1. General Description

A: SPECIFICATION

Engine	Model				2.0 L
	Cylinder arrangement				Horizontally opposed, liquid cooled, 4-cylinder, 4-stroke gasoline engine
	Valve system mechanism				Chain driven, double overhead camshaft, 4-valve/cylinder
	Bore × Stroke	mm (in)			86.0 × 86.0 (3.39 × 3.39)
	Displacement	cm^3 (cu in)			1,998 (121.92)
	Compression ratio				10.6
	Compression pressure (at 200 — 300 rpm)	kPa (kg/cm^2, psi)		Standard	1,350 — 1,750 (14 — 18, 196 — 254)
	Number of piston rings				Compression ring: 2 Oil ring: 1
	Intake valve timing		Open	Max. retard	ATDC 26°
				Min. advance	BTDC 42°
			Close	Max. retard	ABDC 82°
				Min. advance	ABDC 14°
	Exhaust valve timing		Open	Max. retard	BBDC 11°
				Min. advance	BBDC 66°
			Close	Max. retard	ATDC 55°
				Min. advance	ATDC 0°
	Cam clearance mm (in)	Intake		Standard	$0.13^{+0.02}_{-0.03}$ ($0.0051^{+0.0008}_{-0.0012}$)
		Exhaust		Standard	0.22±0.02 (0.0087±0.0008)
	Idle speed (For CVT model, select lever in “P” or “N” range. For MT model, gear shift lever in neutral position.) rpm		No load	Standard	700±100
			A/C ON	Standard	700 — 865±50
	Ignition order				1 → 3 → 2 → 4
	Ignition timing	BTDC/rpm		Standard	10°±10°/700

NOTE:
OS: Oversize US: Undersize

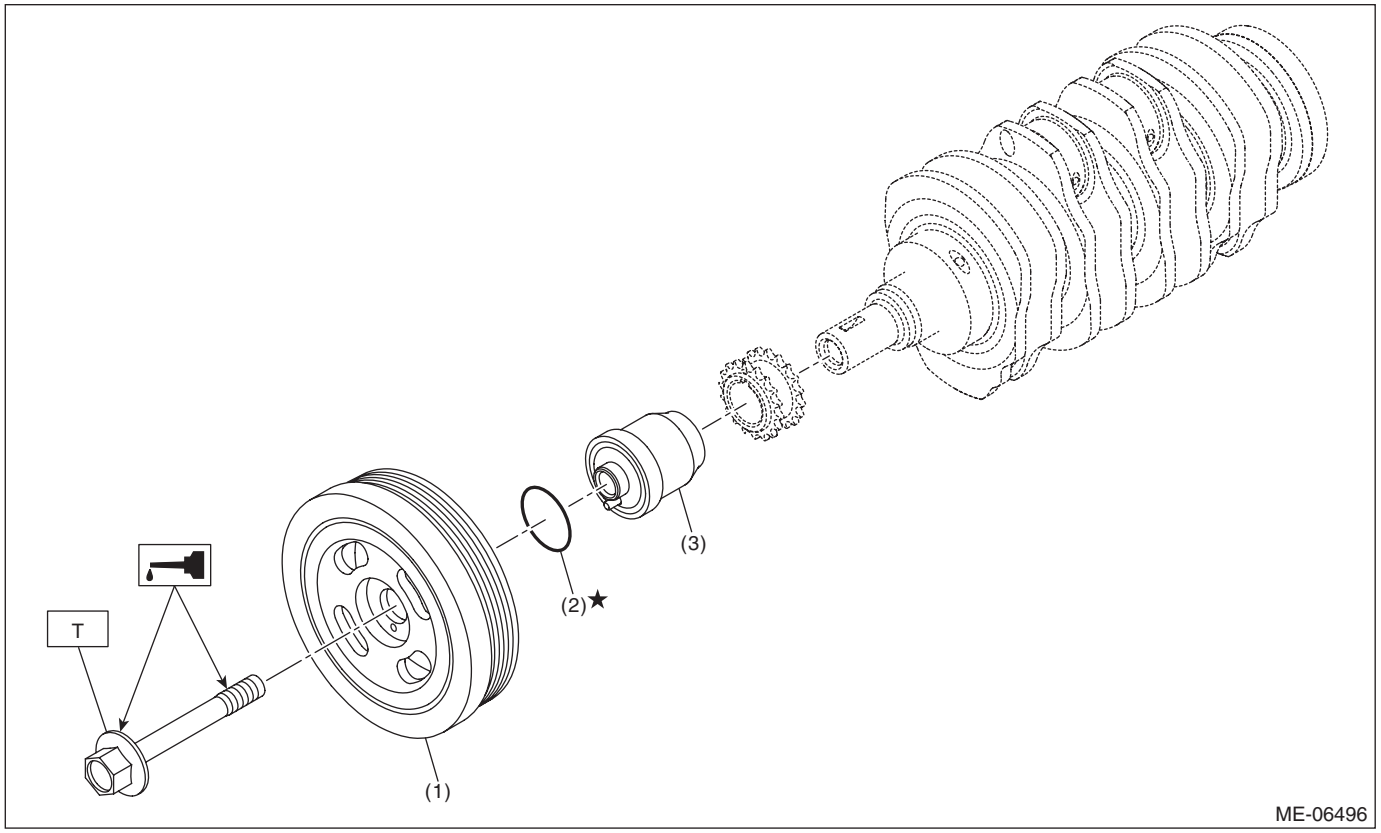
Camshaft	Bending				mm (in)	Limit	0.020 (0.00079)
	Cam lobe height mm (in)	Intake	Valve drive section			Standard	40.34 — 40.44 (1.588 — 1.592)
			Fuel pump drive section			Standard	41.95 — 42.05 (1.652 — 1.656)
		Exhaust				Standard	40.20 — 40.30 (1.583 — 1.587)
	Cam base circle diameter				mm (in)	Standard	34.0 (1.339)
	Journal outer diameter				mm (in)	Standard	25.946 — 25.963 (1.0215 — 1.0222)
	Thrust clearance				mm (in)	Standard	0.068 — 0.116 (0.0027 — 0.0047)
	Oil clearance				mm (in)	Standard	0.037 — 0.072 (0.0015 — 0.0028)
Cylinder head	Warpage (mating surface with cylinder block)				mm (in)	Limit	0.020 (0.00079)
	Grinding limit				mm (in)		To 98.4 (3.874)
	Height				mm (in)	Standard	98.5 (3.878)
Valve & valve guide	Valve overall length				mm (in)	Intake	104.95 (4.132)
						Exhaust	97.9 (3.854)
	Valve head edge thickness			mm (in)	Intake	Standard	0.8 — 1.2 (0.031 — 0.047)
					Exhaust	Standard	1.0 — 1.4 (0.039 — 0.055)
	Valve stem outer diameter			mm (in)	Intake	Standard	5.455 — 5.470 (0.2148 — 0.2154)
					Exhaust	Standard	5.445 — 5.460 (0.2144 — 0.2150)
	Valve guide inner diameter				mm (in)	Standard	5.500 — 5.512 (0.2165 — 0.2170)
	Clearance between valve and valve guide			mm (in)	Intake	Standard	0.030 — 0.057 (0.0012 — 0.0022)
					Exhaust	Standard	0.040 — 0.067 (0.0016 — 0.0026)
	Valve guide protrusion amount				mm (in)	Standard	11.4 — 11.8 (0.449 — 0.465)
Valve & valve shim	Valve stem end outer diameter			mm (in)	Intake	Standard	5.455 — 5.470 (0.2148 — 0.2154)
					Exhaust	Standard	5.445 — 5.460 (0.2144 — 0.2150)
	Valve shim inner diameter				mm (in)	Standard	5.500 — 5.560 (0.2165 — 0.2189)
	Clearance between valve and valve shim			mm (in)	Intake	Standard	0.030 — 0.105 (0.0012 — 0.0041)
					Exhaust	Standard	0.040 — 0.115 (0.0016 — 0.0045)
Valve seat	Seating width between valve and valve seat			mm (in)	Intake	Standard	0.8 — 1.6 (0.031 — 0.063)
					Exhaust	Standard	1.1 — 1.7 (0.043 — 0.067)
	Seating angle between valve and valve seat						45°
	Seating position between valve and valve seat						Valve face center
Valve spring	Free length				mm (in)	Standard	CVT model: 41.68 (1.641)
							MT model: 41.06 (1.617)
	Tension/spring height			N (kgf, lb)/mm (in)	Set	Standard	182 — 210 (18.56 — 21.41, 40.92 — 47.22)/ 33.0 (1.299)
					Lift	Standard	CVT model: 502 — 554 (51.19 — 56.49, 112.87 — 124.56)/ 22.0 (0.866)
							MT model: 552 — 610 (56.29 — 62.20, 124.11 — 137.15)/ 22.0 (0.866)
	Squareness					Standard	2.5°, 1.8 mm (0.071 in) or less

