



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 only 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	9.0 N·m (0.7 ft·lb) 5.0 N·m (0.4 ft·lb) 12.0 N·m (0.9 ft·lb)
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(A) Connecting Rod Screw

(B) Mark

20000-0000-0000

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.

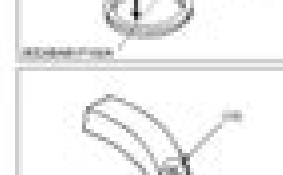
(C) Piston Ring Compressor

(B) Second Ring Groove

(A) Top Ring Groove

(C) Piston Pin Metal

20000-0000-0000



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 two 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 (86 °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 coated 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 planting 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 : -Y15076 and Y15077.

Engine Serial Number : Y15076

Part Name	Part Code
Piston Head	20000-01 20000-02
Piston Ring Assembly	20000-0000

Engine Serial Number : Y15077

Part Name	Part Code
Piston Head	20000-01 20000-02
Piston Ring Assembly	20000-0000

Engine Serial Number : Y15077

(A) Piston Pin	(D) Second Ring Groove
(B) Piston	(E) Compression Ring 1
(C) Compression Ring 2	(F) Compression Ring 2
(G) Oil Ring	(H) Fan Shaped Screw
(I) Piston Ring Compressor	(J) Piston Pin Metal
(K) Piston	(L) Piston Pin Metal

20000-0000-0000

Kubota Diesel Generator Service Manual

Michal Rosen-Zvi



Kubota Diesel Generator Service Manual:

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Table of Contents Kubota Diesel Generator Service Manual

1. Understanding the eBook Kubota Diesel Generator Service Manual
 - The Rise of Digital Reading Kubota Diesel Generator Service Manual
 - Advantages of eBooks Over Traditional Books
2. Identifying Kubota Diesel Generator Service Manual
 - Exploring Different Genres
 - Considering Fiction vs. Non-Fiction
 - Determining Your Reading Goals
3. Choosing the Right eBook Platform
 - Popular eBook Platforms
 - Features to Look for in an Kubota Diesel Generator Service Manual
 - User-Friendly Interface
4. Exploring eBook Recommendations from Kubota Diesel Generator Service Manual
 - Personalized Recommendations
 - Kubota Diesel Generator Service Manual User Reviews and Ratings

- Kubota Diesel Generator Service Manual and Bestseller Lists
- 5. Accessing Kubota Diesel Generator Service Manual Free and Paid eBooks
 - Kubota Diesel Generator Service Manual Public Domain eBooks
 - Kubota Diesel Generator Service Manual eBook Subscription Services
 - Kubota Diesel Generator Service Manual Budget-Friendly Options
- 6. Navigating Kubota Diesel Generator Service Manual eBook Formats
 - ePub, PDF, MOBI, and More
 - Kubota Diesel Generator Service Manual Compatibility with Devices
 - Kubota Diesel Generator Service Manual Enhanced eBook Features
- 7. Enhancing Your Reading Experience
 - Adjustable Fonts and Text Sizes of Kubota Diesel Generator Service Manual
 - Highlighting and Note-Taking Kubota Diesel Generator Service Manual
 - Interactive Elements Kubota Diesel Generator Service Manual
- 8. Staying Engaged with Kubota Diesel Generator Service Manual
 - Joining Online Reading Communities
 - Participating in Virtual Book Clubs
 - Following Authors and Publishers Kubota Diesel Generator Service Manual
- 9. Balancing eBooks and Physical Books Kubota Diesel Generator Service Manual
 - Benefits of a Digital Library
 - Creating a Diverse Reading Collection Kubota Diesel Generator Service Manual
- 10. Overcoming Reading Challenges
 - Dealing with Digital Eye Strain
 - Minimizing Distractions
 - Managing Screen Time
- 11. Cultivating a Reading Routine Kubota Diesel Generator Service Manual
 - Setting Reading Goals Kubota Diesel Generator Service Manual
 - Carving Out Dedicated Reading Time
- 12. Sourcing Reliable Information of Kubota Diesel Generator Service Manual
 - Fact-Checking eBook Content of Kubota Diesel Generator Service Manual
 - Distinguishing Credible Sources

13. Promoting Lifelong Learning
 - Utilizing eBooks for Skill Development
 - Exploring Educational eBooks
14. Embracing eBook Trends
 - Integration of Multimedia Elements
 - Interactive and Gamified eBooks

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