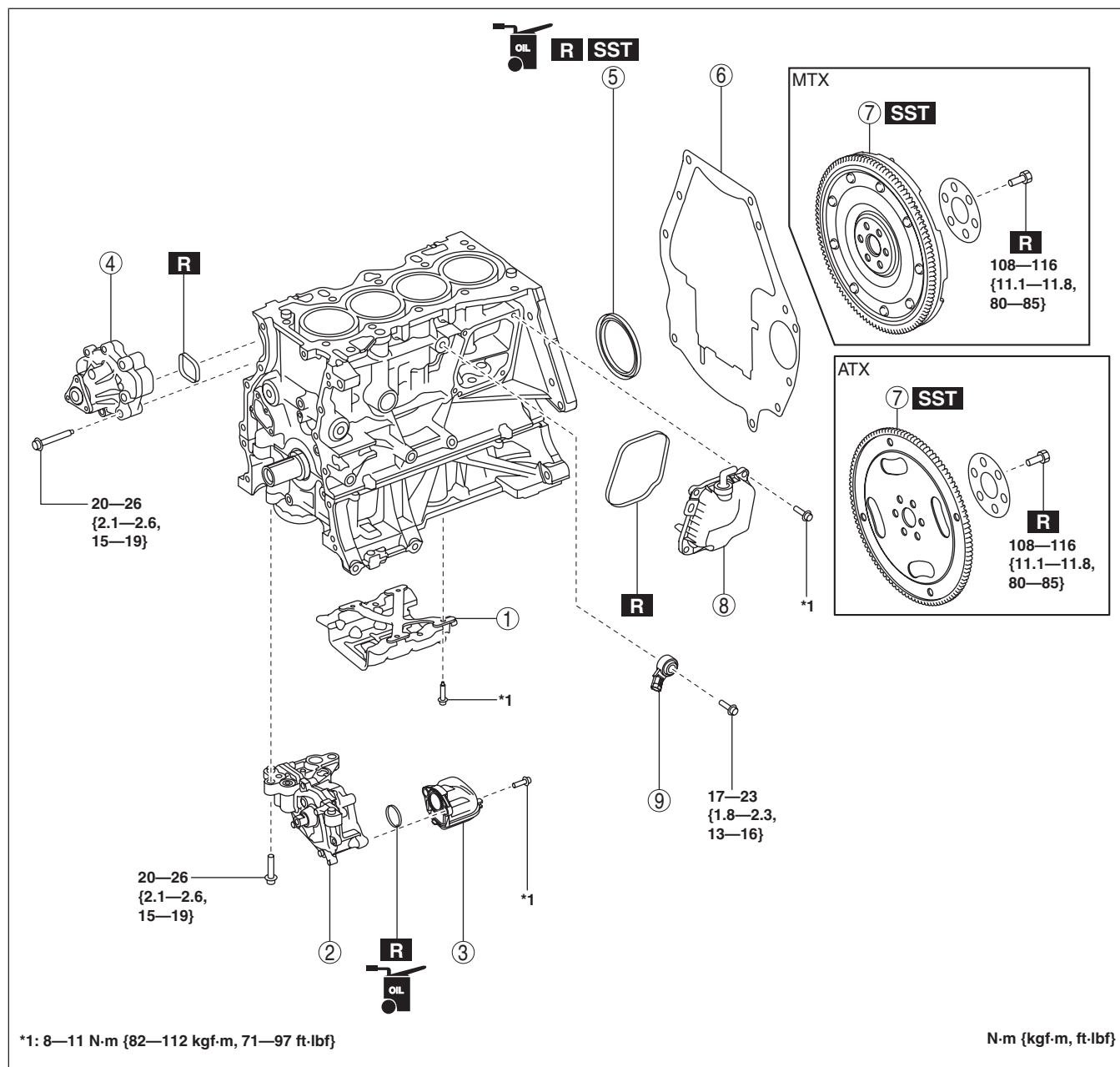


CYLINDER BLOCK ASSEMBLY (II)