Cylinder block & piston	Cylinder block warpage (Mating surface with cylinder head) mm (in)			Limit	0.025 (0.00098)
	Grinding limit of cylinder block mm (in)				To 204.9 (8.067)
	Height of cylinder block mm (in)			Standard	205.0 (8.071)
	Inner diameter of cylinder liner mm (in)	Cylinder bore size mark A		Standard	86.005 — 86.015 (3.3860 — 3.3864)
		Cylinder bore size mark B		Standard	85.995 — 86.005 (3.3856 — 3.3860)
	Cylindricality of cylinder liner mm (in)			Limit	0.030 (0.0012)
	Out-of-roundness of cylinder liner mm (in)			Limit	0.030 (0.0012)
	Piston grade point mm (in)				40.0 (1.57)
	Piston outer diameter mm (in)	Standard Size	Grade A	Standard	85.985 — 85.995 (3.3852 — 3.3856)
			Grade B	Standard	85.975 — 85.985 (3.3848 — 3.3852)
		0.25 (0.0098) OS		Standard	86.225 — 86.245 (3.3947 — 3.3955)
		0.50 (0.0197) OS		Standard	86.475 — 86.495 (3.4045 — 3.4053)
	Clearance between cylinder liner and piston mm (in)			Standard	0.010 — 0.030 (0.00039 — 0.00118)
	Inner diameter of cylinder liner boring limit (diameter) mm (in)				To 86.505 (3.4057)
Piston and piston pin	Degree of fit				Piston pin must be fitted into position with thumb at 20°C (68°F).
	Clearance between piston and piston pin mm (in)			Standard	0.004 — 0.008 (0.0002 — 0.0003)
Piston ring	Closed gap mm (in)	Compression ring	Top ring	Standard	0.20 — 0.25 (0.0079 — 0.0098)
			Second ring	Standard	0.40 — 0.50 (0.0157 — 0.0197)
		Oil ring (Upper rail and lower rail)		Standard	0.10 — 0.35 (0.0039 — 0.0138)
	Clearance between compression ring and piston mm (in)	Top ring		Standard	0.040 — 0.080 (0.0016 — 0.0031)
		Second ring		Standard	0.045 — 0.085 (0.0018 — 0.0033)
Connecting rod and connecting rod bearing	Bend or twist per 100 mm (3.94 in) in length mm (in)			Limit	0.10 (0.0039)
	Thrust clearance mm (in)			Standard	0.070 — 0.330 (0.0028 — 0.0130)
	Connecting rod bearing thickness (at center) mm (in)	Standard size		Standard	1.492 — 1.508 (0.0587 — 0.0594)
		0.03 (0.0012) US		Standard	1.511 — 1.515 (0.0595 — 0.0596)
		0.05 (0.0020) US		Standard	1.521 — 1.525 (0.0599 — 0.0600)
		0.25 (0.0098) US		Standard	1.621 — 1.625 (0.0638 — 0.0640)
	Oil clearance mm (in)			Standard	0.025 — 0.055 (0.0010 — 0.0022)
Piston pin & connecting rod bushing	Clearance between piston pin and connecting rod bushing mm (in)			Standard	0.004 — 0.026 (0.0002 — 0.0010)

Crankshaft and crankshaft bearing	Bending			Limit	0.035 (0.0014)
	Crankshaft pin	Cylindricality mm (in)		Limit	0.006 (0.0002)
		Out-of-roundness mm (in)		Limit	0.005 (0.0002)
		Grinding limit (dia.)		mm (in)	To 49.726 (1.9577)
	Crankshaft journal	Cylindricality mm (in)		Limit	0.006 (0.0002)
		Out-of-roundness mm (in)		Limit	0.005 (0.0002)
		Grinding limit (dia.)		mm (in)	To 67.735 (2.6667)
	Crankshaft pin outer diameter mm (in)		Standard size	Standard	49.976 — 50.000 (1.9676 — 1.9685)
			0.03 (0.0012) US	Standard	49.946 — 49.970 (1.9664 — 1.9673)
			0.05 (0.0020) US	Standard	49.926 — 49.950 (1.9656 — 1.9665)
			0.25 (0.0098) US	Standard	49.726 — 49.750 (1.9577 — 1.9587)
	Crankshaft journal outer diameter mm (in)		Standard size	Standard	67.985 — 68.009 (2.6766 — 2.6775)
			0.03 (0.0012) US	Standard	67.955 — 67.979 (2.6754 — 2.6763)
			0.05 (0.0020) US	Standard	67.935 — 67.959 (2.6746 — 2.6755)
			0.25 (0.0098) US	Standard	67.735 — 67.759 (2.6667 — 2.6677)
	Crankshaft bearing thickness (at center) mm (in)	#1, #2, #3, #4	Standard size	Standard	2.495 — 2.513 (0.0982 — 0.0989)
			0.03 (0.0012) US	Standard	2.519 — 2.522 (0.0992 — 0.0993)
			0.05 (0.0020) US	Standard	2.529 — 2.532 (0.0996 — 0.0997)
			0.25 (0.0098) US	Standard	2.629 — 2.632 (0.1035 — 0.1036)
		#5	Standard size	Standard	2.493 — 2.511 (0.0981 — 0.0989)
			0.03 (0.0012) US	Standard	2.517 — 2.520 (0.0991 — 0.0992)
			0.05 (0.0020) US	Standard	2.527 — 2.530 (0.0995 — 0.0996)
			0.25 (0.0098) US	Standard	2.627 — 2.630 (0.1034 — 0.1035)
	Thrust clearance			mm (in)	Standard	0.130 — 0.308 (0.00512 — 0.01213)
	Oil clearance			mm (in)	Standard	0.013 — 0.031 (0.00051 — 0.00122)

