1. General Description

A: SPECIFICATION

Engine	Model				2.5 L	
	Cylinder arrangement				Horizontally opposed, liquid cooled, 4-cylinder, 4-stroke gasoline engine	
	Valve system mechanism				Belt driven, double overhead camshaft, 4-valve/cylinder	
	Bore × Stroke mm (in)				99.5 × 79.0 (3.92 × 3.11)	
	Piston displacement cm^3 (cu in)				2,457 (149.94)	
	Compression ratio				8.4	
	Compression pressure (at 200 — 300 rpm) kPa (kgf/cm^2, psi)				981 — 1,177 (10 — 12, 142 — 171)	
	Number of piston rings				Pressure ring: 2, Oil ring: 1	
	Intake valve timing	Open	Max.retard		5° ATDC	
			Min. advance		15° BTDC	
		Close	Max.retard		65° ABDC	
			Min. advance		45° ABDC	
	Exhaust valve timing	Open			55° BBDC	
		Close			5° ATDC	
	Valve clearance	Intake mm (in)			0.20±0.02 (0.0079±0.0008)	
		Exhaust mm (in)			0.35±0.02 (0.0138±0.0008)	
	Idle speed [At neural position on MT, or “P” or “N” range on AT] rpm			No Load	MT: 700±100 AT: 700±100	
				A/C ON	A/C refrigerant pressure is low	MT: 725±100 AT: 750±100
					A/C refrigerant pressure is high	MT: 800±100 AT: 825±100
	Ignition order				$1 \rightarrow 3 \rightarrow 2 \rightarrow 4$	
	Ignition timing BTDC/rpm			MT model	17°±10°/700	
				AT model	17°±10°/700	

NOTE:
OS: Oversize US: undersize

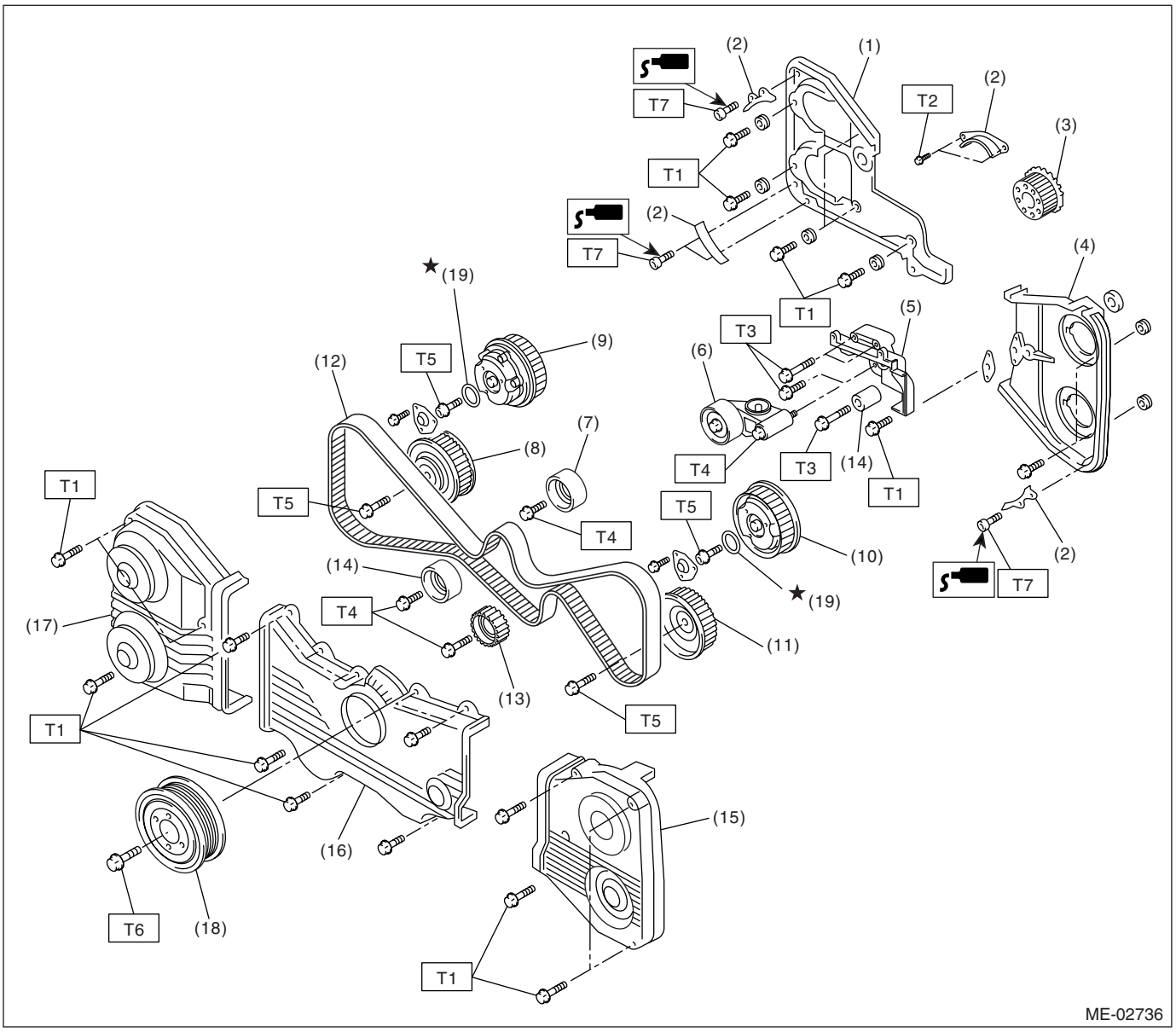
Belt tension adjuster	Protrusion of adjuster rod			5.2 — 6.2 mm (0.204 — 0.244 in)
Belt tensioner	Spacer O.D.			17.955 — 17.975 mm (0.7069 — 0.7077 in)
	Tensioner bushing I.D.			18.0 — 18.08 mm (0.7087 — 0.7118 in)
	Clearance between spacer and bushing		Standard	0.025 — 0.125 mm (0.0010 — 0.0049 in)
			Limit	0.175 mm (0.069 in)
	Side clearance of spacer		Standard	0.2 — 0.55 mm (0.0079 — 0.0217 in)
			Limit	0.81 mm (0.0319 in)
Camshaft	Bend limit			0.020 mm (0.00079 in)
	Thrust clearance		Standard	0.068 — 0.116 mm (0.0027 — 0.0046 in)
			Limit	0.14 mm (0.0055 in)
	Cam lobe height	Intake	Standard	46.55 — 46.65 mm (1.833 — 1.837 in)
			Limit	46.45 mm (1.829 in)
		Exhaust	Standard	46.75 — 46.85 mm (1.841 — 1.844 in)
			Limit	46.65 mm (1.837 in)
	Camshaft journal O.D.	Standard	Front	37.946 — 37.963 mm (1.4939 — 1.4946 in)
			Center rear	29.946 — 29.963 mm (1.1790 — 1.1796 in)
	Oil clearance		Standard	0.037 — 0.072 mm (0.0015 — 0.0028 in)
			Limit	0.10 mm (0.0039 in)
Cylinder head	Surface warpage limit (Mating surface with cylinder block)			0.035 mm (0.0014 in)
	Grinding limit			0.3 mm (0.012 in)
	Standard height			127.5 mm (5.02 in)
Valve seat	Refacing angle			90°
	Contacting width	Intake	Standard	0.6 — 1.4 mm (0.024 — 0.055 in)
			Limit	1.7 mm (0.067 in)
		Exhaust	Standard	1.2 — 1.8 mm (0.047 — 0.071 in)
			Limit	2.2 mm (0.087 in)
Valve guide	Inside diameter			6,000 — 6.012 mm (0.2362 — 0.2367 in)
	Protrusion above head			15.8 — 16.2 mm (0.622 — 0.638 in)
Valve	Head edge thickness	Intake	Standard	1.0 — 1.4 mm (0.039 — 0.055 in)
			Limit	0.8 mm (0.031 in)
		Exhaust	Standard	1.3 — 1.7 mm (0.051 — 0.067 in)
			Limit	0.8 mm (0.031 in)
	Stem outer diameter		Intake	5.955 — 5.970 mm (0.2344 — 0.2350 in)
			Exhaust	5.945 — 5.960 mm (0.2341 — 0.2346 in)
	Valve stem gap	Standard	Intake	0.030 — 0.057 mm (0.0012 — 0.0022 in)
			Exhaust	0.040 — 0.067 mm (0.0016 — 0.0026 in)
		Limit	—	0.15 mm (0.0059 in)
	Overall length		Intake	104.4 mm (4.110 in)
			Exhaust	104.65 mm (4.120 in)
Valve spring	Free length			47.32 mm (1.863 in)
	Squareness			2.5°, 2.1 mm (0.083 in) or less
	Tension/spring height		Set	205 — 235 N (20.9 — 24.0 kgf, 46.1 — 52.8 lb)/ 36.0 mm (1.417 in)
			Lift	426 — 490 N (43.4 — 50.0 kgf, 95.8 — 110 lb)/ 26.50 mm (1.043 in)

