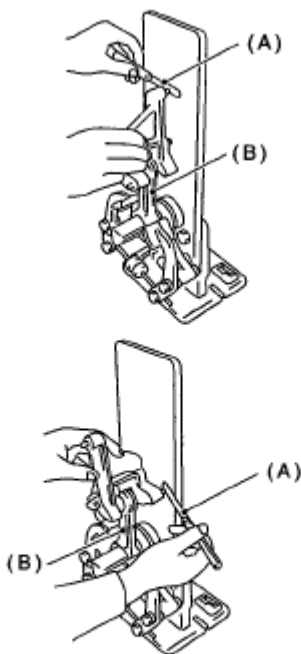
Courtesy of SUBARU OF AMERICA, INC.

CONNECTING ROD

1. Replace the connecting rod, if the large end thrust surface is damaged.
2. Check for bend or twist using a connecting rod aligner. Replace the connecting rod if the bend or twist exceeds the limit.

Limit of bend or twist per 100 mm (3.94 in) in length:

0.10 mm (0.0039 in)



ME-00179

- (A) Thickness gauge
(B) Connecting rod

Fig. 232: Checking Connecting Rod Clearance
Courtesy of SUBARU OF AMERICA, INC.

3. Install the connecting rod fitted with bearing to the crankshaft, and measure the thrust clearance using a thickness gauge. If the thrust clearance exceeds the standard or uneven wear is found, replace the connecting rod.

Connecting rod thrust clearance:

Standard

0.070 - 0.330 mm (0.0028 - 0.0130 in)

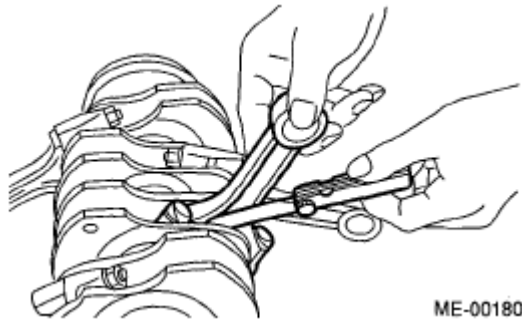


Fig. 233: Measuring Connecting Rod Thrust Clearance:
Courtesy of SUBARU OF AMERICA, INC.

4. Inspect the connecting rod bearing for scar, peeling, seizure, melting, wear, etc.
5. Measure the oil clearance on each connecting rod bearing using plastigauge. If any oil clearance is not within the standard, replace the defective bearing with a new part of standard size or undersize as necessary.

Connecting rod oil clearance:

Standard

0.016 - 0.044 mm (0.00063 - 0.0017 in)

CONNECTING ROD SPECIFICATION

Unit: mm (in)		
Bearing	Bearing size (Thickness at center)	Outer diameter of crank pin
Standard	1.492 - 1.501 (0.0587 - 0.0591)	51.984 - 52.000 (2.0466 - 2.0472)
0.03 (0.0012) Undersize	1.510 - 1.513 (0.0594 - 0.0596)	51.954 - 51.970 (2.0454 - 2.0461)
0.05 (0.0020) Undersize	1.520 - 1.523 (0.0598 - 0.0600)	51.934 - 51.950 (2.0446 - 2.0453)
0.25 (0.0098) Undersize	1.620 - 1.623 (0.0638 - 0.0639)	51.734 - 51.750 (2.0368 - 2.0374)

6. Inspect the bushing at connecting rod small end, and replace with a new part if worn or damaged.
7. Measure the piston pin clearance at connecting rod small end. If the measured value is not within the standard, replace it with a new part.

Clearance between piston pin and bushing:

Standard

0 - 0.022 mm (0 - 0.0009 in)

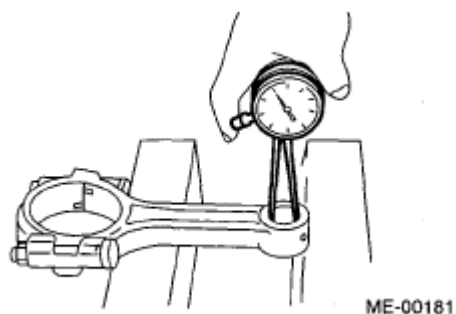


Fig. 234: Measuring Connecting Rod Small End Inner Diameter
Courtesy of SUBARU OF AMERICA, INC.