B: COMPONENT

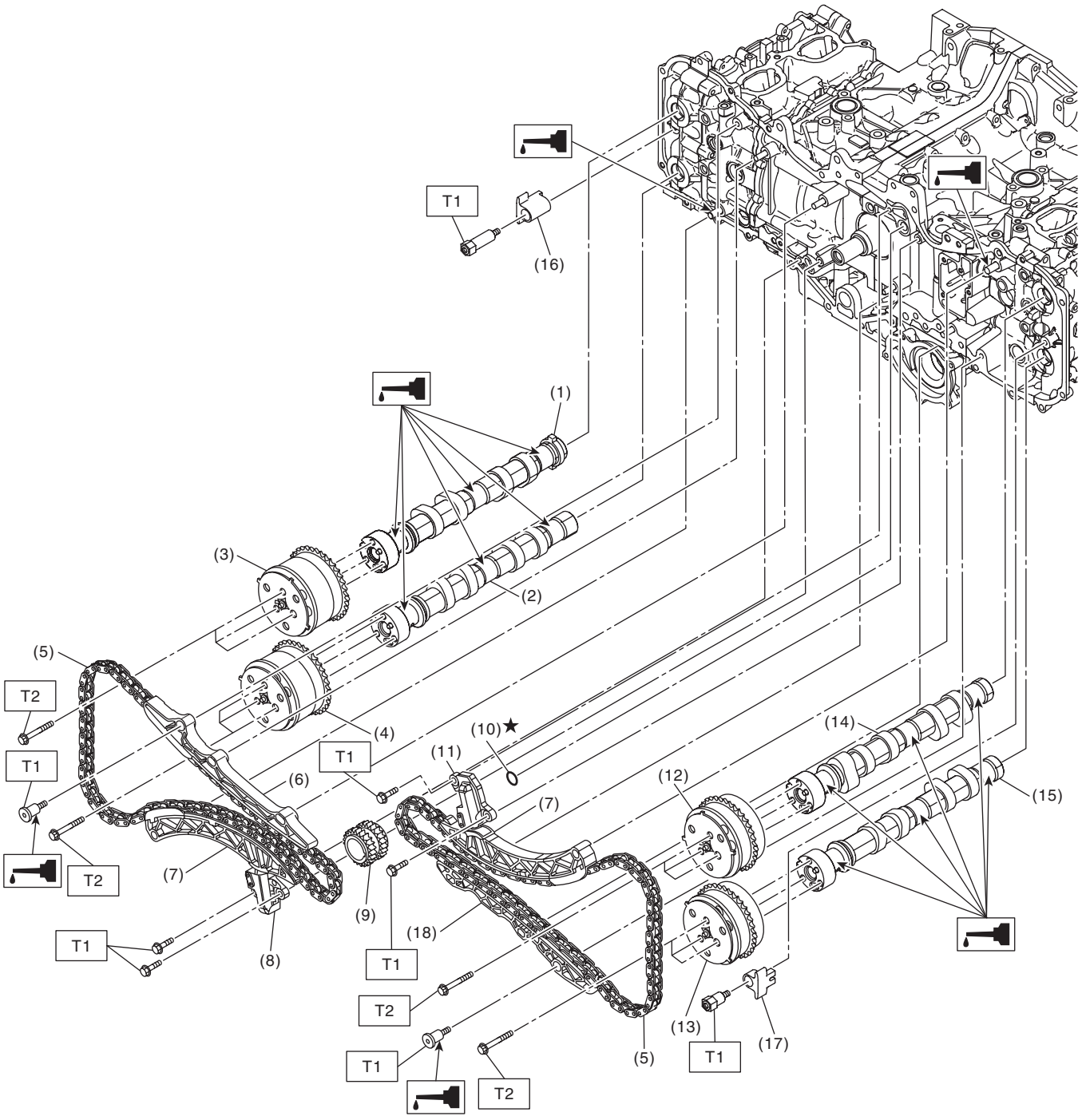
1. CRANK PULLEY



(1) Crank pulley
(2) O-ring
(3) Crank pulley boss

Tightening torque: N·m (kgf-m, ft-lb)
T: <Ref. to ME(w/o STI)-87, INSTALLATION, Crank Pulley.>

2. TIMING CHAIN & CAMSHAFT

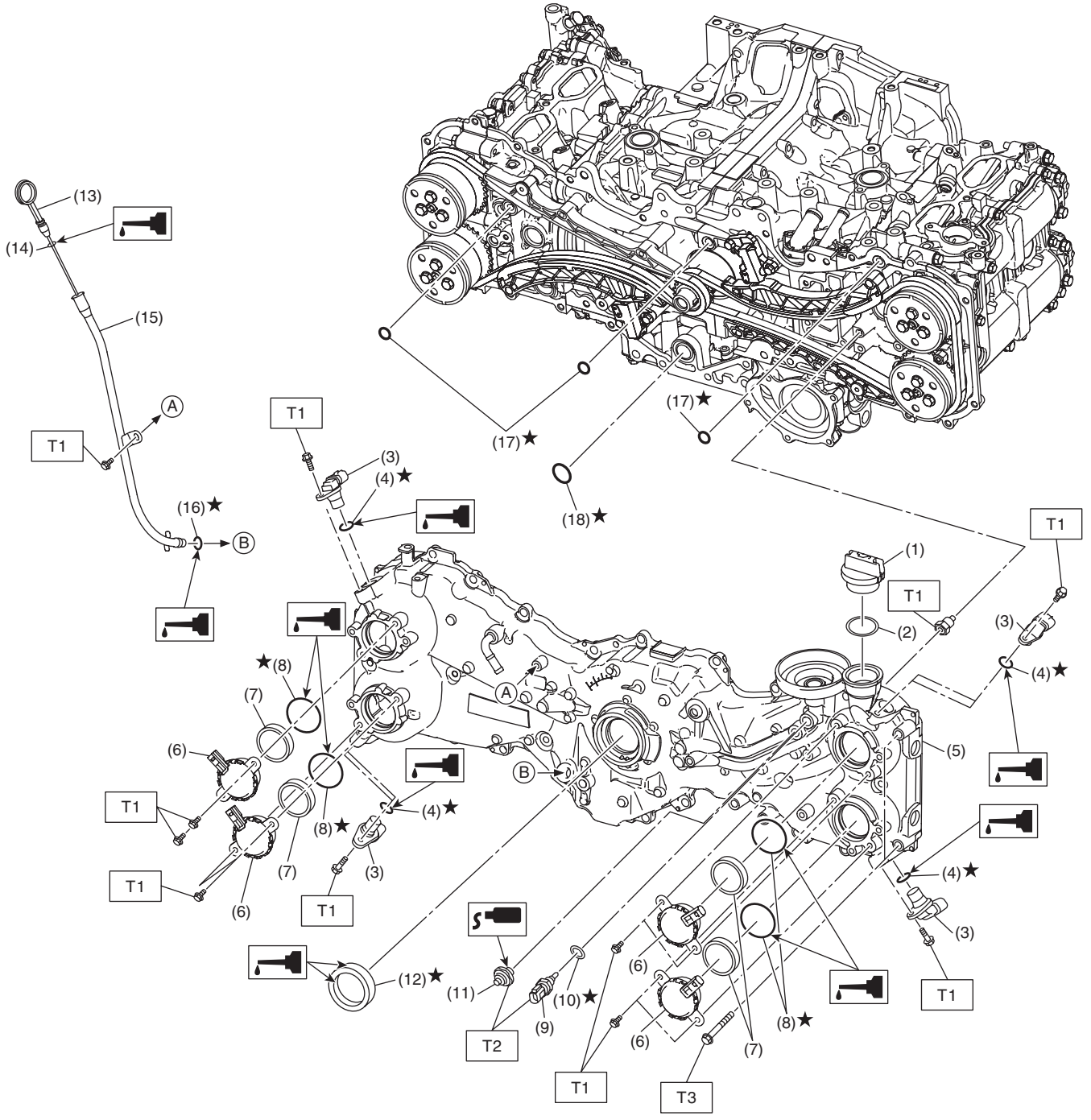


ME-07893

(1) Intake camshaft RH
(2) Exhaust camshaft RH
(3) Intake cam sprocket RH
(4) Exhaust cam sprocket RH
(5) Timing chain
(6) Chain guide A
(7) Chain tension lever
(8) Chain tensioner RH
(9) Crank sprocket
(10) O-ring
(11) Chain tensioner LH
(12) Intake cam sprocket LH
(13) Exhaust cam sprocket LH
(14) Intake camshaft LH
(15) Exhaust camshaft LH
(16) Chain guide B
(17) Chain guide C
(18) Chain guide D

Tightening torque: N·m (kgf-m, ft-lb)
T1: 6.4 (0.7, 4.7)
T2: 18 (1.8, 13.3)