Cylinder block	Surface warpage limit (Mating surface with cylinder head)			0.025 mm (0.0098 in)
	Grinding limit			0.1 mm (0.004 in)
	Standard height			201.0 mm (7.91 in)
	Cylinder inner diameter	Standard	A	99.505 — 99.515 mm (3.9175 — 3.9179 in)
			B	99.495 — 99.505 mm (3.9171 — 3.9175 in)
	Taper		Standard	0.015 mm (0.0006 in)
			Limit	0.050 mm (0.0020 in)
	Out-of-roundness		Standard	0.010 mm (0.0004 in)
			Limit	0.050 mm (0.0020 in)
	Piston clearance		Standard	–0.010 — 0.010 mm (–0.0004 — 0.0004 in)
			Limit	0.030 mm (0.0012 in)
	Boring limit			0.5 mm (0.020 in)
Piston	Outer diameter	Standard	A	99.505 — 99.515 mm (3.9175 — 3.9179 in)
			B	99.495 — 99.505 mm (3.9171 — 3.9175 in)
		0.25 mm (0.0098 in) OS		99.745 — 99.765 mm (3.9270 — 3.9278 in)
		0.50 mm (0.0197 in) OS		99.995 — 100.015 mm (3.9368 — 3.9376 in)
Piston pin	Standard clearance between piston and piston pin		Standard	0.004 — 0.008 mm (0.0002 — 0.0003 in)
			Limit	0.020 mm (0.0008 in)
	Degree of fit			Piston pin must be fitted into position with thumb at 20°C (68°F).
Piston ring	Ring closed gap	Top ring	Standard	0.20 — 0.25 mm (0.0079 — 0.0098 in)
			Limit	1.0 mm (0.039 in)
		Second ring	Standard	0.37 — 0.52 mm (0.015 — 0.020 in)
			Limit	1.0 mm (0.039 in)
		Oil ring	Standard	0.20 — 0.50 mm (0.0079 — 0.0197 in)
			Limit	1.5 mm (0.059 in)
	Ring groove gap	Top ring	Standard	0.040 — 0.080 mm (0.0016 — 0.0031 in)
			Limit	0.15 mm (0.0059 in)
		Second ring	Standard	0.030 — 0.070 mm (0.0012 — 0.0028 in)
			Limit	0.15 mm (0.0059 in)
Connecting rod	Bend or twist per 100 mm (3.94 in) in length		Limit	0.10 mm (0.0039 in)
	Side clearance of large end		Standard	0.070 — 0.330 mm (0.0028 — 0.0130 in)
			Limit	0.4 mm (0.016 in)
Bearing of large end	Oil clearance		Standard	0.017 — 0.045 mm (0.0007 — 0.0018 in)
			Limit	0.05 mm (0.0020 in)
	Thickness at center portion		Standard	1.490 — 1.502 mm (0.0587 — 0.0591 in)
			0.03 mm (0.0012 in) US	1.504 — 1.512 mm (0.0592 — 0.0595 in)
			0.05 mm (0.0020 in) US	1.514 — 1.522 mm (0.0596 — 0.0599 in)
			0.25 mm (0.0098 in) US	1.614 — 1.622 mm (0.0635 — 0.0639 in)
Bushing of small end	Clearance between piston pin and bushing		Standard	0 — 0.022 mm (0 — 0.0009 in)
			Limit	0.030 mm (0.0012 in)

