

### Fuel Tightness of Pump Element

1. Remove the engine stop solenoid.
2. Remove the injection pipes and glow plugs.
3. Install the injection pump pressure tester to the injection pump.
4. Install the injection nozzle (2) filled with the proper injection pressure to the injection pump pressure tester (1). (Refer to the figure.)
5. Set the speed control lever to the maximum speed position.
6. Start the starter to increase the pressure.
7. If the pressure can not reach the allowable limit, replace the pump with new one or repair with a Kubota-authorized pump service shop.

Fuel tightness of pump element	Allowable limit	10.73 MPa (140 kgf/cm <sup>2</sup> , 1400 psi)
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### NOTE

- Never try to disassemble the injection pump assembly. For repairs, you are strongly requested to contact a Kubota-authorized pump service shop.

(1) Injection Pump Pressure Tester (2) Injection Nozzle

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### Fuel Tightness of Delivery Valve

1. Remove the engine stop solenoid.
2. Remove the injection pipes and glow plugs.
3. Set a pressure tester to the fuel injection pump.
4. Install the injection nozzle (2) filled with the proper injection pressure to the injection pump pressure tester (1).
5. Start the starter to increase the pressure.
6. Stop the starter when the fuel jets from the injection nozzle. After that, turn the flywheel by the handle and raise the pressure to approx. 12.73 MPa (140 kgf/cm<sup>2</sup>, 1400 psi).
7. Now turn the flywheel back about half a turn (to keep the plunger back). Maintain the flywheel at this position and check the time taken for the pressure to drop from 12.73 to 12.73 MPa (from 140 to 140 kgf/cm<sup>2</sup>, from 1400 to 1400 psi).
8. Measure the time needed to depressure the pressure from 12.73 to 12.73 MPa (140 to 140 kgf/cm<sup>2</sup>, 1400 to 1400 psi).
9. If the measurement is less than allowable limit, replace the pump with new one or repair with a Kubota-authorized pump service shop.

Fuel tightness of delivery valve	Factory specification	15 seconds 12.73 to 12.73 MPa 140 to 140 kgf/cm <sup>2</sup> 1400 to 1400 psi
	Allowable limit	5 seconds 12.73 to 12.73 MPa 140 to 140 kgf/cm <sup>2</sup> 1400 to 1400 psi

### NOTE

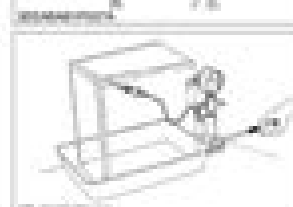
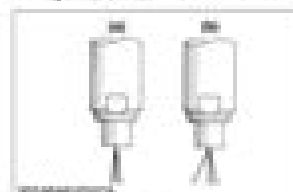
- Never try to disassemble the injection pump assembly. For repairs, you are strongly requested to contact a Kubota-authorized pump service shop.

(1) Injection Pump Pressure Tester (2) Injection Nozzle

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### CAUTION

1. Check the nozzle injection pressure and condition after confirming that there is nobody standing in the direction the fuel goes.
2. If the fuel from the nozzle directly contacts the human body, cells may be destroyed and blood poisoning may be caused.



### Nozzle Spraying Condition

1. Set the injection nozzle to a nozzle tester, and check the nozzle spraying condition.

2. If the spraying condition is defective, replace the nozzle piece.

(a) Good

(b) Bad

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### Fuel Injection Pressure

1. Set the injection nozzle to a nozzle tester.
2. Slowly move the scalar handle to measure the pressure at which fuel begins jetting out from the nozzle.