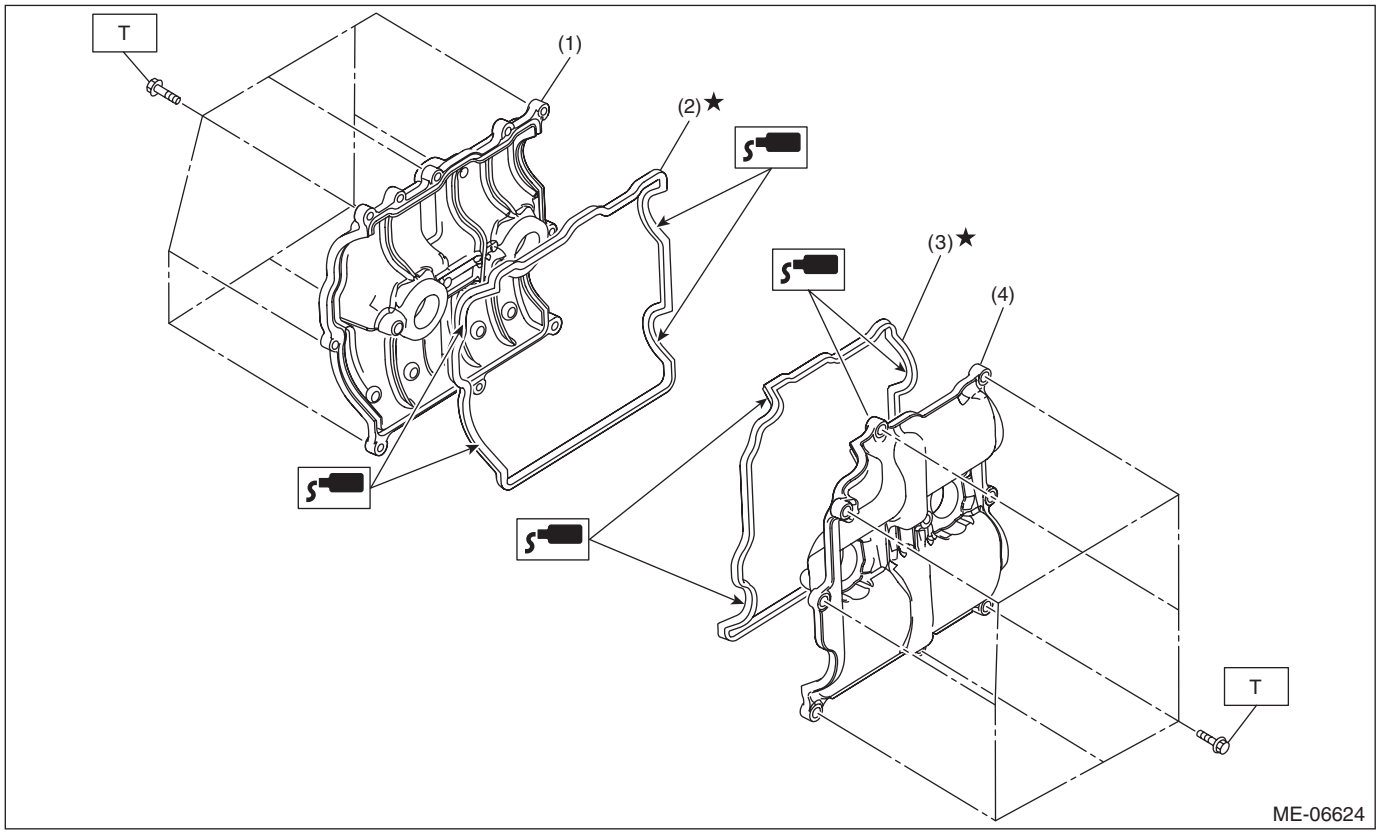
3. CHAIN COVER



(1) Oil filler cap
(2) Gasket
(3) Camshaft position sensor
(4) O-ring
(5) Chain cover
(6) Oil control solenoid
(7) Back-up ring
(8) O-ring
(9) Engine oil temperature sensor
(10) Gasket
(11) Oil pressure switch
(12) Front oil seal
(13) Oil level gauge
(14) O-ring
(15) Oil level gauge guide
(16) O-ring
(17) O-ring
(18) O-ring

Tightening torque: N·m (kgf-m, ft-lb)
T1: 6.4 (0.7, 4.7)
T2: 18 (1.8, 13.3)
T3: <Ref. to ME(w/o STI)-101, INSTALLATION, Chain Cover.>

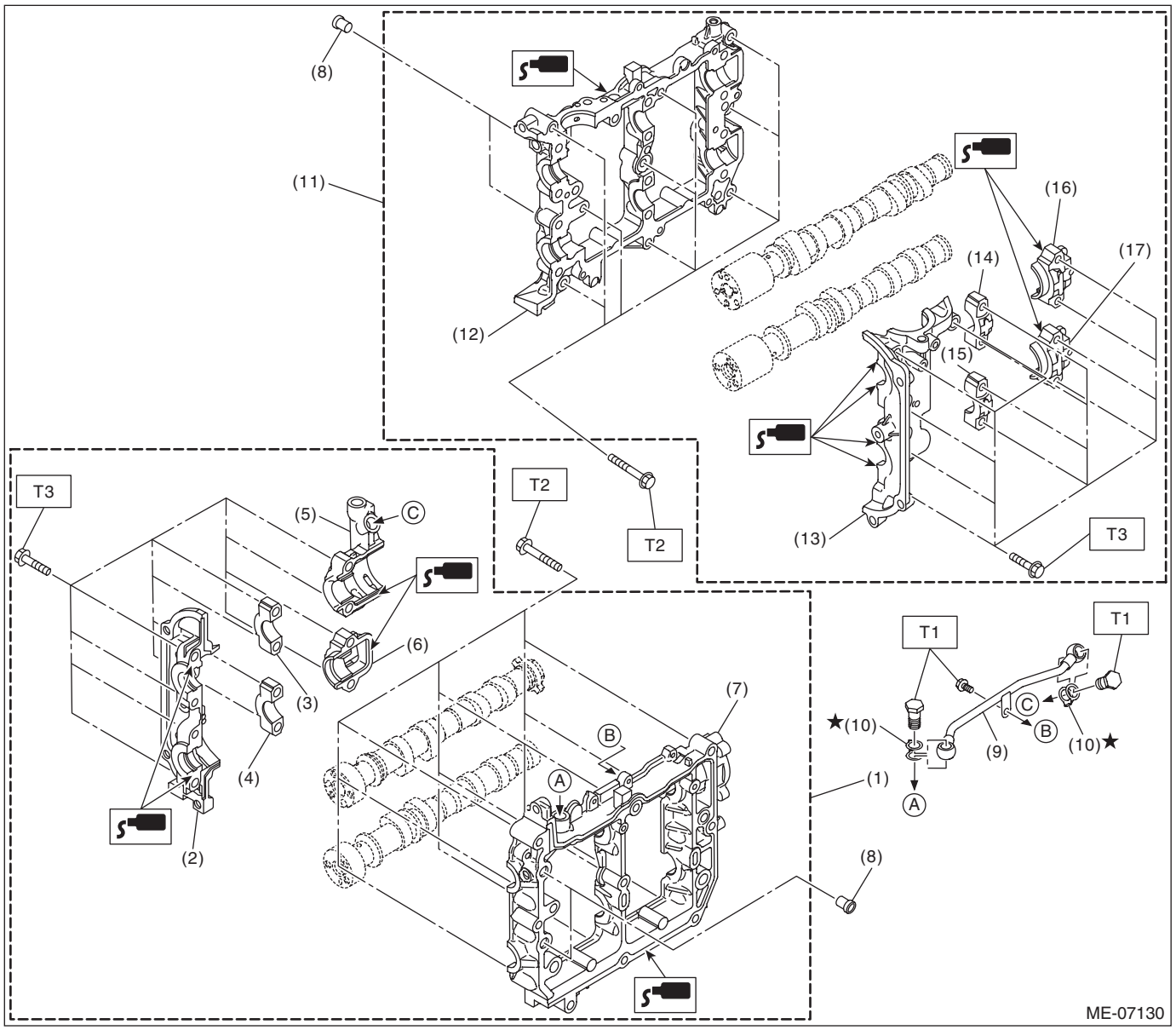
4. ROCKER COVER



(1) Rocker cover RH
(2) Rocker cover gasket RH
(3) Rocker cover gasket LH
(4) Rocker cover LH

Tightening torque: N·m (kgf-m, ft-lb)
T: <Ref. to ME(w/o STI)-161, INSTALLATION, Rocker Cover.>