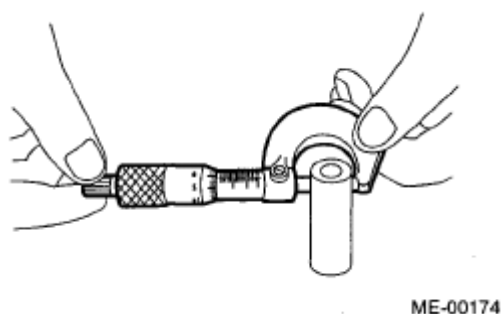


Fig. 235: Measuring Piston Pin Outer Diameter
Courtesy of SUBARU OF AMERICA, INC.

8. The replacement procedure for the connecting rod small end bushing is as follows.
1. Remove the bushing from connecting rod with ST and press.
 2. Press the bushing with the ST after applying oil on the periphery of new bushing.

ST 499037100 CONNECTING ROD BUSHING REMOVER AND INSTALLER

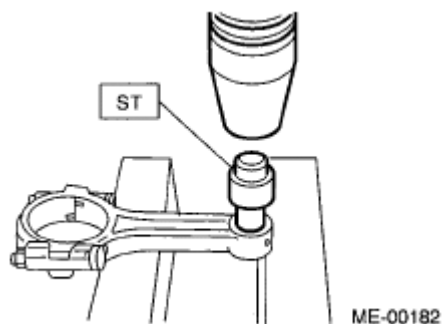


Fig. 236: Pressing Bushing
Courtesy of SUBARU OF AMERICA, INC.

3. Make two 3 mm (0.12 in) holes in the pressed bushing by aligning with the pre-manufactured holes on the connecting rod, and ream the inside of the bushing.
4. After completion of reaming, clean the bushing to remove chips.

CRANKSHAFT AND CRANKSHAFT BEARING

1. Clean the crankshaft completely, and check it for cracks using liquid penetrant tester. If defective, replace the crankshaft.
2. Measure the bend of crankshaft. If it exceeds the limit, correct or replace it.

NOTE: If a suitable V-block is not available, using just the #1 and #5 crankshaft bearings on cylinder block, position the crankshaft on cylinder block. Then, measure the crankshaft bend using a dial gauge.

Crankshaft bend limit:

0.035 mm (0.0014 in)

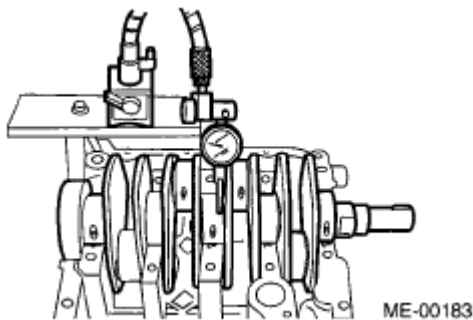


Fig. 237: Measuring Bend Of Crankshaft
Courtesy of SUBARU OF AMERICA, INC.

3. Inspect the crank journal and crank pin for wear. If they are not within the specification, replace the bearing with a suitable (undersize) one, and replace or grind to correct the crankshaft as necessary. When grinding the crank journal or crank pin, finish them to the specified dimensions according to the undersize bearing to be used.

Crank pin:

Out-of-roundness

0.003 mm (0.0001 in)

Cylindrically

0.004 mm (0.0002 in)

Grinding limit (dia.)

To 51.750 mm (2.0374 in)

Crank journal:

Out-of-roundness

0.005 mm (0.0002 in)

Cylindrically

0.006 mm (0.0002 in)

Grinding limit (dia.)

To 59.758 mm (2.3527 in)



Fig. 238: Measuring Crank Journal Outer Diameter
Courtesy of SUBARU OF AMERICA, INC.