Crankshaft	Bending limit			0.035 mm (0.0014 in)
	Crank pin	Out-of-roundness		0.003 mm (0.0001 in)
		Cylindricality		0.004 mm (0.0002 in)
		Grinding limit (dia.)		To 51.750 mm (2.0374 in)
	Crank journal	Out-of-roundness		0.005 mm (0.0002 in)
		Cylindricality		0.006 mm (0.0002 in)
		Grinding limit (dia.)		To 59.750 mm (2.3524 in)
	Crank pin outer diameter		Standard	51.984 — 52.000 mm (2.0466 — 2.0472 in)
			0.03 mm (0.0012 in) US	51.954 — 51.970 mm (2.0454 — 2.0461 in)
			0.05 mm (0.0020 in) US	51.934 — 51.950 mm (2.0447 — 2.0453 in)
			0.25 mm (0.0098 in) US	51.734 — 51.750 mm (2.0368 — 2.0374 in)
	Crank journal outer diameter		Standard	59.992 — 60.008 mm (2.3619 — 2.3625 in)
			0.03 mm (0.0012 in) US	59.962 — 59.978 mm (2.3607 — 2.3613 in)
			0.05 mm (0.0020 in) US	59.942 — 59.958 mm (2.3599 — 2.3605 in)
			0.25 mm (0.0098 in) US	59.742 — 59.758 mm (2.3520 — 2.3527 in)
	Thrust clearance		Standard	0.030 — 0.115 mm (0.0012 — 0.0045 in)
			Limit	0.25 mm (0.0098 in)
	Oil clearance		Standard	0.010 — 0.030 mm (0.0004 — 0.0012 in)
			Limit	0.040 mm (0.0016 in)
Main bearing	Thickness of main bearing	#1, #3	Standard	1.998 — 2.011 mm (0.0787 — 0.0792 in)
			0.03 mm (0.0012 in) US	2.017 — 2.020 mm (0.0794 — 0.0795 in)
			0.05 mm (0.0020 in) US	2.027 — 2.030 mm (0.0798 — 0.0799 in)
			0.25 mm (0.0098 in) US	2.127 — 2.130 mm (0.0837 — 0.0839 in)
		#2, #4, #5	Standard	2,000 — 2.013 mm (0.0787 — 0.0793 in)
			0.03 mm (0.0012 in) US	2.019 — 2.022 mm (0.0795 — 0.0796 in)
			0.05 mm (0.0020 in) US	2.029 — 2.032 mm (0.0799 — 0.0800 in)
			0.25 mm (0.0098 in) US	2.129 — 2.132 mm (0.0838 — 0.0839 in)

B: COMPONENT

1. TIMING BELT

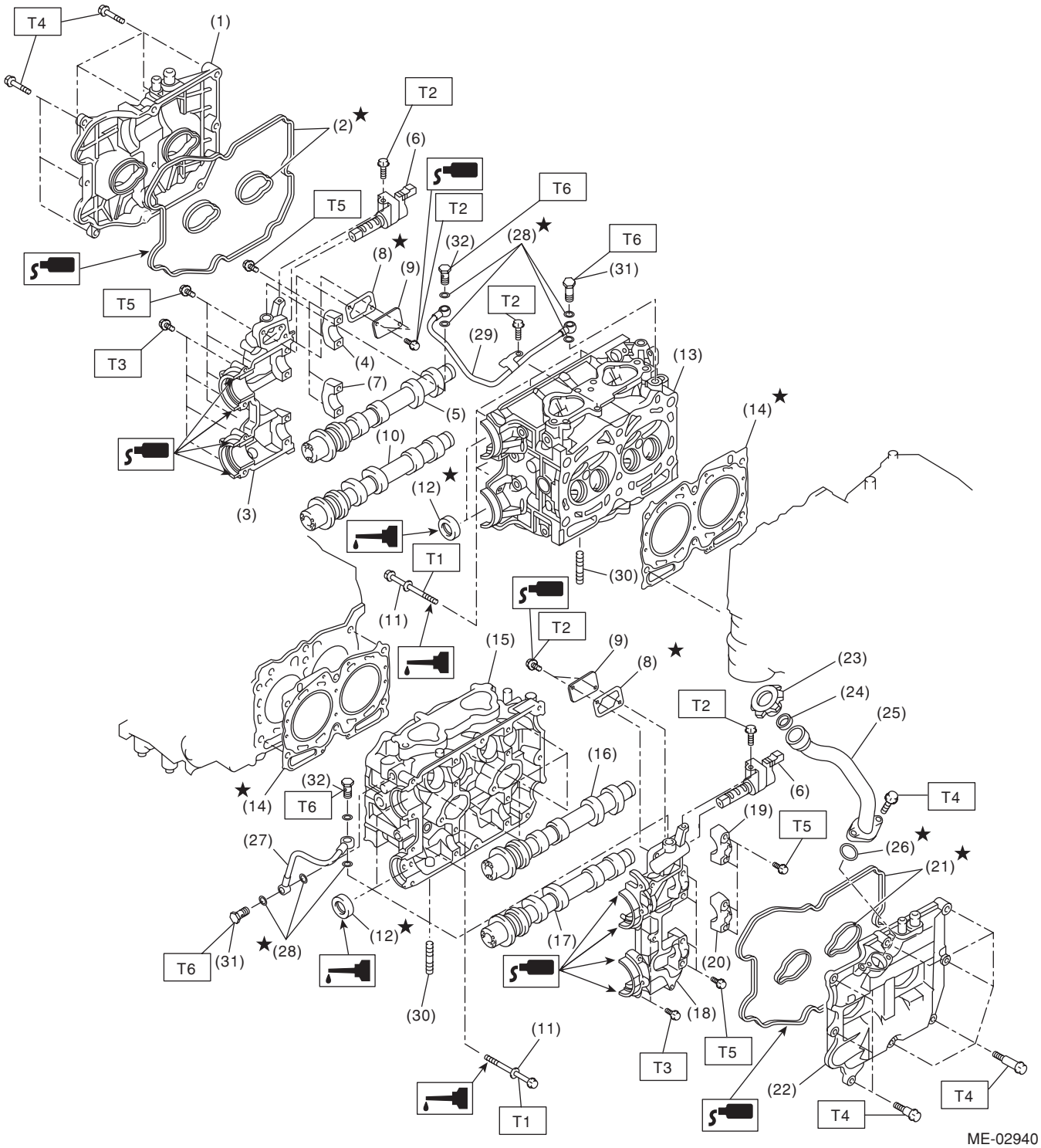


(1) Timing belt cover No. 2 (RH)
(2) Timing belt guide (MT model)
(3) Crank sprocket
(4) Timing belt cover No. 2 (LH)
(5) Tensioner bracket
(6) Automatic belt tension adjuster ASSY
(7) Belt idler
(8) Exhaust cam sprocket (RH)
(9) Intake cam sprocket (RH)
(10) Intake cam sprocket (LH)
(11) Exhaust cam sprocket (LH)
(12) Timing belt
(13) Belt idler No. 2
(14) Belt idler
(15) Timing belt cover (LH)
(16) Front belt cover
(17) Timing belt cover (RH)
(18) Crank pulley
(19) O-ring