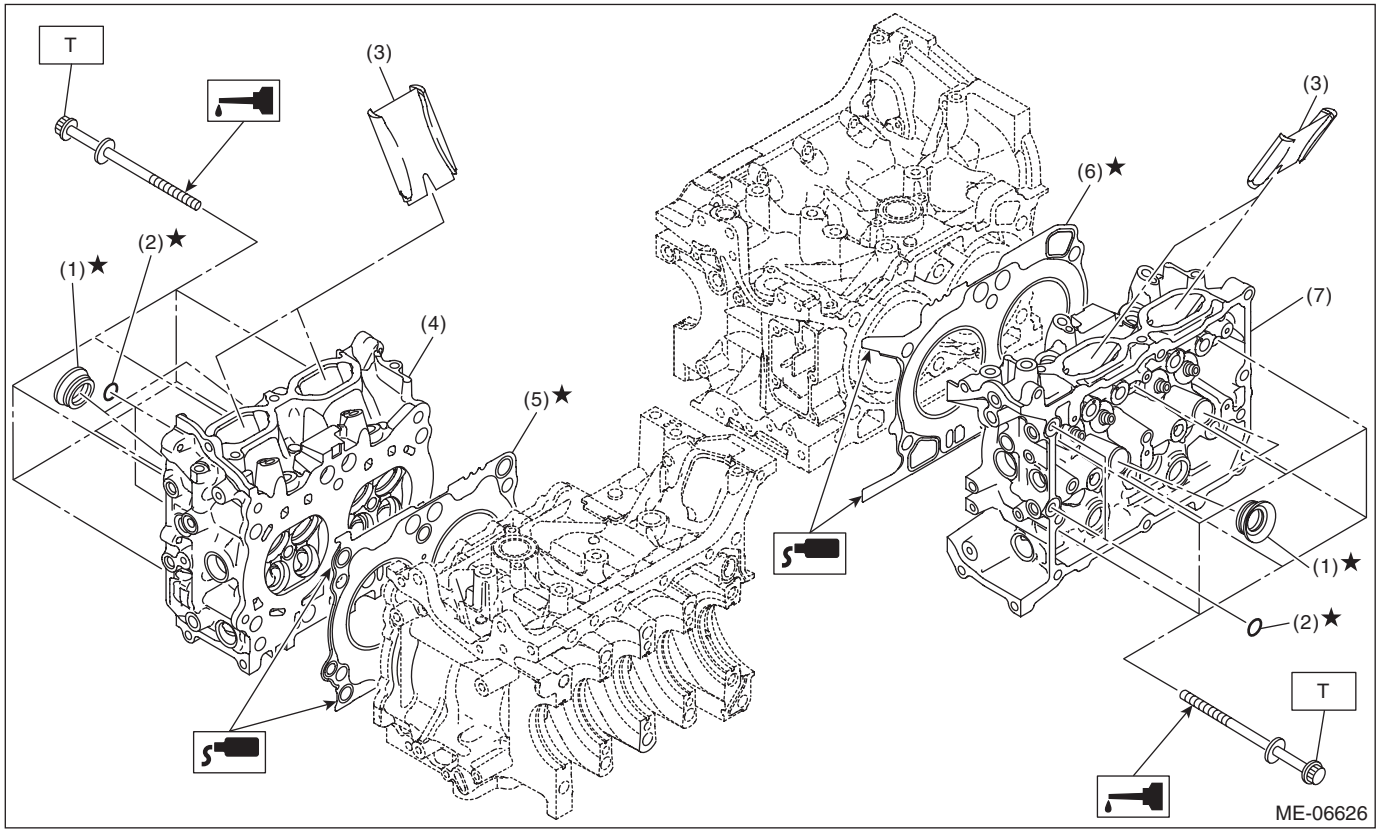
5. CAM CARRIER



(1) Cam carrier ASSY RH
(2) Front camshaft cap RH
(3) Intake center camshaft cap RH
(4) Exhaust center camshaft cap RH
(5) Intake rear camshaft cap RH
(6) Exhaust rear camshaft cap RH
(7) Cam carrier RH
(8) Filter
(9) Oil pipe
(10) Gasket
(11) Cam carrier ASSY LH
(12) Cam carrier LH
(13) Front camshaft cap LH
(14) Intake center camshaft cap LH
(15) Exhaust center camshaft cap LH
(16) Intake rear camshaft cap LH
(17) Exhaust rear camshaft cap LH

Tightening torque: N·m (kgf-m, ft-lb)
T1: <Ref. to ME(w/o STI)-204, CAM CARRIER RH, ASSEMBLY, Cam Carrier.>
T2: <Ref. to ME(w/o STI)-204, ASSEMBLY, Cam Carrier.>
T3: <Ref. to ME(w/o STI)-180, INSTALLATION, Cam Carrier.>

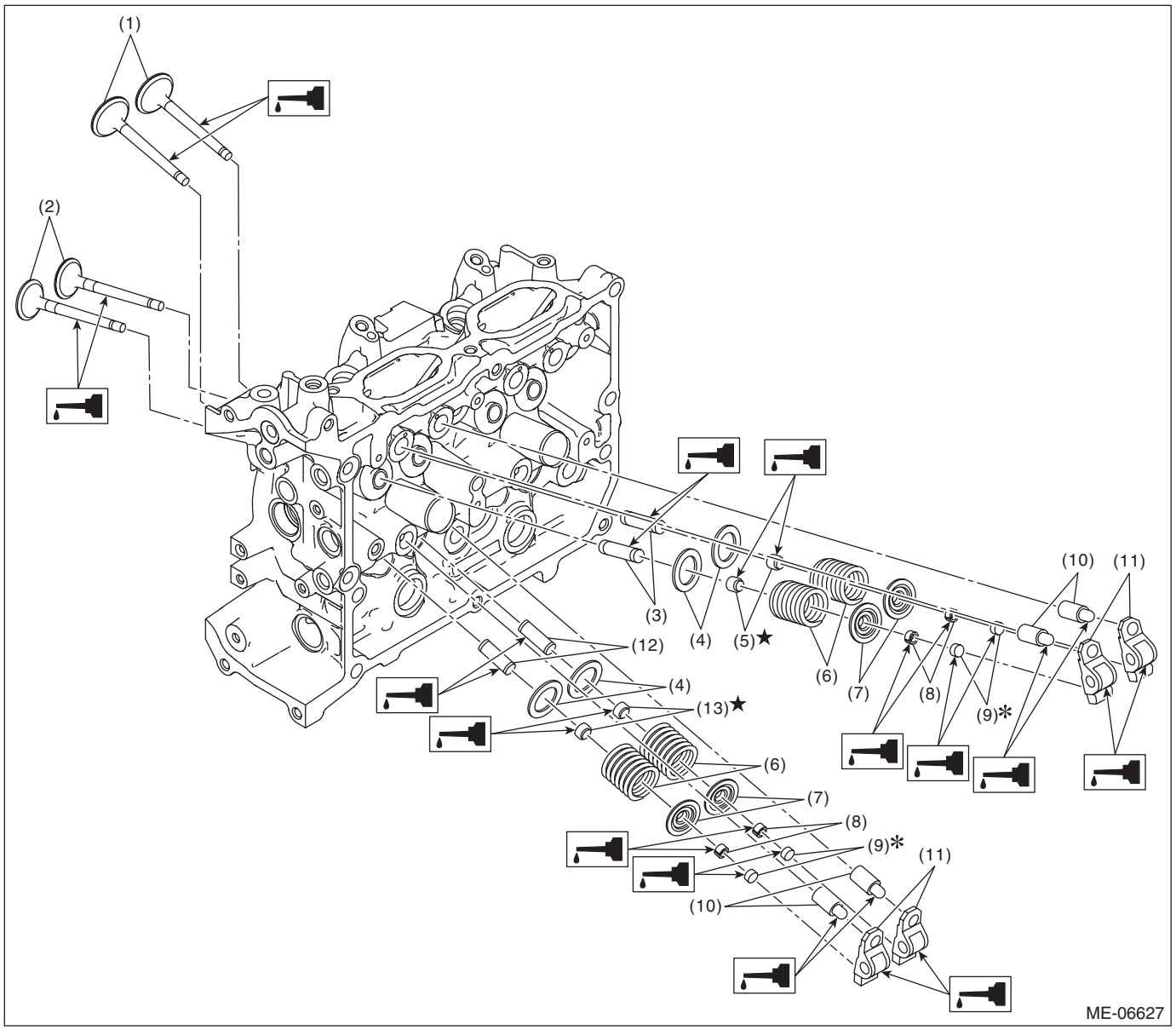
6. CYLINDER HEAD



(1) Spark plug pipe gasket
(2) O-ring
(3) Cylinder head plate
(4) Cylinder head RH
(5) Cylinder head gasket RH
(6) Cylinder head gasket LH
(7) Cylinder head LH

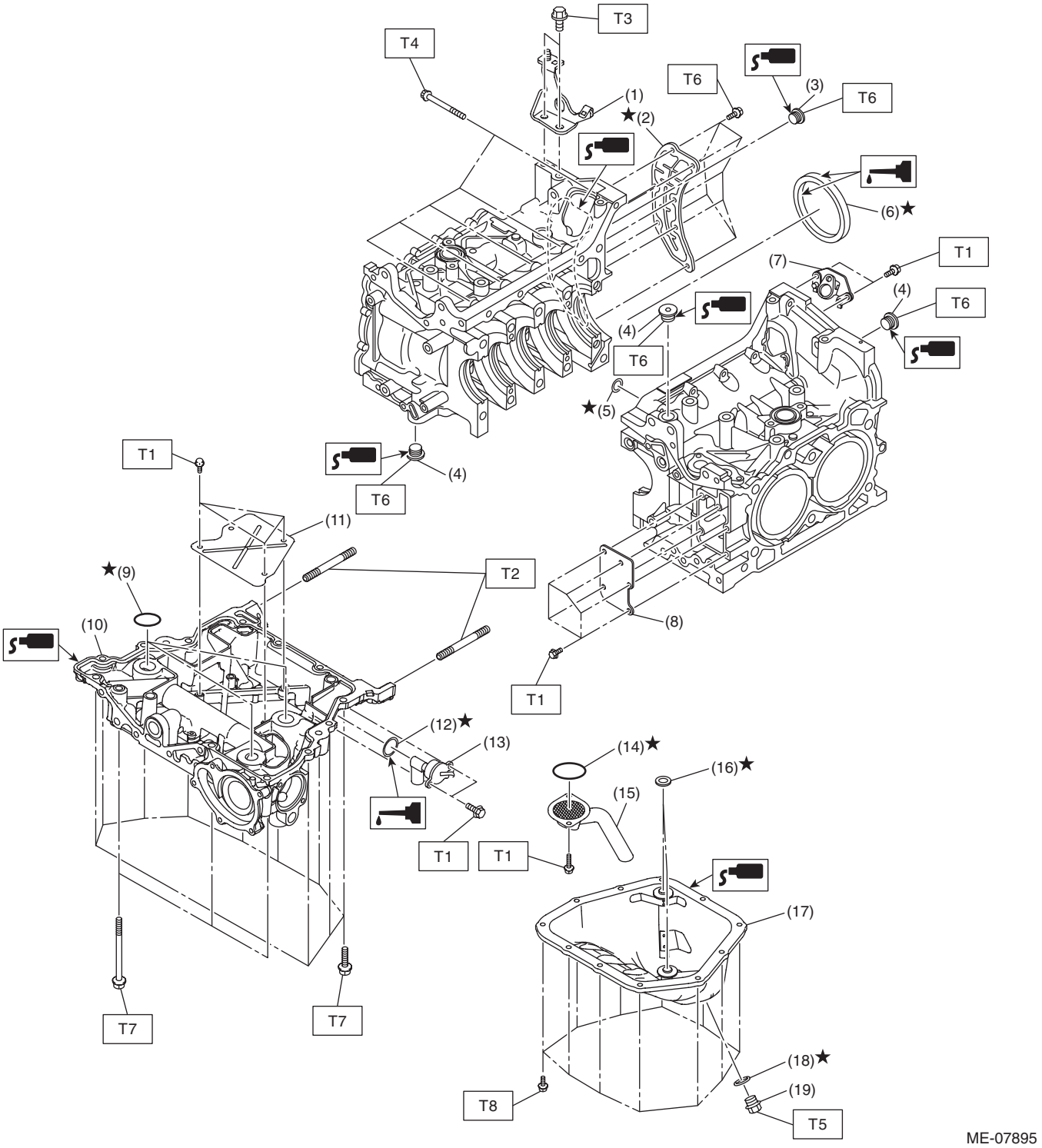
Tightening torque: N·m (kgf-m, ft-lb)
T: <Ref. to ME(w/o STI)-218, INSTALLATION, Cylinder Head.>

