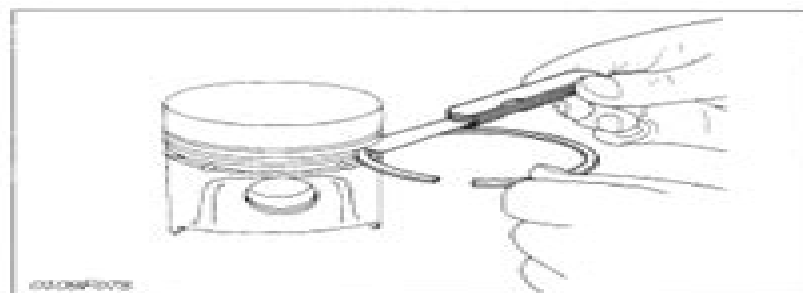


### Piston Ring Gap

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.

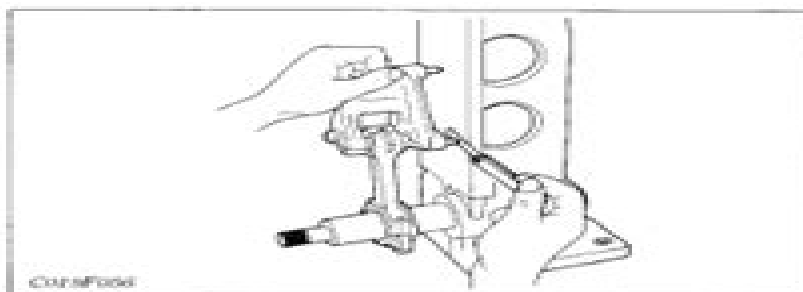
|                 |                       |             |                                         |
|-----------------|-----------------------|-------------|-----------------------------------------|
| Piston ring gap | Factory specification | Second ring | 0.25 to 0.40 mm<br>0.0098 to 0.0157 in. |
|                 |                       | Oil ring    | 0.20 to 0.40 mm<br>0.0079 to 0.0157 in. |
|                 | Allowable limit       |             | 1.2 mm<br>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<br>0.0035 to 0.0044 in. |
|                       |                       | Oil ring    | 0.02 to 0.06 mm<br>0.0008 to 0.0024 in.   |
|                       | Allowable limit       |             | 0.15 mm<br>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<br>0.0020 in.<br>(gauge pin span at 100 mm,<br>3.94 in.) |
|---------------------------------|-----------------|------------------------------------------------------------------|

# Kubota Z400 Workshop Manual

**Patrick Vollmar**



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