CRANK JOURNAL OUTER DIAMETER SPECIFICATION

		Unit: mm (in)		
		Crank journal outer diameter		Crank pin outer diameter
		#1, #3	#2, #4, #5	
Standard	Journal O.D.	59.992 - 60.008 (2.3619 - 2.3625)	59.992 - 60.008 (2.3619 - 2.3625)	51.984 - 52.000 (2.0466 - 2.0472)
	Bearing size (Thickness at center)	1.998 - 2.011 (0.0787 - 0.0792)	2.000 - 2.013 (0.0787 - 0.0793)	1.492 - 1.501 (0.0587 - 0.0591)
0.03 (0.0012) Undersize	Journal O.D.	59.962 - 59.978 (2.3607 - 2.3613)	59.962 - 59.978 (2.3607 - 2.3613)	51.954 - 51.970 (2.0454 - 2.0461)
	Bearing size (Thickness at center)	2.017 - 2.020 (0.0794 - 0.0795)	2.019 - 2.022 (0.0795 - 0.0796)	1.510 - 1.513 (0.0594 - 0.0596)
0.05 (0.0020) Undersize	Journal O.D.	59.942 - 59.958 (2.3599 - 2.3605)	59.942 - 59.958 (2.3599 - 2.3605)	51.934 - 51.950 (2.0446 - 2.0453)
	Bearing size (Thickness at center)	2.027 - 2.030 (0.0798 - 0.0799)	2.029 - 2.032 (0.0799 - 0.0800)	1.520 - 1.523 (0.0598 - 0.0600)
0.25 (0.0098) Undersize	Journal O.D.	59.742 - 59.758 (2.3520 - 2.3527)	59.742 - 59.758 (2.3520 - 2.3527)	51.734 - 51.750 (2.0368 - 2.0374)
	Bearing size (Thickness at center)	2.127 - 2.130 (0.0837 - 0.0839)	2.129 - 2.132 (0.0838 - 0.0839)	1.620 - 1.623 (0.0638 - 0.0639)

4. Use a thickness gauge to measure the thrust clearance of the crankshaft at the #5 crank journal bearing. If the thrust clearance is not within the standard, replace the bearing.

Crankshaft thrust clearance:***Standard***

0.030 - 0.115 mm (0.0012 - 0.0045 in)

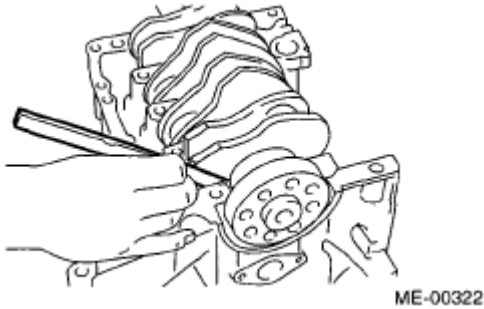


Fig. 239: Measuring Crankshaft Thrust Clearance
Courtesy of SUBARU OF AMERICA, INC.

5. Inspect individual crankshaft bearings for signs of flaking, seizure, melting and wear.
6. Measure the oil clearance on each crankshaft bearing using plastigauge. If the measured value is out of standard, replace the defective bearing with an undersize one, and replace or grind to correct the crankshaft as necessary.

Crankshaft oil clearance:***Standard***

0.010 - 0.030 mm (0.0004 - 0.0012 in)

OIL SWITCHING SOLENOID VALVE

REMOVAL

RH SIDE

1. Disconnect the ground cable from the battery.

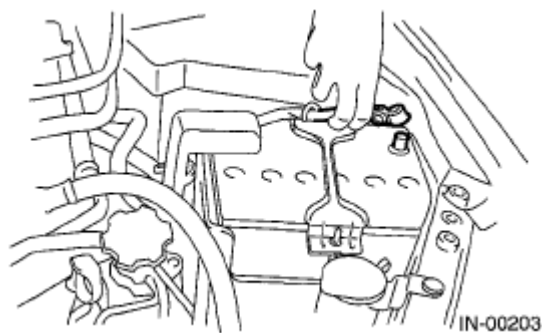


Fig. 240: Disconnecting Ground Cable From Battery
Courtesy of SUBARU OF AMERICA, INC.