Tightening torque: N·m (kgf-m, ft-lb)

T1: 5 (0.5, 3.6)
T2: 9.75 (1.0, 7.2)
T3: 24.5 (2.5, 18.1)
T4: 39 (4.0, 28.9)
T5: <Ref. to ME(H4DOTC)-50, INSTALLATION, Cam Sprocket.>
T6: <Ref. to ME(H4DOTC)-40, INSTALLATION, Crank Pulley.>
T7: 6.4 (0.65, 4.7)

2. CYLINDER HEAD AND CAMSHAFT

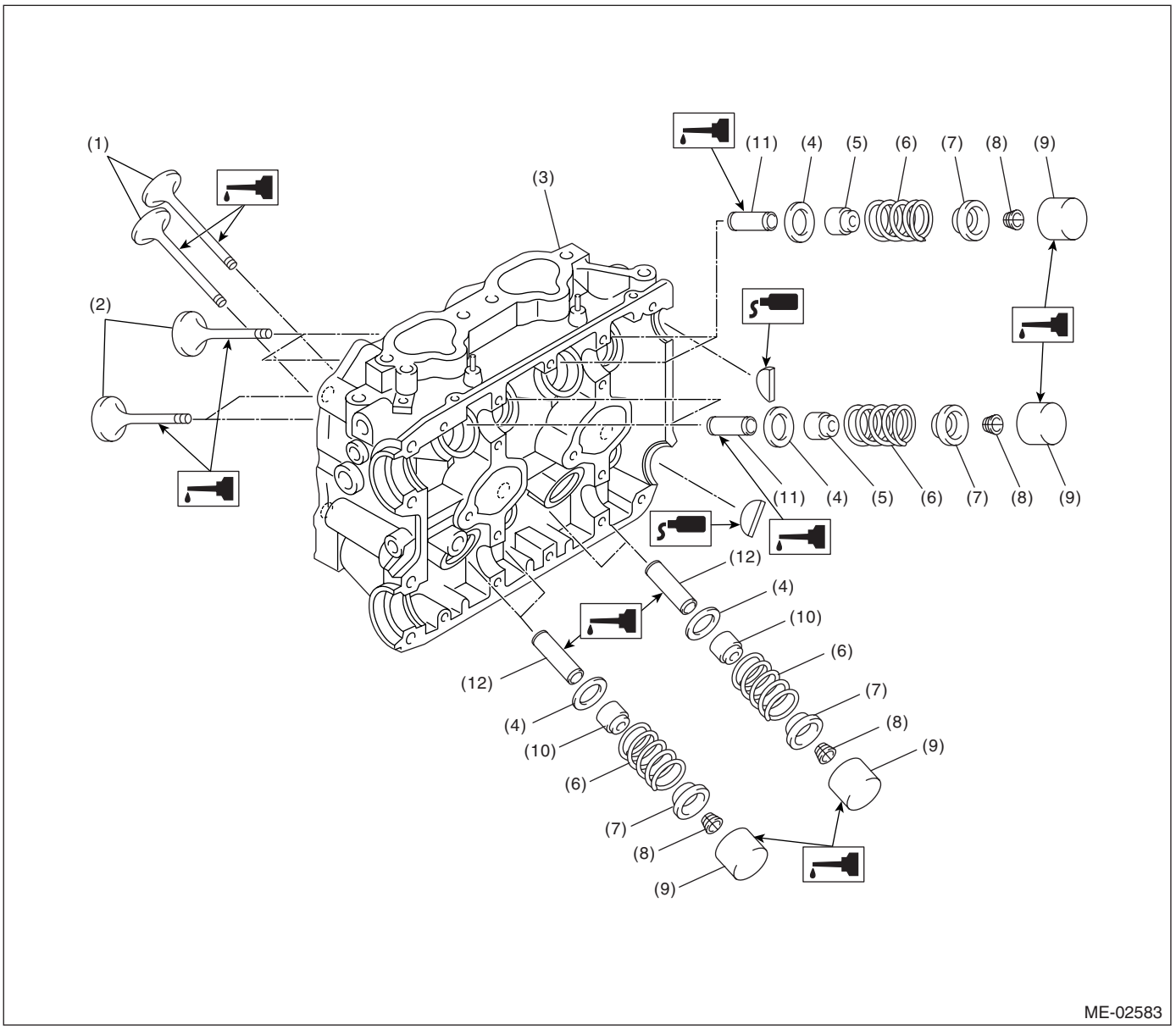


(1) Rocker cover (RH)
(2) Rocker cover gasket (RH)
(3) Camshaft cap (Front RH)
(4) Intake camshaft cap (Rear RH)
(5) Intake camshaft (RH)
(6) Oil flow control solenoid valve
(7) Exhaust camshaft cap (Rear RH)
(8) Gasket
(9) Oil return cover
(10) Exhaust camshaft (RH)
(11) Cylinder head bolt
(12) Oil seal
(13) Cylinder head (RH)
(14) Cylinder head gasket
(15) Cylinder head (LH)
(16) Intake camshaft (LH)
(17) Exhaust camshaft (LH)
(18) Camshaft cap (Front LH)
(19) Intake camshaft cap (Rear LH)
(20) Exhaust camshaft cap (Rear LH)
(21) Rocker cover gasket (LH)
(22) Rocker cover (LH)
(23) Oil filler cap
(24) Gasket
(25) Oil filler duct
(26) O-ring
(27) Oil pipe (LH)
(28) Gasket
(29) Oil pipe (RH)
(30) Stud bolt
(31) Union screw with filter (With protrusion)
(32) Union screw without filter (Without protrusion)

Tightening torque: N·m (kgf-m, ft-lb)