id011000504100

1. Assemble in the order indicated in the table.

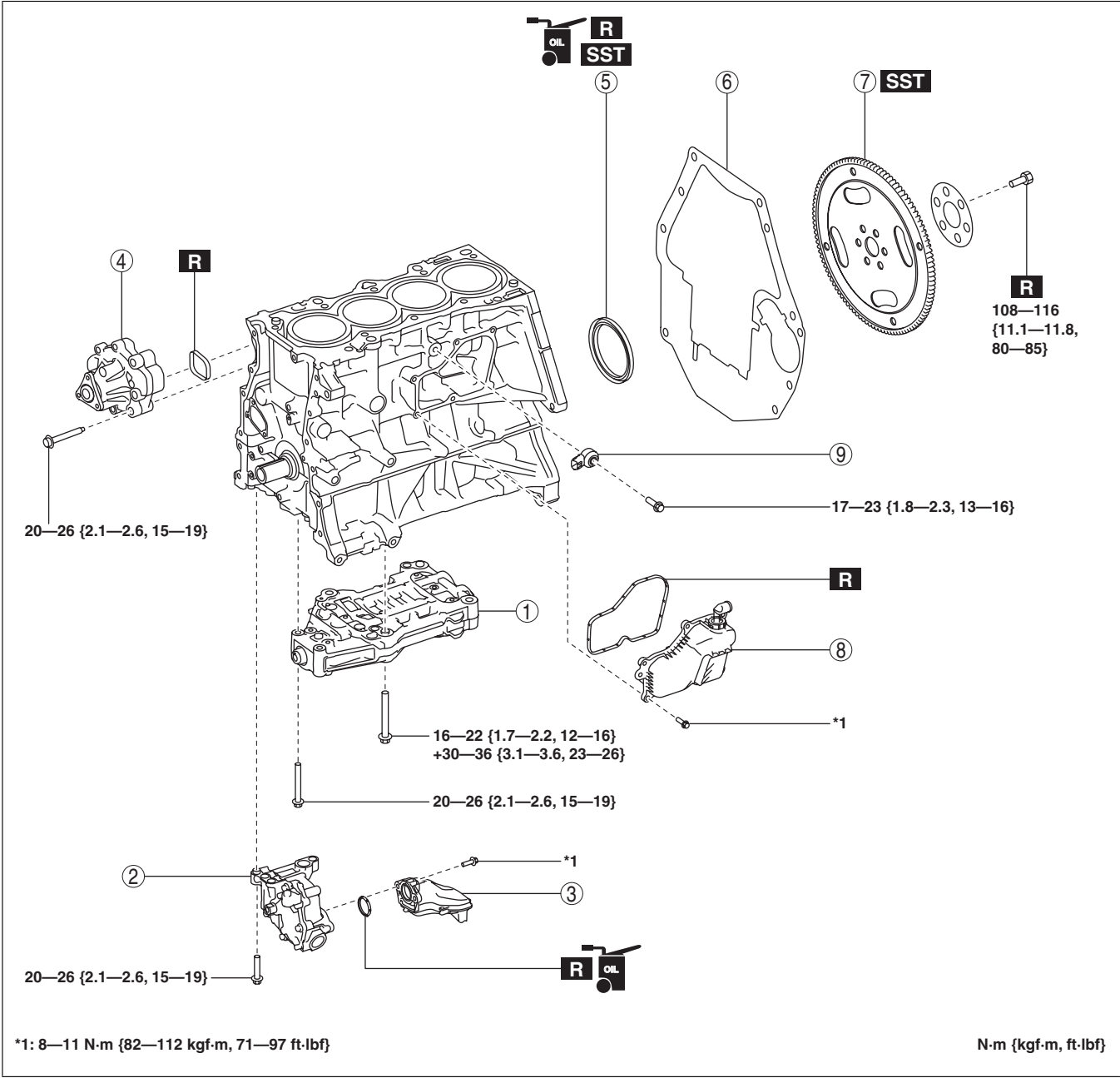
SKYACTIV-G 2.0



1	Oil baffle plate (See Oil Baffle Plate Assembly Note (SKYACTIV-G 2.0).)
2	Oil pump (See Oil Pump Assembly Note.)
3	Oil strainer
4	Water pump (See Water Pump Assembly Note.)
5	Rear oil seal (See Rear Oil Seal Assembly Note.)