2. Remove the air intake chamber.

<Ref. to **REMOVAL** , Air Intake Chamber . >

3. Remove the engine harness connector from the bracket.

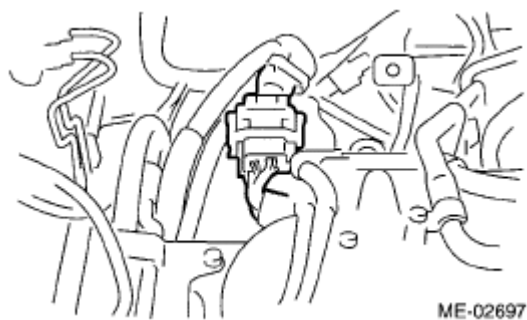


Fig. 241: Identifying Engine Harness Connector
Courtesy of SUBARU OF AMERICA, INC.

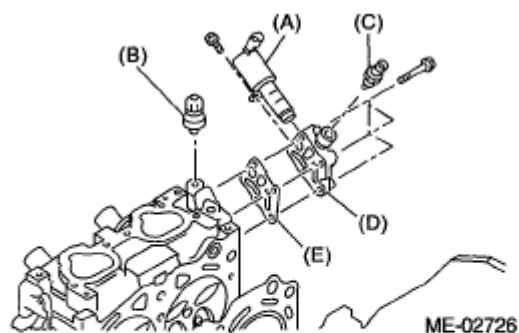
4. Disconnect the connector from the oil switching solenoid valve.
5. Remove the oil switching solenoid valve.
6. Remove the variable valve lift diagnosis oil pressure switch.

<Ref. to **REMOVAL** , Variable Valve Lift Diagnosis Oil Pressure Switch . >

7. Remove the oil temperature sensor.

<Ref. to **REMOVAL** , Oil Temperature Sensor . >

8. Remove the oil switching solenoid valve holder from the cylinder head.



- (A) Oil switching solenoid valve
- (B) Variable valve lift diagnosis oil pressure switch
- (C) Oil temperature sensor
- (D) Oil switching solenoid valve holder
- (E) Gasket

Fig. 242: Identifying Oil Switching Solenoid Valve Components
 Courtesy of SUBARU OF AMERICA, INC.

LH SIDE

1. Disconnect the ground cable from the battery.

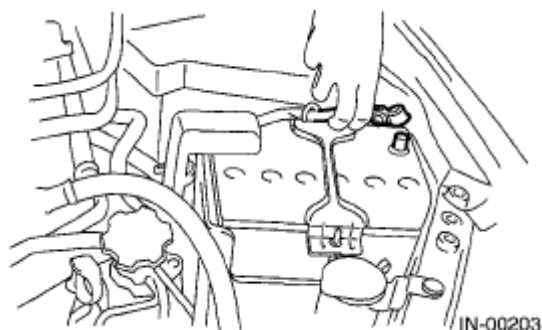


Fig. 243: Disconnecting Ground Cable From Battery
 Courtesy of SUBARU OF AMERICA, INC.

2. Remove the V-belts.

<Ref. to **REMOVAL**, V-belt. >

3. Remove the crank pulley.

<Ref. to **REMOVAL**, Crank Pulley. >

4. Remove the timing belt cover.

<Ref. to **REMOVAL**, Timing Belt Cover. >

5. Remove the timing belt.

<Ref. to **REMOVAL**, Timing Belt. >

6. Remove the cam sprocket.

<Ref. to **REMOVAL**, Cam Sprocket. >

7. Remove the timing belt cover No. 2 (LH).

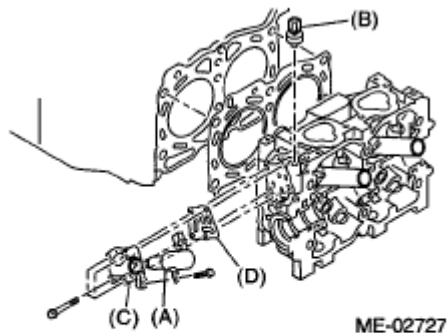
8. Disconnect the connector from the oil switching solenoid valve.

