



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	9.0 N·m (0.9 kgf·m) 5.0 N·m (0.5 kgf·m) 12.0 N·m (1.2 kgf·m)
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(A) Connecting Rod Screw

(B) 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.

■ Important!

- 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.

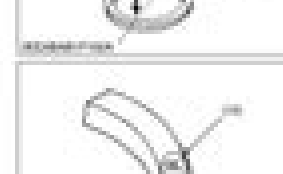
(C) Piston Ring Compressor

(B) Second Ring Groove

(A) Top Ring Groove

(C) Piston Pin Metal

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 pin below 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 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.

■ Important!

- 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

(A) Piston Pin	(D) Piston Head
(B) Piston	(E) Manufacturer's Mark
(C) Piston Pin Groove	(F) Oil Ring Gap
(D) Compression Ring 1	(G) Compression Ring 2
(E) Compression Ring 2	(H) Oil Ring Expander
(F) Oil Ring	(I) Piston Ring Filler
(G) Compression Ring 1	(J) Piston Ring Filler
(H) Piston Ring Filler	(K) Piston Ring Filler
(I) Piston Ring Filler	(L) Piston Ring Filler

27000-ER02-001

Kubota Diesel Generator Service Manual

Surplus Record



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The Modern Homestead Manual Skip Thomsen, Cat Freshwater, 1998-10 **Cruising World** ,1992-01 *Home Power* ,2003 **Light Utility Tractor Service Manual** ,1975 **Public Works Manual** ,2002 **Diesel & Gas Turbine Worldwide Catalog** ,1983 **British Power Farmer and Agricultural Engineer** ,1991 *Questions and answers for job interview Offshore Drillings Rigs* Petrogav International Oil & Gas Training Center, The job interview is probably the most important step you will take in your job search journey Because it s always important to be prepared to respond effectively to the questions that employers typically ask at a job interview Petrogav International has prepared this eBooks that will help you to get a job in oil and gas industry Since these questions are so common hiring managers will expect you to be able to answer them smoothly and without hesitation This eBook contains 270 questions and answers for job interview and as a BONUS 287 links to video movies This course covers aspects like HSE Process Mechanical Electrical and Instrumentation Control that will enable you to apply for any position in the Oil and Gas Industry **Regional Industrial Buying Guide** ,2000 **April 2022 - Surplus Record Machinery & Equipment Directory** Surplus Record,2022-04-01 SURPLUS RECORD is the leading independent business directory of new and used capital equipment machine tools machinery and industrial equipment listing over 95 000 industrial assets including metalworking and fabricating machine tools chemical and process equipment cranes air compressors pumps motors circuit breakers generators transformers turbines and more Over 1 100 businesses list with the SURPLUS RECORD April 2022 issue Vol 99 No 4

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