6	End plate (See End Plate Assembly Note.)
7	Flywheel (MTX), drive plate (ATX) (See Flywheel (MTX), Drive Plate (ATX) Assembly Note.)
8	Oil separator
9	Knock sensor (KS) (See Knock Sensor (KS) Assembly Note.)

SKYACTIV-G 2.5



1	Balancer unit (See Balancer Unit Assembly Note (SKYACTIV-G 2.5).)
2	Oil pump (See Oil Pump Assembly Note.)
3	Oil strainer
4	Water pump (See Water Pump Assembly Note.)
5	Rear oil seal (See Rear Oil Seal Assembly Note.)

6	End plate (See End Plate Assembly Note.)
7	Flywheel (MTX), drive plate (ATX) (See Flywheel (MTX), Drive Plate (ATX) Assembly Note.)
8	Oil separator
9	Knock sensor (KS) (See Knock Sensor (KS) Assembly Note.)

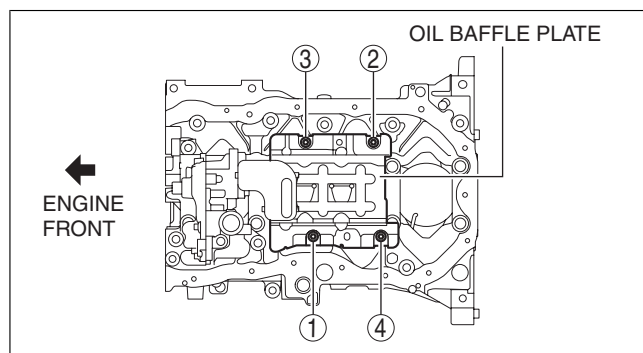
bpe1ze00000050

Oil Baffle Plate Assembly Note (SKYACTIV-G 2.0)

1. Tighten the bolts in the order shown in the figure.

Tightening torque

8—11 N·m {82—112 kgf·cm, 71—97 in·lbf}

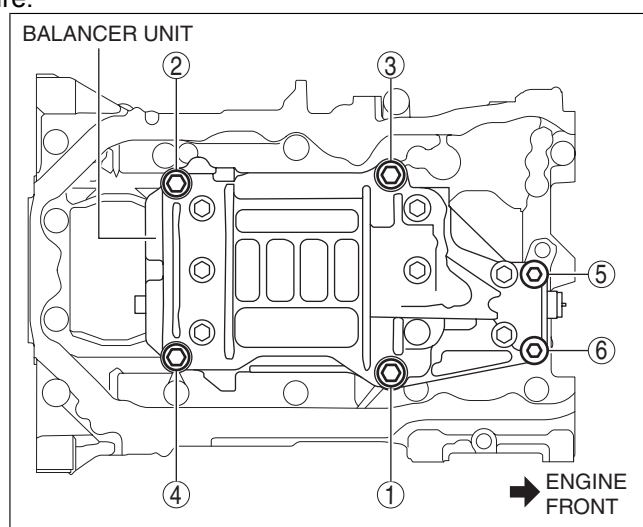


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Balancer Unit Assembly Note (SKYACTIV-G 2.5)

1. Assemble the balancer unit using the following procedure:

- (1) Tighten the bolts in the order shown in the figure.



