



Connecting Rod Cap

1. Remove the connecting rod screw from connecting rod cap.
2. Remove the connecting rod cap.

(When reassembling)

- Align the marks (B) with each other. (Place the marks toward the injection pump.)
- Apply engine oil to the connecting rod screws and lightly screw it in by hand, then tighten it to the specified torque.
If the connecting rod screw won't fit without oil smoothly, clean the threads.
- If the connecting rod screw is still hard to screw in, replace it.
- When using the existing crank pin metal again, put red marks on the crank pin metal and the connecting rod in order to keep their positioning.
- Fit the crank pin metal in place. Its vertically ground side toward the connecting rod, and the non-ground side toward the cap.

Tightening torque	Connecting rod screw
15.7 N·m (1.6 kgf·m) 11.8 N·m (1.2 kgf·m) 17.3 N·m (1.8 kgf·m)	

(1) Connecting Rod Screw

(2) Mark

27000-ER02-001

Piston

1. Turn the flywheel and bring the No. 1 piston to the top dead center.
2. Pull out the piston upward by lightly tapping it from the bottom of the combustion with the gap of a hammer.

(When reassembling)

- Before inserting the piston into the cylinder, apply enough engine oil to the cylinder.
- When inserting the piston into the cylinder, face the mark on the connecting rod to the injection pump.

CAUTION

- Do not change the combination of cylinder and piston. Make sure of the position of each piston by marking. For example, mark "1" on the No.1 piston.
- When inserting the piston into the cylinder, place the gap of the compression ring 1 on the opposite side of the combustion chamber and stagger the gaps of the compression ring 2 and oil ring making a right angle from the gap of the compression ring 1.
- Carefully insert the pistons using a piston ring compressor (C). Otherwise, their chrome-plated section may be scratched, creating trouble inside the bore.

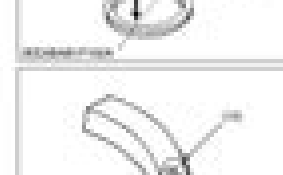
(1) Piston Ring Compressor

(2) Second Ring Groove

(3) Piston Ring Groove

(4) Piston Pin Metal

27000-ER02-002



Piston Ring and Connecting Rod

1. Remove the piston rings using a piston ring tool.
2. Put the fan shaped screw (B) on the piston as shown in figure.
3. Remove the piston pin (C), and separate the connecting rod (D) from the piston (B).

(When reassembling)

- Be sure to fit the crankpin bearing and the connecting rod are same L&R colors.
- When installing the ring, assemble the rings so that the manufacturer's mark (D) face the gap between the head of the piston.
- When installing the oil ring into the piston, place the expander part (H) on the opposite side of the oil ring gap (F).
- Apply engine oil to the piston pin.
- When installing the piston pin, remove the piston in 30 °C (170 °F) at for 10 to 15 minutes and insert the piston pin to the piston.
- Assemble the piston to the connecting rod with the aligning the direction of the fan shaped screw (B) of piston head and the mark (B) of connecting rod.
- The end faces of the oil ring are plated with hard chrome. In putting the piston ring the scraper, be careful not to get the oil ring scratched by the cylinder. Use the piston ring filler to tighten up the spring. If the ring's plating is scratched, it may get stuck on the cylinder wall, causing a serious trouble.

CAUTION

- Mark the same number on the connecting rod and the piston so as not to change the combination.
- The Piston Ring Assembly is NOT interchangeable between Engine Serial Number : 27000-ER02 and 27000-ER01.

Engine Serial Number : 27000-ER02

Part Name	Part Code
Piston Head	27000-ER02-001-001
Piston Ring Assembly	27000-ER02-001-001

Engine Serial Number : 27000-ER01

Part Name	Part Code
Piston Head	27000-ER01-001-001
Piston Ring Assembly	27000-ER01-001-001

- (1) Piston Pin
- (2) Piston
- (3) Piston Pin Groove Ring
- (4) Compression Ring 1
- (5) Compression Ring 2
- (6) Oil Ring
- (7) Connecting Rod
- (8) Fan Shaped Screw
- (9) Piston
- (10) Expander part

- (11) Oil Ring Groove
- (12) Manufacturer's Mark

- (A) Connecting Rod (L Color : Blue or Yellow without Color)
- (B) Crankpin Bearing (L Color : Blue or Yellow without Color)

27000-ER02-001

Kubota Diesel Generator Service Manual

Skip Thomsen,Cat Freshwater



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