7. VALVE ASSEMBLY



(1) Exhaust valve
(2) Intake valve
(3) Intake valve guide
(4) Valve spring seat
(5) Intake valve oil seal
(6) Valve spring
(7) Valve spring retainer
(8) Valve collet
(9) Valve shim
(10) Roller rocker arm pivot
(11) Roller rocker arm
(12) Exhaust valve guide
(13) Exhaust valve oil seal

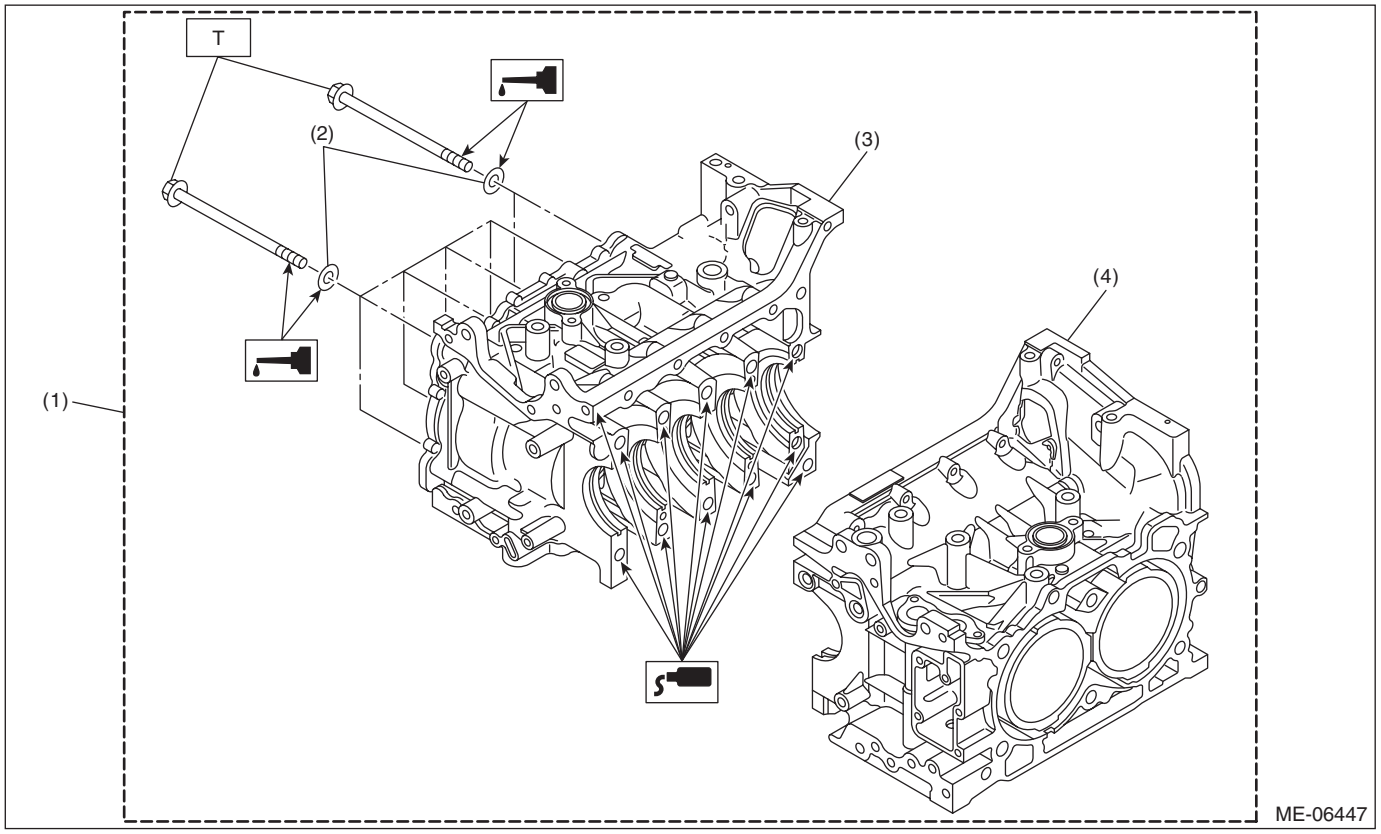
8. CYLINDER BLOCK 1



(1) Engine rear hanger
(2) Oil separator cover
(3) Cylinder block plug
(4) Main gallery plug
(5) O-ring
(6) Rear oil seal
(7) Crankshaft position sensor holder
(8) Cylinder block plate
(9) O-ring
(10) Oil pan upper
(11) Baffle plate
(12) O-ring
(13) Oil level switch
(14) O-ring
(15) Oil strainer
(16) Oil pan seal ring
(17) Oil pan
(18) Drain plug gasket
(19) Drain plug

Tightening torque: N·m (kgf-m, ft-lb)
T1: 6.4 (0.7, 4.7)
T2: 10 (1.0, 7.4)
T3: 21 (2.1, 15.5)
T4: 25 (2.5, 18.4)
T5: 41.7 (4.3, 30.8)
T6: <Ref. to ME(w/o STI)-305, CYLINDER BLOCK, ASSEMBLY, Cylinder Block.>
T7: <Ref. to ME(w/o STI)-272, INSTALLATION, Cylinder Block.>
T8: <Ref. to LU(w/o STI)-21, OIL PAN AND STRAINER, INSTALLATION, Oil Pan and Strainer.>