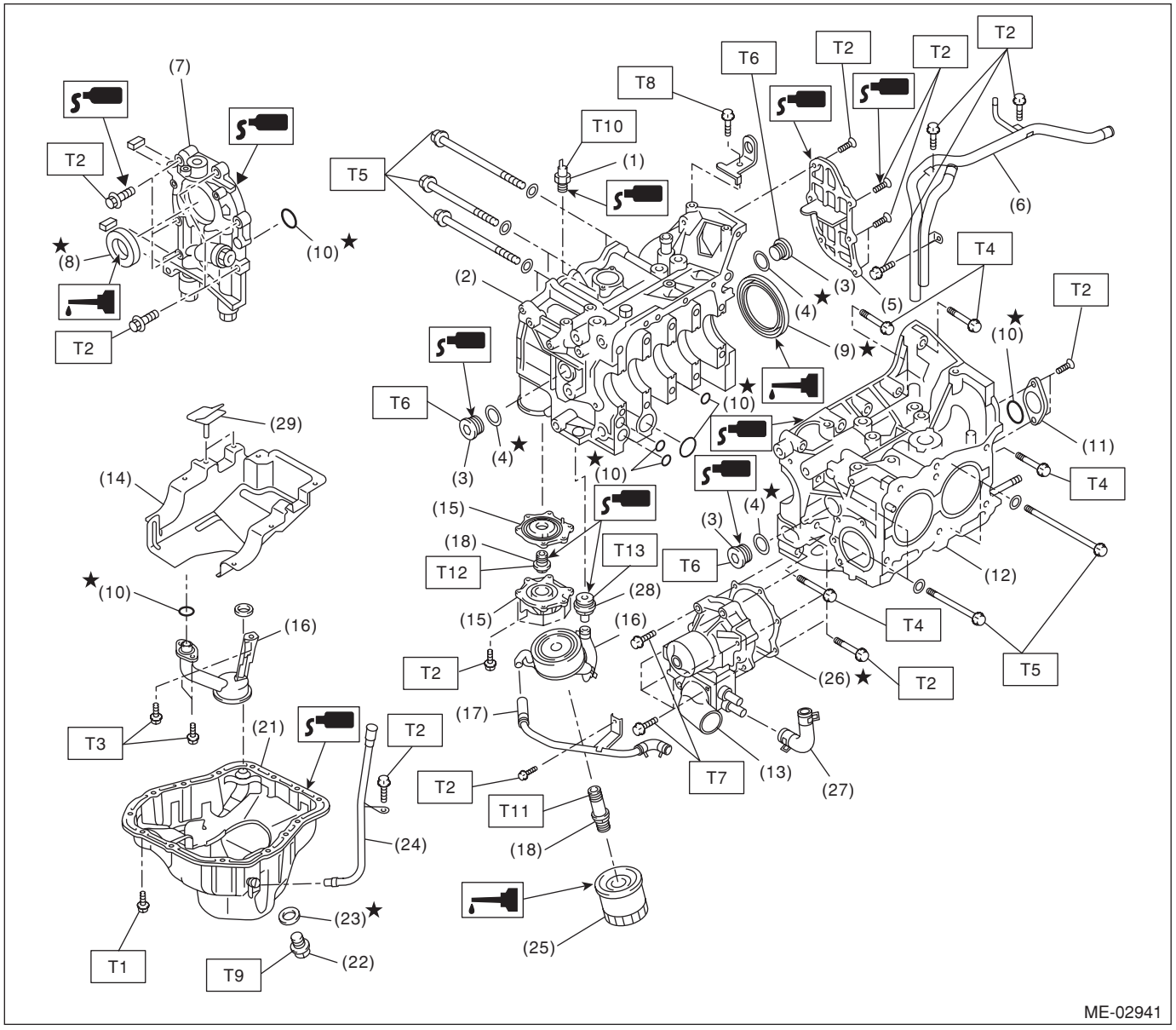
T1:	***<Ref. to ME(H4DOTC)-57, INSTALLATION, Cylinder Head.>***
T2:	***8 (0.8, 5.9)***
T3:	***10 (1.0, 7.2)***
T4:	***6.4 (0.65, 4.7)***
T5:	***20 (2.0, 14.5)***
T6:	***29 (3.0, 21.4)***

3. CYLINDER HEAD AND VALVE ASSEMBLY



(1) Exhaust valve
(2) Intake valve
(3) Cylinder head
(4) Valve spring seat
(5) Intake valve oil seal
(6) Valve spring
(7) Retainer
(8) Retainer key
(9) Valve lifter
(10) Exhaust valve oil seal
(11) Intake valve guide
(12) Exhaust valve guide