3. If the measurement is not within the factory specifications, replace the adjusting washer (1) in the nozzle holder to adjust it. (Reference)

- Pressure variation with 0.025 mm (0.001 in.) difference of adjusting washer thickness.  
Approx. 100 MPa (9.0 kgf/cm<sup>2</sup>, 90 psi)

Fuel injection pressure	Factory specification	10.73 to 12.73 MPa 140 to 140 kgf/cm <sup>2</sup> 1400 to 1400 psi
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(1) Adjusting Washer

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### Valve Seat Tightness

1. Set the injection nozzle to a nozzle tester.
2. Raise the fuel pressure, and keep at 12.73 MPa (140 kgf/cm<sup>2</sup>, 1400 psi) for 10 seconds.
3. If any fuel leak is found, replace the nozzle piece.

Valve seat tightness	Factory specification	No fuel leak at 12.73 MPa 140 kgf/cm <sup>2</sup> 1400 psi
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# Kubota 03 E2b Series Diesel Engine Workshop Service Manual

**Padhraic Smyth**



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## **Table of Contents Kubota 03 E2b Series Diesel Engine Workshop Service Manual**

1. Understanding the eBook Kubota 03 E2b Series Diesel Engine Workshop Service Manual
  - The Rise of Digital Reading Kubota 03 E2b Series Diesel Engine Workshop Service Manual
  - Advantages of eBooks Over Traditional Books
2. Identifying Kubota 03 E2b Series Diesel Engine Workshop 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 03 E2b Series Diesel Engine Workshop Service Manual
  - User-Friendly Interface
4. Exploring eBook Recommendations from Kubota 03 E2b Series Diesel Engine Workshop Service Manual
  - Personalized Recommendations
  - Kubota 03 E2b Series Diesel Engine Workshop Service Manual User Reviews and Ratings
  - Kubota 03 E2b Series Diesel Engine Workshop Service Manual and Bestseller Lists
5. Accessing Kubota 03 E2b Series Diesel Engine Workshop Service Manual Free and Paid eBooks
  - Kubota 03 E2b Series Diesel Engine Workshop Service Manual Public Domain eBooks
  - Kubota 03 E2b Series Diesel Engine Workshop Service Manual eBook Subscription Services
  - Kubota 03 E2b Series Diesel Engine Workshop Service Manual Budget-Friendly Options

6. Navigating Kubota 03 E2b Series Diesel Engine Workshop Service Manual eBook Formats
  - ePub, PDF, MOBI, and More
  - Kubota 03 E2b Series Diesel Engine Workshop Service Manual Compatibility with Devices
  - Kubota 03 E2b Series Diesel Engine Workshop Service Manual Enhanced eBook Features
7. Enhancing Your Reading Experience
  - Adjustable Fonts and Text Sizes of Kubota 03 E2b Series Diesel Engine Workshop Service Manual
  - Highlighting and Note-Taking Kubota 03 E2b Series Diesel Engine Workshop Service Manual
  - Interactive Elements Kubota 03 E2b Series Diesel Engine Workshop Service Manual
8. Staying Engaged with Kubota 03 E2b Series Diesel Engine Workshop Service Manual
  - Joining Online Reading Communities
  - Participating in Virtual Book Clubs
  - Following Authors and Publishers Kubota 03 E2b Series Diesel Engine Workshop Service Manual
9. Balancing eBooks and Physical Books Kubota 03 E2b Series Diesel Engine Workshop Service Manual
  - Benefits of a Digital Library
  - Creating a Diverse Reading Collection Kubota 03 E2b Series Diesel Engine Workshop Service Manual
10. Overcoming Reading Challenges
  - Dealing with Digital Eye Strain
  - Minimizing Distractions
  - Managing Screen Time
11. Cultivating a Reading Routine Kubota 03 E2b Series Diesel Engine Workshop Service Manual
  - Setting Reading Goals Kubota 03 E2b Series Diesel Engine Workshop Service Manual
  - Carving Out Dedicated Reading Time
12. Sourcing Reliable Information of Kubota 03 E2b Series Diesel Engine Workshop Service Manual
  - Fact-Checking eBook Content of Kubota 03 E2b Series Diesel Engine Workshop 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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