





Piston Ring Gap

- 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.
- If the ring gap exceeds the allowable limit, replace the ring.

Piston ring gap	Factory specifica- tion	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

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

Platon ring diserance	Factory specifica- tion	Second ring	0.085 to 0.112 mm 0.00335 to 0.00441 in.
		Oil ring	0.02 to 0.06 mm 0.0008 to 0.0024 in.
	Allowable Simit		0.15 mm 0.0059 in.

Connecting Rod Alignment

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

Space between pin and face plate	Allowable limit	0.05 mm 0.0020 in, Igauge pin span at 100 mm, 3.94 in 1
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Kubota Z400 Workshop Manual

Mervyn Bleach, Jeremy Churchill



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