4. CYLINDER BLOCK

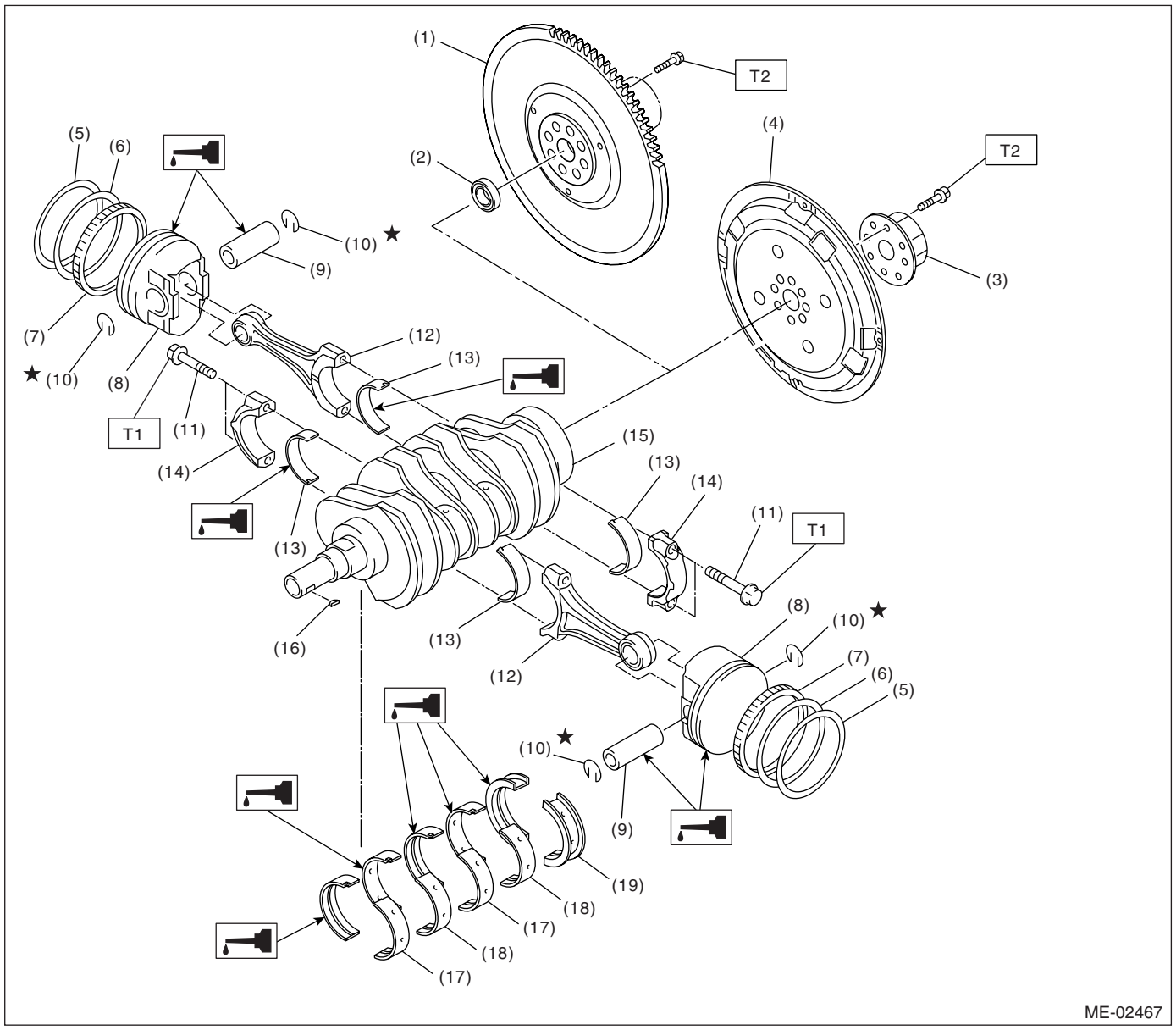


(1) Oil pressure switch
(2) Cylinder block (RH)
(3) Service hole plug
(4) Gasket
(5) Oil separator cover
(6) Water by-pass pipe
(7) Oil pump
(8) Front oil seal
(9) Rear oil seal
(10) O-ring
(11) Service hole cover
(12) Cylinder block (LH)
(13) Water pump
(14) Baffle plate
(15) Adapter
(16) Oil cooler
(17) Water by-pass pipe
(18) Connector
(19) Oil strainer
(20) Gasket
(21) Oil pan
(22) Drain plug
(23) Metal gasket
(24) Oil level gauge guide
(25) Oil filter
(26) Gasket
(27) Water pump hose
(28) Plug
(29) Seal
(30) Gasket

Tightening torque: N·m (kgf-m, ft-lb)

T1: 5 (0.5, 3.6)
T2: 6.4 (0.65, 4.7)
T3: 10 (1.0, 7.2)
T4: 25 (2.5, 18.1)
T5: <Ref. to ME(H4DOTC)-67, INSTALLATION, Cylinder Block.>
T6: 70 (7.1, 50.6)
T7: First 12 (1.2, 8.7)
Second 12 (1.2, 8.7)
T8: 16 (1.6, 11.6)
T9: 44 (4.5, 33)
T10: 25 (2.5, 18.1)
T11: 54 (5.3, 39)
T12: 45 (4.6, 33)
T13: 69 (7.0, 50.9)

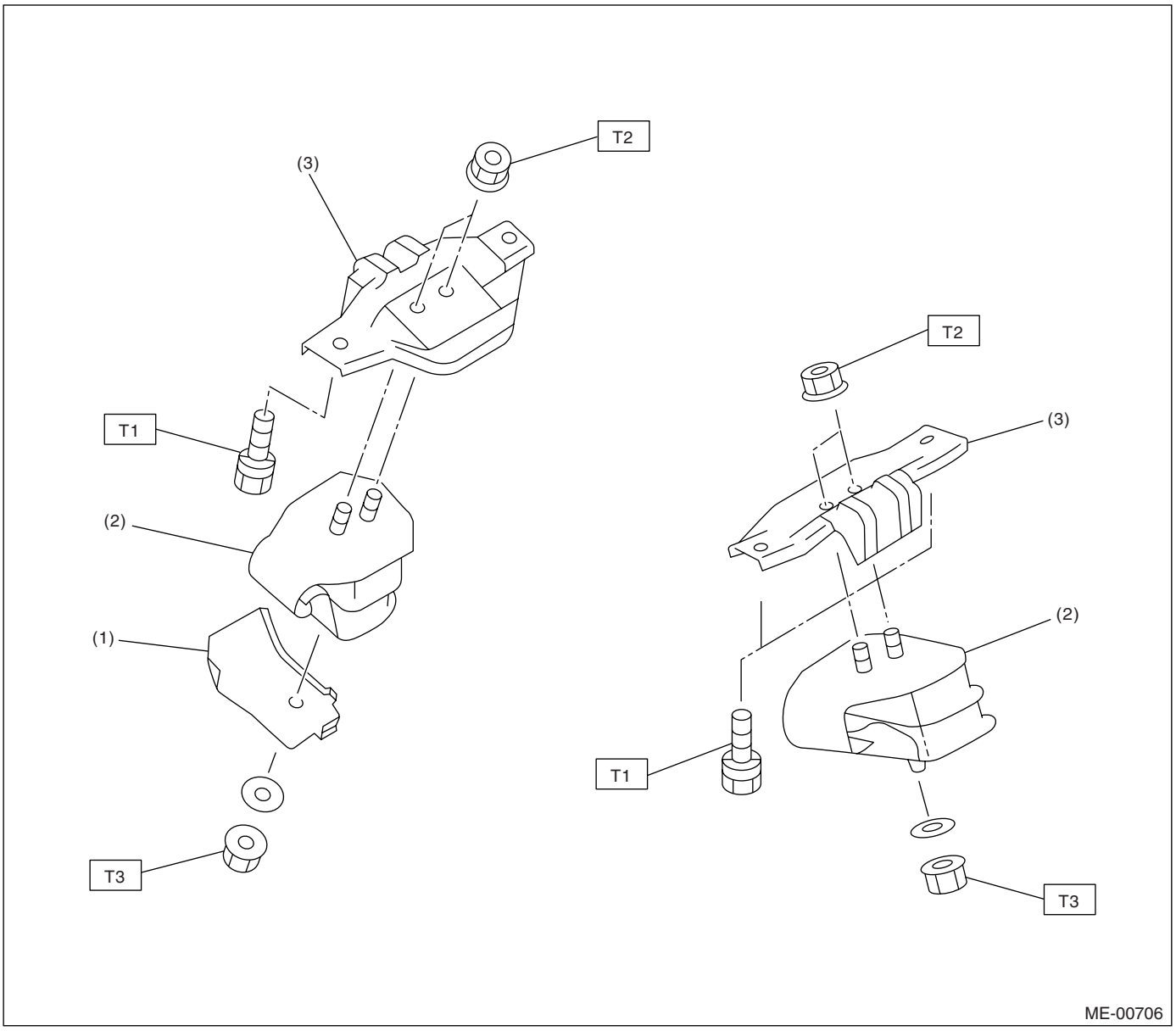
5. CRANKSHAFT AND PISTON



(1) Flywheel (MT model)
(2) Ball bearing MT model)
(3) Reinforcement (AT model)
(4) Drive plate (AT model)
(5) Top ring
(6) Second ring
(7) Oil ring
(8) Piston
(9) Piston pin
(10) Snap ring
(11) Connecting rod bolt
(12) Connecting rod
(13) Connecting rod bearing
(14) Connecting rod cap
(15) Crankshaft
(16) Woodruff key
(17) Crankshaft bearing #1, #3
(18) Crankshaft bearing #2, #4
(19) Crankshaft bearing #5