9. Remove the oil switching solenoid valve.

10. Remove the variable valve lift diagnosis oil pressure switch.

<Ref. to **REMOVAL**, Variable Valve Lift Diagnosis Oil Pressure Switch . >

11. Remove the oil switching solenoid valve holder from the cylinder head.



- (A) Oil switching solenoid valve
- (B) Variable valve lift diagnosis oil pressure switch
- (C) Oil switching solenoid valve holder
- (D) Gasket

Fig. 244: Identifying Oil Switching Solenoid Valve Components

Courtesy of SUBARU OF AMERICA, INC.

INSTALLATION

RH SIDE

Install in the reverse order of removal.

NOTE:

- Use a new gasket.
- Apply liquid gasket to variable valve lift diagnosis oil pressure switch threads.
- Install the oil switching solenoid valve to the holder, then install it to the cylinder head.

Tightening torque:

T1

8 N.m (0.8 kgf-m, 5.9 ft-lb)

T2

10 N.m (1.0 kgf-m, 7.4 ft-lb)

T3

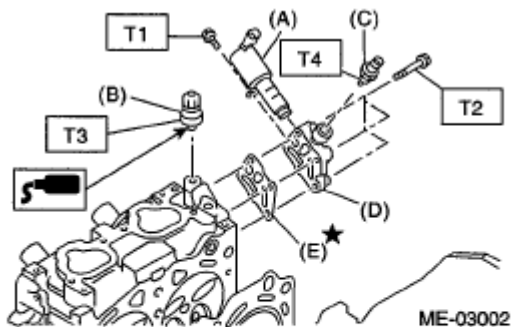
17 N.m (1.7 kgf-m, 12.5 ft-lb)

T4

18 N.m (1.8 kgf-m, 13.3 ft-lb)

Liquid gasket

THREE BOND 1324 (Part No. 004403042) or equivalent



- (A) Oil switching solenoid valve
- (B) Variable valve lift diagnosis oil pressure switch
- (C) Oil temperature sensor
- (D) Oil switching solenoid valve holder
- (E) Gasket

Fig. 245: Identifying Oil Switching Solenoid Valve Components
 Courtesy of SUBARU OF AMERICA, INC.

LH SIDE

Install in the reverse order of removal.

NOTE:

- Use a new gasket.
- Apply liquid gasket to variable valve lift diagnosis oil pressure switch

threads.

- Install the oil switching solenoid valve to the holder, then install it to the cylinder head.

Tightening torque:

T1

8 N.m (0.8 kgf-m, 5.9 ft-lb)

T2

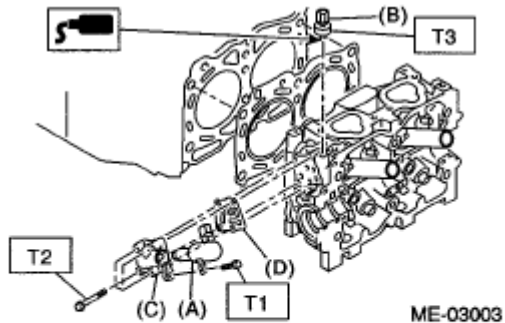
10 N.m (1.0 kgf-m, 7.4 ft-lb)

T3

17 N.m (1.7 kgf-m, 12.5 ft-lb)

Liquid gasket

THREE BOND 1324 (Part No. 004403042) or equivalent



- (A) Oil switching solenoid valve
- (B) Variable valve lift diagnosis oil pressure switch
- (C) Oil switching solenoid valve holder
- (D) Gasket

Fig. 246: Identifying Oil Switching Solenoid Valve Components
Courtesy of SUBARU OF AMERICA, INC.

INTAKE AND EXHAUST VALVE

SPECIFICATION

Refer to "**CYLINDER HEAD**" for removal and installation procedures of intake and exhaust valves. <Ref. to **REMOVAL**, Cylinder Head . > <Ref. to **INSTALLATION**, Cylinder Head. >

PISTON

SPECIFICATION

Refer to "**CYLINDER BLOCK**" for removal and installation procedures of pistons. <Ref. to **REMOVAL**, Cylinder Block. > <Ref. to **INSTALLATION**, Cylinder Block. >

CONNECTING ROD

SPECIFICATION

Refer to "**CYLINDER BLOCK**" for removal and installation procedures of connecting rod. <Ref. to **REMOVAL**, Cylinder Block. > <Ref. to **INSTALLATION**, Cylinder Block. >

CRANKSHAFT

SPECIFICATION

Refer to "**CYLINDER BLOCK**" for removal and installation procedures of the crankshaft. <Ref. to **REMOVAL**, Cylinder Block. > <Ref. to **INSTALLATION**, Cylinder Block. >

ENGINE TROUBLE IN GENERAL

INSPECTION

NOTE: The "RANK" shown in the chart shows the possibilities of the cause of trouble in order from "Very often" to "Rarely".