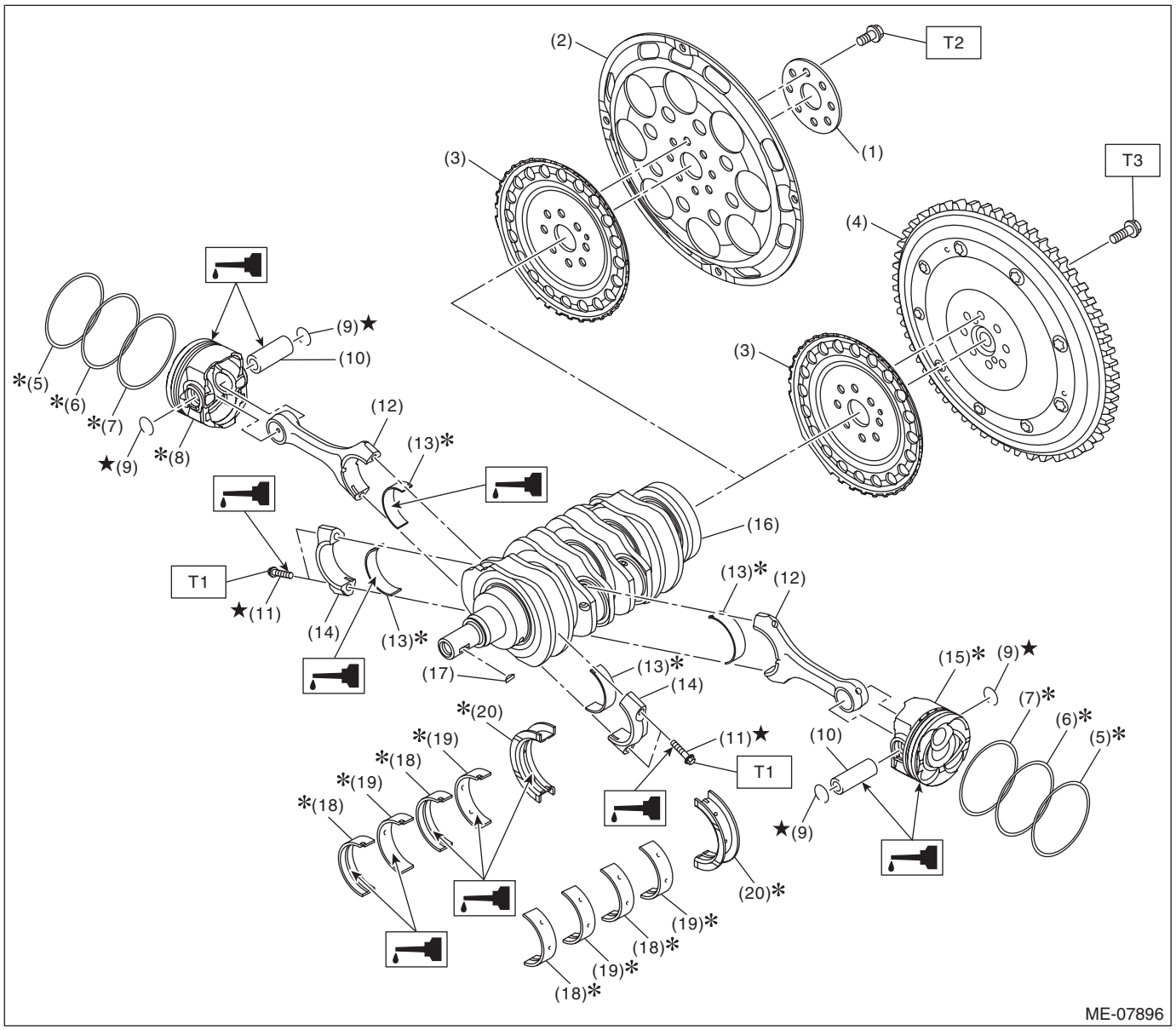
9. CYLINDER BLOCK 2



(1) Cylinder block ASSY
(2) Washer
(3) Cylinder block RH
(4) Cylinder block LH

Tightening torque: N·m (kgf-m, ft-lb)
T: <Ref. to ME(w/o STI)-272, INSTALLATION, Cylinder Block.>

10.CRANKSHAFT AND PISTON



(1) Reinforcement drive plate (CVT model)
(2) Drive plate (CVT model)
(3) Crankshaft position sensor plate
(4) Flywheel (MT model)
(5) Top ring
(6) Second ring
(7) Oil ring
(8) Piston RH
(9) Circlip
(10) Piston pin
(11) Connecting rod cap bolt
(12) Connecting rod
(13) Connecting rod bearing
(14) Connecting rod cap
(15) Piston LH
(16) Crankshaft
(17) Woodruff key
(18) Crankshaft bearing #1, #3
(19) Crankshaft bearing #2, #4
(20) Crankshaft bearing #5

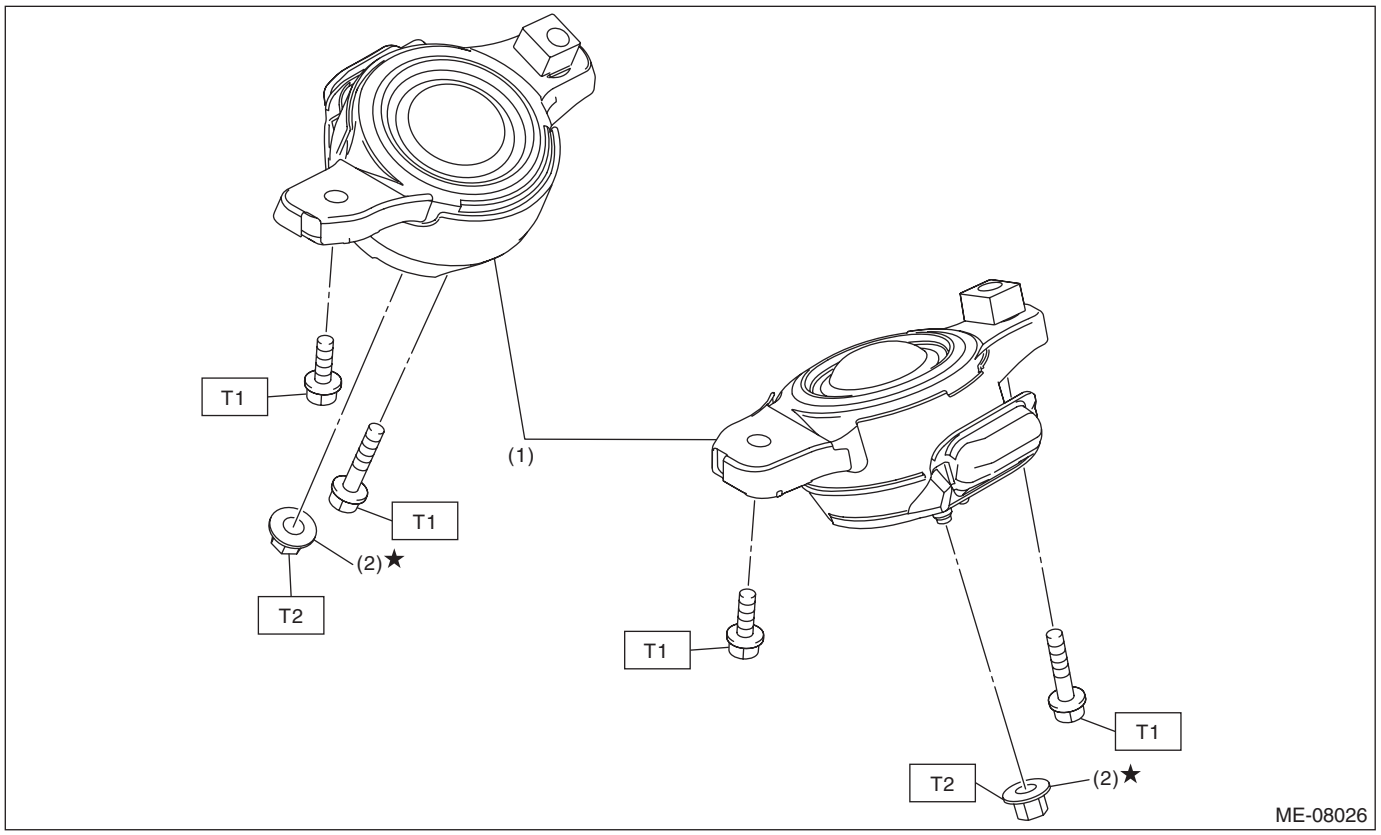
Tightening torque: N·m (kgf-m, ft-lb)

T1: <Ref. to ME(w/o STI)-272, INSTALLATION, Cylinder Block.>

T2: <Ref. to CVT(TR690)-138, INSTALLATION, Drive Plate.>

T3: <Ref. to CL-15, INSTALLATION, Flywheel.>

11.ENGINE MOUNTING



(1) Front cushion rubber (2) Nut

Tightening torque: N·m (kgf-m, ft-lb)
T1: 35 (3.6, 25.8)
T2: 60 (6.1, 44.3)

C: CAUTION

- Prior to starting work, pay special attention to the following:
  1. Always wear work clothes, a work cap, and protective shoes. Additionally, wear a helmet, protective goggles, etc. if necessary.
  2. Protect the vehicle using a seat cover, fender cover, etc.
  3. Prepare the service tools, clean cloth, containers to catch grease and oil, etc.
- Vehicle components are extremely hot immediately after driving. Be wary of receiving burns from heated parts.
- When performing a repair, identify the cause of trouble and avoid unnecessary removal, disassembly and replacement.
- Before disconnecting connectors of sensors or units, be sure to disconnect the ground cable from battery.
- Always use the jack-up point when the shop jacks or rigid racks are used to support the vehicle.
- Remove or install the engine in an area where chain hoists, lifting devices, etc. are available for ready use. When lifting up the vehicle, make sure to support the vehicle at the jack-up points.
- Be careful not to let any oil or grease contact the clutch disc or flywheel.
- Remove contamination including dirt and corrosion before removal, installation, disassembly or assembly.
- Keep the removed parts in order and protect them from dust and dirt.
- All removed parts, if to be reused, should be reinstalled in the original positions with attention to the correct directions, etc.
- Rotating parts and sliding parts such as piston, bearing and gear should be coated with oil when being assembled.
- Bolts, nuts and washers should be replaced with new parts as required.
- Be sure to tighten the fasteners including bolts and nuts to the specified torque.