Tightening torque: N·m (kgf-m, ft-lb)
T1: 52 (5.3, 38.4)
T2: 72 (7.3, 52.8)

6. ENGINE MOUNTING



(1) Heat shield cover
(2) Front cushion rubber
(3) Front engine mounting bracket

Tightening torque: N·m (kgf-m, ft-lb)
T1: 35 (3.6, 25.8)
T2: 42 (4.3, 30.9)
T3: 85 (8.7, 62.7)

C: CAUTION

- Wear work clothing, including a cap, protective goggles and protective shoes during operation.
- Remove contamination including dirt and corrosion before removal, installation or disassembly.
- Keep the disassembled parts in order and protect them from dust and dirt.
- Before removal, installation or disassembly, be sure to clarify the failure. Avoid unnecessary removal, installation, disassembly and replacement.
- Be careful not to burn your hands, because each part on the vehicle is hot after running.
- Be sure to tighten fasteners including bolts and nuts to the specified torque.
- Place shop jacks or rigid racks at the specified points.
- Before disconnecting electrical connectors of sensors or units, be sure to disconnect the ground cable from battery.
- All parts should be thoroughly cleaned, paying special attention to engine oil passages, pistons and bearings.
- Rotating parts and sliding parts such as piston, bearing and gear should be coated with oil prior to assembly.
- Be careful not to let oil, grease or coolant contact the timing belt, clutch disc and flywheel.
- All removed parts, if to be reused, should be reinstalled in the original positions and directions.
- Bolts, nuts and washers should be replaced with new ones as required.
- Even if necessary inspections have been made in advance, proceed with assembly work while making rechecks.
- Remove or install the engine in an area where chain hoists, lifting devices, etc. are available for ready use.
- Be sure not to damage coated surfaces of body panels with tools or stain seats and windows with coolant or oil. Place a cover over fender, as required, for protection.
- Prior to starting work, prepare the following:

Service tools, clean cloth, containers to catch coolant and oil, wire ropes, chain hoist, transmission jacks, etc.

- Lift-up or lower the vehicle when necessary. Make sure to support the correct positions.

D: PREPARATION TOOL

1. SPECIAL TOOL

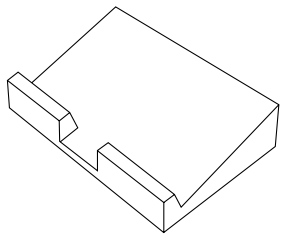
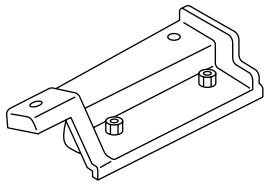
ILLUSTRATION	TOOL NUMBER	DESCRIPTION	REMARKS
 ST-498267600	498267600	CYLINDER HEAD TABLE	• Used for replacing valve guides. • Used for removing and installing valve spring.
 ST-498457000	498457000	ENGINE STAND ADAPTER RH	Used with ENGINE STAND (499817100).

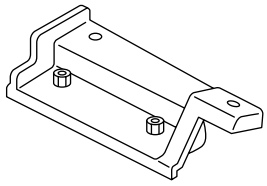
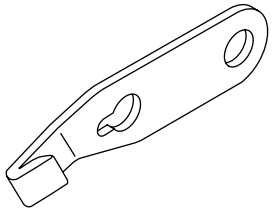
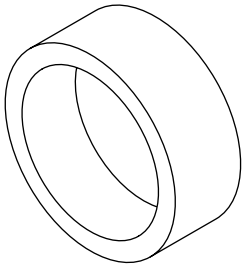
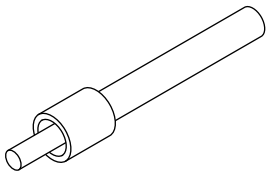
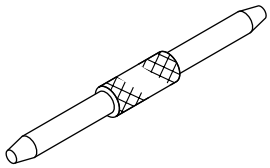
ILLUSTRATION	TOOL NUMBER	DESCRIPTION	REMARKS
 ST-498457100	498457100	ENGINE STAND ADAPTER LH	Used with ENGINE STAND (499817100).
 ST-498497100	498497100	CRANKSHAFT STOPPER	Used for stopping rotation of flywheel when loosening/tightening crank pulley bolt.
 ST-498747300	498747300	PISTON GUIDE	Used for installing piston in cylinder. (2.5 L model)
 ST-498857100	498857100	VALVE OIL SEAL GUIDE	Used for press-fitting of intake and exhaust valve guide oil seals.
 ST-499017100	499017100	PISTON PIN GUIDE	Used for installing piston pin, piston and connecting rod.

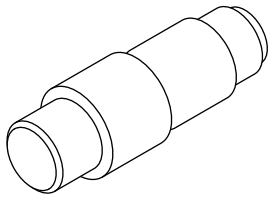
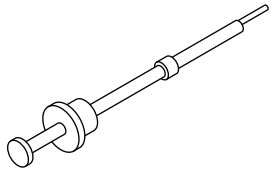
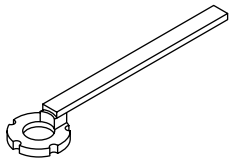
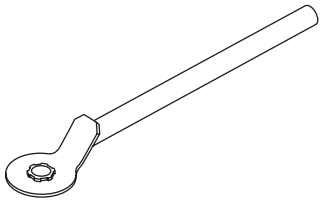
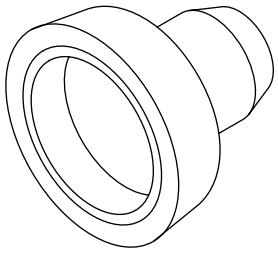
ILLUSTRATION	TOOL NUMBER	DESCRIPTION	REMARKS
 ST-499037100	499037100	CONNECTING ROD BUSHING REMOVER & INSTALLER	Used for removing and installing connecting rod bushing.
 ST-499097700	499097700	PISTON PIN REMOVER ASSY	Used for removing piston pin.
 ST-499207400	499207400	CAM SPROCKET WRENCH	Used for removing and installing cam sprocket. (Exhaust side)
 ST-499977500	499977500	CAM SPROCKET WRENCH	Used for removing and installing cam sprocket. (Intake side)
 ST-499587200	499587200	CRANKSHAFT OIL SEAL INSTALLER	• Used for installing crankshaft oil seal. • Used with CRANKSHAFT OIL SEAL GUIDE (499597100).