A - Very often

B - Sometimes

C - Rarely

PROBLEM SYMPTOMS CHART

Symptoms	Problem parts etc.	Possible cause	RANK
1. Engine does not start.			
1) Starter does not turn.	Starter	Defective battery-to-starter harness	B
		Defective starter switch	C
		Defective inhibitor switch	C
		Defective starter	B
	Battery	Improper connection of the terminal	A
		Run-down battery	A

2008 Subaru Impreza 2.5i

2008 ENGINE Mechanical (H4SO Engine) - Impreza

	Friction	Defective charging system	B
		Seizure of crankshaft and connecting rod bearing	C
		Seized camshaft	C
		Seized or stuck piston and cylinder	C
2) Initial combustion does not occur.	Starter	Defective starter	C
	Engine control system <Ref. to <u>BASIC DIAGNOSTIC PROCEDURE</u> . >		A
	Fuel line	Defective fuel pump and relay	A
		Clogged fuel line	B
		Lack of or insufficient fuel	B
	Timing belt	Degradation, etc.	B
		Defective timing	B
	Compression	Incorrect valve clearance	C
		Loosened spark plug or defective gasket	C
		Loosened cylinder head bolt or defective gasket	C
		Improper valve sealing	C
		Defective valve stem	C
		Worn or broken valve spring	B
		Worn or stuck piston rings, cylinder and piston	C
		Incorrect valve timing	B
		Improper engine oil (low viscosity)	B
3) Initial combustion occurs.	Engine control system <Ref. to <u>BASIC DIAGNOSTIC PROCEDURE</u> . >		A
	Intake system	Defective intake manifold gasket	B
		Defective throttle body gasket	B
	Fuel line	Defective fuel pump and relay	C
		Clogged fuel line	C
		Lack of or insufficient fuel	B
	Timing belt	Degradation, etc.	B
		Defective timing	B
	Compression	Incorrect valve clearance	C
		Loosened spark plug or defective gasket	C
		Loosened cylinder head bolt or defective gasket	C
		Improper valve sealing	C
		Defective valve stem	C
		Worn or broken valve spring	B
		Worn or stuck piston rings, cylinder and piston	C

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		Incorrect valve timing	B
		Improper engine oil (low viscosity)	B
4) Engine stalls after initial combustion.	Engine control system <Ref. to <u>BASIC DIAGNOSTIC PROCEDURE</u> . >		A
	Intake system	Loosened or cracked intake duct	B
		Loosened or cracked PCV hose	C
		Loosened or cracked vacuum hose	C
		Defective intake manifold gasket	B
		Defective throttle body gasket	B
		Dirty air cleaner element	C
	Fuel line	Clogged fuel line	C
		Lack of or insufficient fuel	B
	Timing belt	Degradation, etc.	B
		Defective timing	B
	Compression	Incorrect valve clearance	C
		Loosened spark plug or defective gasket	C
		Loosened cylinder head bolt or defective gasket	C
		Improper valve sealing	C
		Defective valve stem	C
		Worn or broken valve spring	B
		Worn or stuck piston rings, cylinder and piston	C
		Incorrect valve timing	B
		Improper engine oil (low viscosity)	B
2. Rough idle and engine stall	Engine control system <Ref. to <u>BASIC DIAGNOSTIC PROCEDURE</u> . >		A
	Intake system	Loosened or cracked intake duct	A
		Loosened or cracked PCV hose	A
		Loosened or cracked vacuum hose	A
		Defective intake manifold gasket	B
		Defective throttle body gasket	B
		Defective PCV valve	C
		Loosened oil filler cap	B
		Dirty air cleaner element	C
	Fuel line	Defective fuel pump and relay	C
		Clogged fuel line	C
		Lack of or insufficient fuel	B
	Timing belt	Defective timing	C
		Incorrect valve clearance	B
		Loosened spark plug or defective gasket	B
		Loosened cylinder head bolt or defective	