D: PREPARATION TOOL

1. SPECIAL TOOL

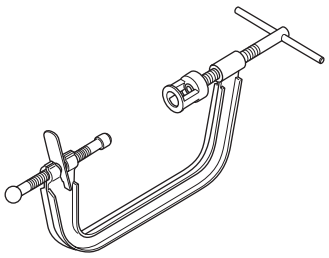
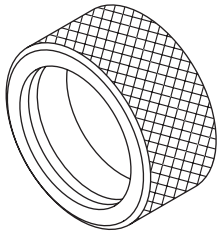
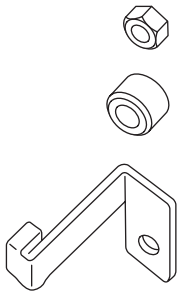
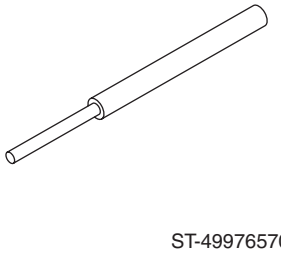
ILLUSTRATION	TOOL NUMBER	DESCRIPTION	REMARKS
 ST0920287002000	0920287002000	REMOVER AND REPLACER	Used for removing and installing valve spring.
 ST-398437700	398437700	OIL SEAL INSTALLER	Used for installing the front oil seal of engine.
 ST-498277200	498277200	STOPPER SET	Used for preventing the torque converter from falling when removing and installing the engine. (CVT model)
 ST-499765700	499765700	VALVE GUIDE REMOVER AND INSTALLER	Used for removing and installing valve guide.

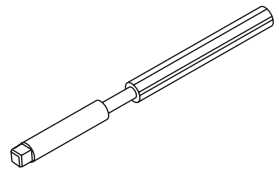
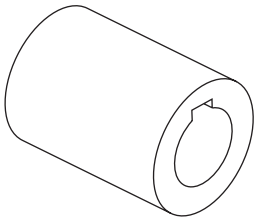
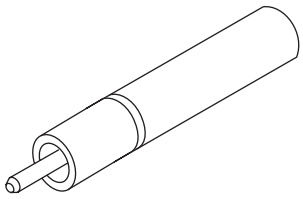
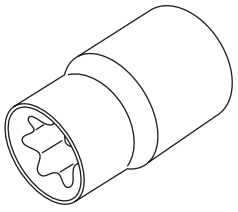
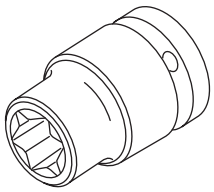
ILLUSTRATION	TOOL NUMBER	DESCRIPTION	REMARKS
 ST-499765900	499765900	VALVE GUIDE REAMER	Used for reaming valve guides.
 ST18252AA000	18252AA000	CRANKSHAFT SOCKET	Used for rotating crankshaft.
 ST18261AA010	18261AA010	VALVE OIL SEAL GUIDE	Used for press-fitting of intake valve oil seals and exhaust valve oil seals.
 ST18270AA020	18270AA020	SOCKET	Used for removing and installing connecting rod.
 ST18270KA010	18270KA010	SOCKET	Used for installing and removing intake cam sprocket and exhaust cam sprocket.

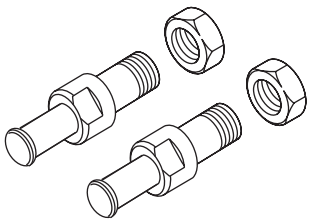
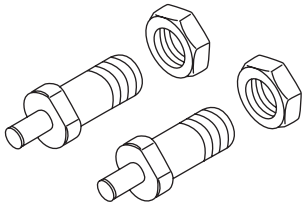
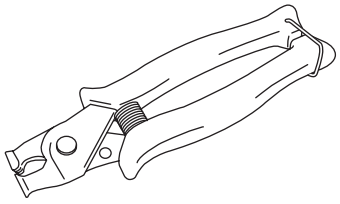
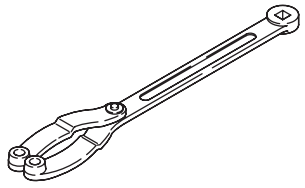
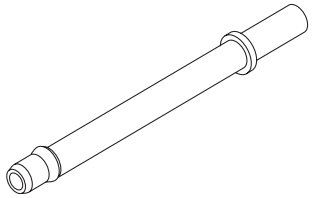
ILLUSTRATION	TOOL NUMBER	DESCRIPTION	REMARKS
 ST18334AA000	18334AA000	PULLEY WRENCH PIN SET	• Used for removing and installing the crank pulley. • Used together with PULLEY WRENCH (18355AA000).
 ST18334AA020	18334AA020	PULLEY WRENCH PIN SET	• Used for removing and installing intake cam sprocket and exhaust cam sprocket. • Used together with PULLEY WRENCH (18355AA000).
 ST18353AA000	18353AA000	CLAMP PLIERS	• Used for removing and installing the PCV hose assembly. • This tool is made by the French company CAILLAU. (code) 54.0.000.205 To make it easier to obtain, it has been provided with a tool number.
 ST18355AA000	18355AA000	PULLEY WRENCH	• Used for removing and installing the crank pulley. • Used for removing and installing intake cam sprocket and exhaust cam sprocket. • Used together with PULLEY WRENCH PIN SET (18334AA000) or PULLEY WRENCH PIN SET (18334AA020).
 ST18471AA000	18471AA000	FUEL PIPE ADAPTER	Used for inspecting the fuel pressure.

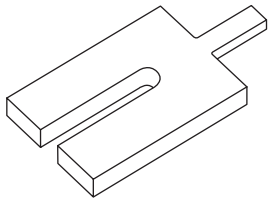
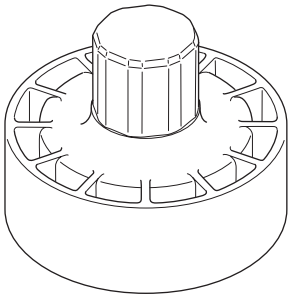
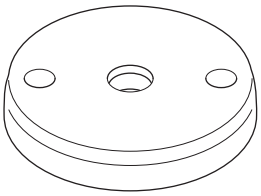
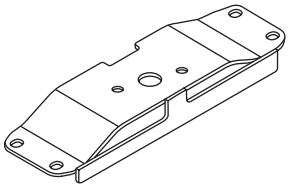
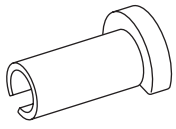
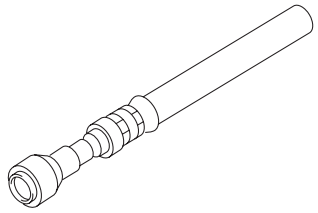
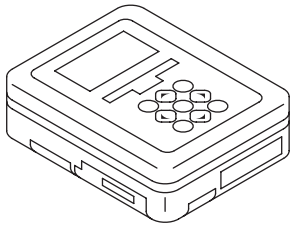
ILLUSTRATION	TOOL NUMBER	DESCRIPTION	REMARKS
 ST18632AA030	18632AA030 (Newly adopted tool)	STAND ASSY	Used for removing and installing rocker cover LH.
 ST18657AA030	18657AA030	OIL SEAL INSTALLER	• Used for installing the rear oil seal of engine. • Used together with OIL SEAL GUIDE (18671AA020).
 ST18671AA020	18671AA020	OIL SEAL GUIDE	• Used for installing the rear oil seal of engine. • Used together with OIL SEAL INSTALLER (18657AA030).
 ST41099YC001	41099YC001 (Newly adopted tool)	ST REAR MOUNT	Used for removing and installing engine. (CVT model)
 ST42099AE000	42099AE000	QUICK CONNECTOR RELEASE	Used for removing FUEL HOSE (42075AG690). NOTE: FUEL HOSE (42075AG690) is used for checking the fuel pressure.

ILLUSTRATION	TOOL NUMBER	DESCRIPTION	REMARKS
 ST42075AG690	42075AG690	FUEL HOSE	Used for inspecting the fuel pressure. NOTE: This is the SUBARU genuine part.
 ST1B022XU0	1B022XU0	SUBARU SELECT MONITOR III KIT	Used for various inspections.

2. GENERAL TOOL

TOOL NAME	REMARKS
Compression gauge	Used for measuring compression.
Vacuum gauge	Used for measuring intake manifold vacuum.
Oil pressure gauge	Used for measuring engine oil pressure.
Fuel pressure gauge	Used for measuring fuel pressure.
Piston ring compressor	Used for installing the piston into the cylinder block.
Thickness gauge	Used for various inspections.
Angle gauge	Used for angle tightening.