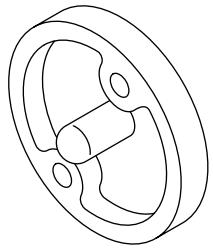
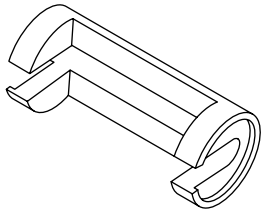
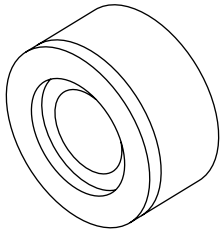
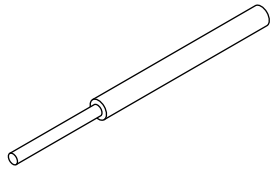
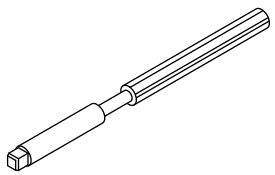
ILLUSTRATION	TOOL NUMBER	DESCRIPTION	REMARKS
 ST-499597100	499597100	CRANKSHAFT OIL SEAL GUIDE	• Used for installing crankshaft oil seal. • Used with CRANKSHAFT OIL SEAL INSTALLER (499587200).
 ST-499718000	499718000	VALVE SPRING REMOVER	Used for removing and installing valve spring.
 ST18251AA020	18251AA020	VALVE GUIDE ADJUSTER	Used for installing intake and exhaust valve guides.
 ST-499767200	499767200	VALVE GUIDE REMOVER	Used for removing valve guides.
 ST-499767400	499767400	VALVE GUIDE REAMER	Used for reaming valve guides.

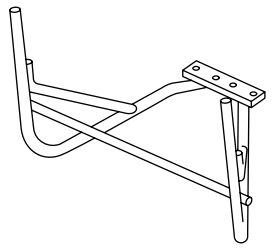
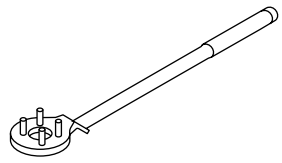
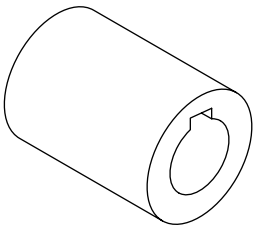
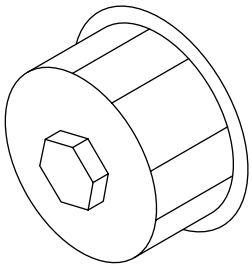
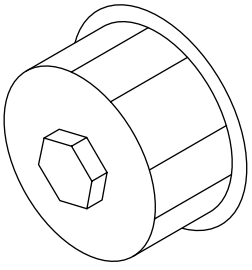
ILLUSTRATION	TOOL NUMBER	DESCRIPTION	REMARKS
 ST-499817100	499817100	ENGINE STAND	• Stand used for engine disassembly and assembly. • Used with ENGINE STAND ADAPTER RH (498457000) & LH (498457100).
 ST-499977100	499977100	CRANK PULLEY WRENCH	Used for stopping rotation of crank pulley when loosening/tightening crank pulley bolt.
 ST-499987500	499987500	CRANKSHAFT SOCKET	Used for rotating crankshaft.
 ST18332AA000	18332AA000	OIL FILTER WRENCH	Used for removing and installing oil filter. (Inner diameter 68 mm (2.68 in))
 ST18332AA010	18332AA010	OIL FILTER WRENCH	Used for removing and installing oil filter. (Inner diameter 65 mm (2.56 in))

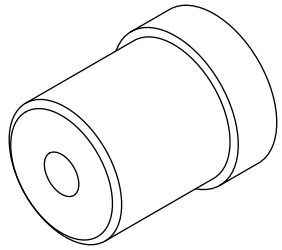
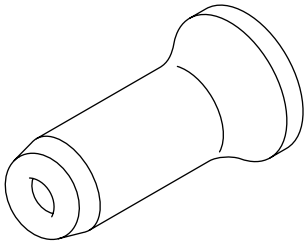
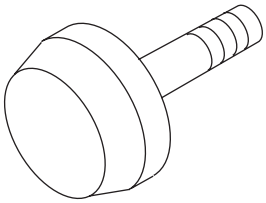
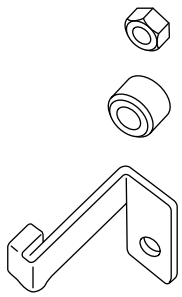
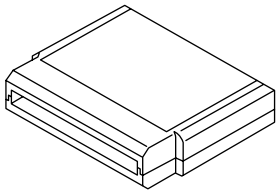
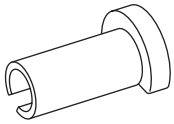
ILLUSTRATION	TOOL NUMBER	DESCRIPTION	REMARKS
 ST-499587100	499587100	OIL SEAL INSTALLER	Used for installing oil pump oil seal.
 ST-499587600	499587600	OIL SEAL INSTALLER	Used for installing camshaft oil seal for DOHC engine.
 ST-499597200	499597200	OIL SEAL GUIDE	• Used for installing camshaft oil seal for DOHC engine. • Used with OIL SEAL INSTALLER (499587600).
 ST-498277200	498277200	STOPPER SET	Used for installing automatic transmission assembly to engine.
 ST18482AA010	18482AA010	CARTRIDGE	Troubleshooting for electrical system.

ILLUSTRATION	TOOL NUMBER	DESCRIPTION	REMARKS
 ST22771AA030	22771AA030	SUBARU SELECT MONITOR KIT	Troubleshooting for electrical system.
 ST42099AE000	42099AE000	CONNECTOR REMOVER	Used for removing the quick connector in engine compartment.

2. GENERAL TOOL

TOOL NAME	REMARKS
Compression gauge	Used for measuring compression.
Vacuum gauge	Used for measuring negative pressure.
Oil pressure gauge	Used for measuring oil pressure.
Fuel pressure gauge	Used for measuring fuel pressure.

E: PROCEDURE

It is possible to conduct the following service procedures with engine on the vehicle, however, the procedures described in this section are based on the condition that the engine is removed from the vehicle.

- V-belt
- Timing belt
- Camshaft
- Cylinder head