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	Compression	gasket	B
		Improper valve sealing	B
		Defective valve stem	C
		Worn or broken valve spring	B
		Worn or stuck piston rings, cylinder and piston	B
		Incorrect valve timing	A
		Improper engine oil (low viscosity)	B
	Lubrication system	Incorrect oil pressure	B
		Defective rocker cover gasket	C
	Cooling system	Overheating	C
	Others	Evaporative emission control system malfunction	A
		Stuck or damaged throttle valve	B
3. Low output, hesitation and poor acceleration	Engine control system <Ref. to <u>BASIC DIAGNOSTIC PROCEDURE</u> . >		A
	Intake system	Loosened or cracked intake duct	A
		Loosened or cracked PCV hose	A
		Loosened or cracked vacuum hose	B
		Defective intake manifold gasket	B
		Defective throttle body gasket	B
		Defective PCV valve	B
		Loosened oil filler cap	B
		Dirty air cleaner element	A
	Fuel line	Defective fuel pump and relay	B
		Clogged fuel line	B
		Lack of or insufficient fuel	C
	Timing belt	Defective timing	B
	Compression	Incorrect valve clearance	B
		Loosened spark plug or defective gasket	B
		Loosened cylinder head bolt or defective gasket	B
		Improper valve sealing	B
		Defective valve stem	C
		Worn or broken valve spring	B
		Worn or stuck piston rings, cylinder and piston	C
		Incorrect valve timing	A
		Improper engine oil (low viscosity)	B
	Lubrication system	Incorrect oil pressure	B
		Overheating	C

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	Cooling system	Over-cooling	C
	Others	Evaporative emission control system malfunction	A
4. Surging	Engine control system <Ref. to <u>BASIC DIAGNOSTIC PROCEDURE</u> . >		A
	Intake system	Loosened or cracked intake duct	A
		Loosened or cracked PCV hose	A
		Loosened or cracked vacuum hose	A
		Defective intake manifold gasket	B
		Defective throttle body gasket	B
		Defective PCV valve	B
		Loosened oil filler cap	B
		Dirty air cleaner element	B
	Fuel line	Defective fuel pump and relay	B
		Clogged fuel line	B
		Lack of or insufficient fuel	C
	Timing belt	Defective timing	B
	Compression	Incorrect valve clearance	B
		Loosened spark plug or defective gasket	C
		Loosened cylinder head bolt or defective gasket	C
		Improper valve sealing	C
		Defective valve stem	C
		Worn or broken valve spring	C
		Worn or stuck piston rings, cylinder and piston	C
		Incorrect valve timing	A
		Improper engine oil (low viscosity)	B
	Cooling system	Overheating	B
	Others	Evaporative emission control system malfunction	C
5. Engine does not return to idle.	Engine control system <Ref. to <u>BASIC DIAGNOSTIC PROCEDURE</u> . >		A
	Intake system	Loosened or cracked vacuum hose	A
	Others	Stuck or damaged throttle valve	A
6. Dieseling (Run-on)	Engine control system <Ref. to <u>BASIC DIAGNOSTIC PROCEDURE</u> . >		A
	Cooling system	Overheating	B
	Others	Evaporative emission control system malfunction	B
	Engine control system <Ref. to <u>BASIC DIAGNOSTIC PROCEDURE</u> . >		A

