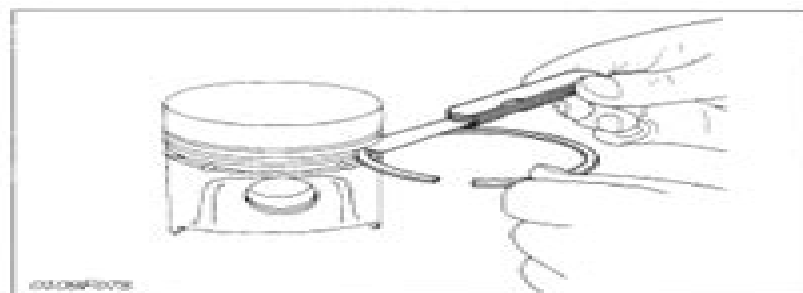


Piston Ring Gap

1. Insert the piston ring into the cylinder and push down to the bottom, where the wear is least, using a piston head.
2. Measure the ring gap with a feeler gauge.
3. If the ring gap exceeds the allowable limit, replace the ring.

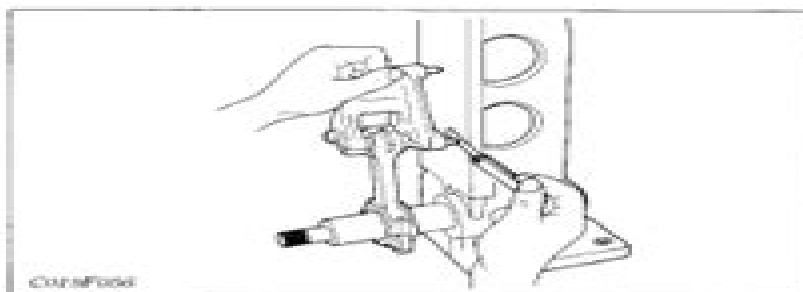
Piston ring gap	Factory specification	Second ring	0.25 to 0.40 mm 0.0098 to 0.0157 in.
		Oil ring	0.20 to 0.40 mm 0.0079 to 0.0157 in.
	Allowable limit		1.2 mm 0.047 in.



Piston Ring Clearance

1. Clean the rings and the ring grooves, and install each ring in its groove.
2. Measure the clearance between the ring and the groove with a feeler gauge.
3. If the clearance exceeds the allowable limit, replace the piston ring.
4. If the clearance still exceeds the allowable limit after replacing the ring, replace the piston.

Piston ring clearance	Factory specification	Second ring	0.065 to 0.112 mm 0.0035 to 0.0044 in.
		Oil ring	0.02 to 0.06 mm 0.0008 to 0.0024 in.
	Allowable limit		0.15 mm 0.0059 in.



Connecting Rod Alignment

1. Remove the connecting rod bearing and install the bearing cap.
2. Install the piston pin in the connecting rod.
3. Install the connecting rod on the connecting rod alignment tool (Code No : 07909-31661).
4. Put a gauge over the piston pin and move it against the faceplate.
5. If the gauge does not fit squarely against the faceplate, measure the space between the pin of the gauge and the faceplate.
6. If the measurement exceeds the allowable limit, replace the connecting rod.

Space between pin and faceplate	Allowable limit	0.05 mm 0.0020 in. (gauge pin span at 100 mm, 3.94 in.)
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Kubota Z400 Workshop Manual

W. H. Davies



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 - The Rise of Digital Reading Kubota Z400 Workshop Manual
 - Advantages of eBooks Over Traditional Books
2. Identifying Kubota Z400 Workshop 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 Z400 Workshop Manual
 - User-Friendly Interface
4. Exploring eBook Recommendations from Kubota Z400 Workshop Manual
 - Personalized Recommendations
 - Kubota Z400 Workshop Manual User Reviews and Ratings
 - Kubota Z400 Workshop Manual and Bestseller Lists
5. Accessing Kubota Z400 Workshop Manual Free and Paid eBooks
 - Kubota Z400 Workshop Manual Public Domain eBooks
 - Kubota Z400 Workshop Manual eBook Subscription Services
 - Kubota Z400 Workshop Manual Budget-Friendly Options
6. Navigating Kubota Z400 Workshop Manual eBook Formats

- ePub, PDF, MOBI, and More
- Kubota Z400 Workshop Manual Compatibility with Devices
- Kubota Z400 Workshop Manual Enhanced eBook Features
- 7. Enhancing Your Reading Experience
 - Adjustable Fonts and Text Sizes of Kubota Z400 Workshop Manual
 - Highlighting and Note-Taking Kubota Z400 Workshop Manual
 - Interactive Elements Kubota Z400 Workshop Manual
- 8. Staying Engaged with Kubota Z400 Workshop Manual
 - Joining Online Reading Communities
 - Participating in Virtual Book Clubs
 - Following Authors and Publishers Kubota Z400 Workshop Manual
- 9. Balancing eBooks and Physical Books Kubota Z400 Workshop Manual
 - Benefits of a Digital Library
 - Creating a Diverse Reading Collection Kubota Z400 Workshop Manual
- 10. Overcoming Reading Challenges
 - Dealing with Digital Eye Strain
 - Minimizing Distractions
 - Managing Screen Time
- 11. Cultivating a Reading Routine Kubota Z400 Workshop Manual
 - Setting Reading Goals Kubota Z400 Workshop Manual
 - Carving Out Dedicated Reading Time
- 12. Sourcing Reliable Information of Kubota Z400 Workshop Manual
 - Fact-Checking eBook Content of Kubota Z400 Workshop 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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