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7. After burning in exhaust system	Intake system	Loosened or cracked intake duct	C
		Loosened or cracked PCV hose	C
		Loosened or cracked vacuum hose	B
		Defective PCV valve	B
		Loosened oil filler cap	C
	Timing belt	Defective timing	B
	Compression	Incorrect valve clearance	B
		Loosened spark plug or defective gasket	C
		Loosened cylinder head bolt or defective gasket	C
		Improper valve sealing	B
		Defective valve stem	C
		Worn or broken valve spring	C
		Worn or stuck piston rings, cylinder and piston	C
		Incorrect valve timing	A
	Lubrication system	Incorrect oil pressure	C
	Cooling system	Over-cooling	C
	Others	Evaporative emission control system malfunction	C
8. Knocking	Engine control system <Ref. to <u>BASIC DIAGNOSTIC PROCEDURE</u> . >		A
	Intake system	Loosened oil filler cap	B
	Timing belt	Defective timing	B
	Compression	Incorrect valve clearance	C
		Incorrect valve timing	B
	Cooling system	Overheating	A
9. Excessive engine oil consumption	Intake system	Loosened or cracked PCV hose	A
		Defective PCV valve	B
		Loosened oil filler cap	C
	Compression	Defective valve stem	A
		Worn or stuck piston rings, cylinder and piston	A
	Lubrication system	Loosened oil pump attaching bolts and defective gasket	B
		Defective oil filter gasket	B
		Defective crankshaft oil seal	B
		Defective rocker cover gasket	B
		Loosened oil drain plug or defective gasket	B
		Loosened oil pan fitting bolts or defective	B

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		oil pan	
10. Excessive fuel consumption	Engine control system <Ref. to <u>BASIC DIAGNOSTIC PROCEDURE</u> . >		A
	Intake system	Dirty air cleaner element	A
	Timing belt	Defective timing	B
	Compression	Incorrect valve clearance	B
		Loosened spark plug or defective gasket	C
		Loosened cylinder head bolt or defective gasket	C
		Improper valve sealing	B
		Defective valve stem	C
		Worn or broken valve spring	C
		Worn or stuck piston rings, cylinder and piston	B
		Incorrect valve timing	B
	Lubrication system	Incorrect oil pressure	C
	Cooling system	Over-cooling	C

ENGINE NOISE

INSPECTION

ENGINE NOISE POSSIBLE CAUSE CHART

Type of sound	Condition	Possible cause
Regular clicking sound	Sound increases as engine speed increases.	- Valve mechanism is defective. - Incorrect valve clearance - Worn valve rocker - Worn camshaft - Broken valve spring
Heavy and dull clank	Oil pressure is low.	- Worn crankshaft main bearing - Worn connecting rod bearing (large end)
	Oil pressure is normal.	- Damaged engine mounting - Loosened flywheel mounting bolt
High-pitched clank (Spark knock)	Sound is noticeable when accelerating with an overload	- Ignition timing advanced - Accumulation of carbon inside combustion chamber

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	condition.	• Wrong spark plug • Improper gasoline
Clank when engine speed is 1,000 to 2,000 rpm	Sound is reduced when fuel injector connector of noisy cylinder is disconnected. ⁽¹⁾	• Worn crankshaft main bearing • Worn connecting rod bearing (large end)
Knocking sound when engine is operating under idling speed and engine is warm	Sound is reduced when fuel injector connector of noisy cylinder is disconnected. ⁽¹⁾	• Worn cylinder liner and piston ring • Broken or stuck piston ring • Worn piston pin and hole at piston end of connecting rod
	Sound is not reduced if each fuel injector connector is disconnected in turn. ⁽¹⁾	• Worn cam sprocket • Worn camshaft journal bore in cylinder head
Squeaky sound	-	Insufficient generator lubrication
Rubbing sound	-	Poor contact of generator brush and rotor
Gear scream when starting engine	-	• Defective ignition starter switch • Worn gear and starter pinion
Sound like polishing glass with a dry cloth	-	• Loose V belt • Defective water pump shaft
Hissing sound	-	• Insufficient compression • Air leakage in air intake system, hose, connection or manifold
Timing belt noise	-	• Loose timing belt • Belt contacting with case/adjacent part
Valve noise	-	Incorrect valve clearance
(1) When disconnecting the fuel injector connector, the malfunction indicator light illuminates and DTC is stored in ECM memory. Therefore, after connecting the fuel injector connector, execute Clear Memory Mode <Ref. to OPERATION , Clear Memory Mode . > and Inspection Mode <Ref. to PROCEDURE , Inspection Mode . >.		