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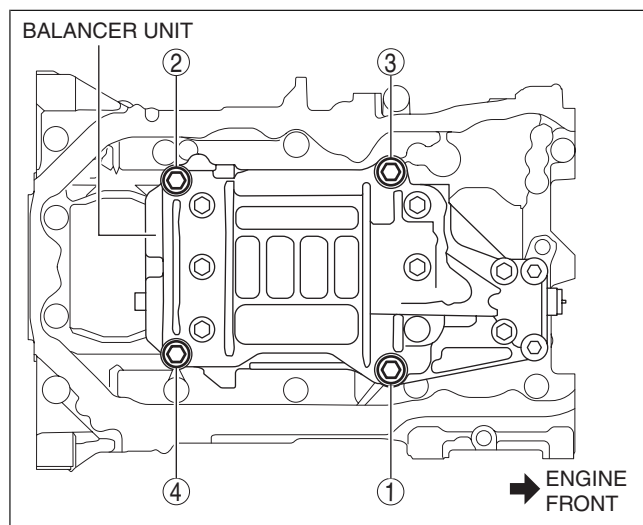
Tightening torque

Installation position	Tightening torque
1—4	16—22 N·m {1.7—2.2 kgf·m, 12—16 ft·lbf}
5, 6	20—26 N·m {2.1—2.6 kgf·m, 15—19 ft·lbf}

- (2) Retighten the bolts in the order of the numbers indicated in the figure.

Tightening torque

30—36 N·m {3.1—3.6 kgf·m, 23—26 ft·lbf}

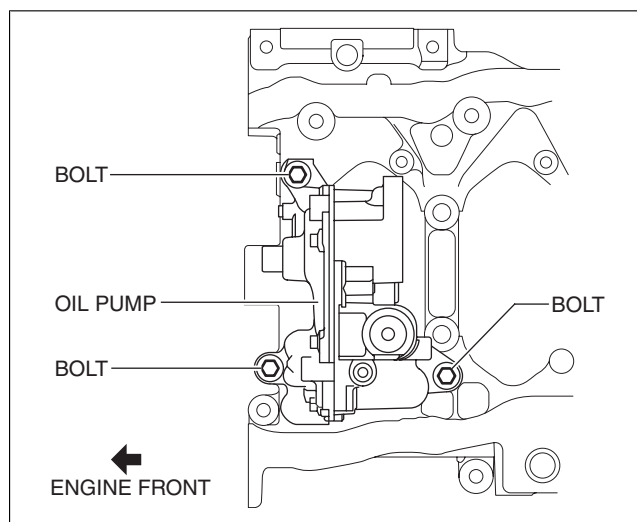


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Oil Pump Assembly Note SKYACTIV-G 2.0

1. Tighten the oil pump using the following procedure:

- (1) Temporarily tighten the **three bolts** shown in the figure.



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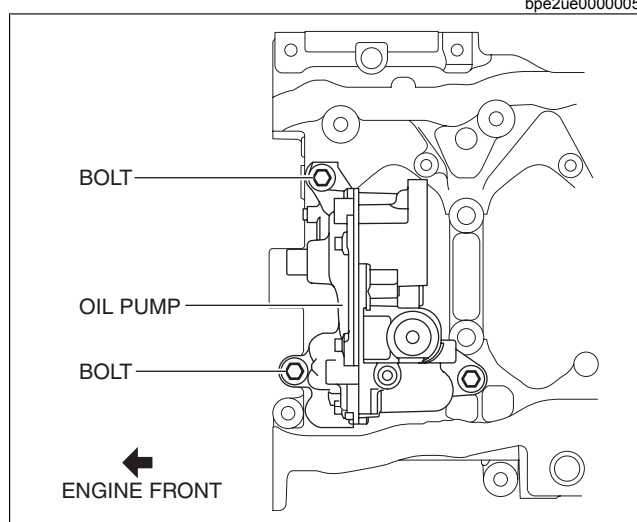
- (2) Tighten the **two bolts** shown in the figure to specified torque.

Note

- The tightening order for the two bolts is optional.

Tightening torque

20—26 N·m {2.1—2.6 kgf·m, 15—19 ft·lbf}

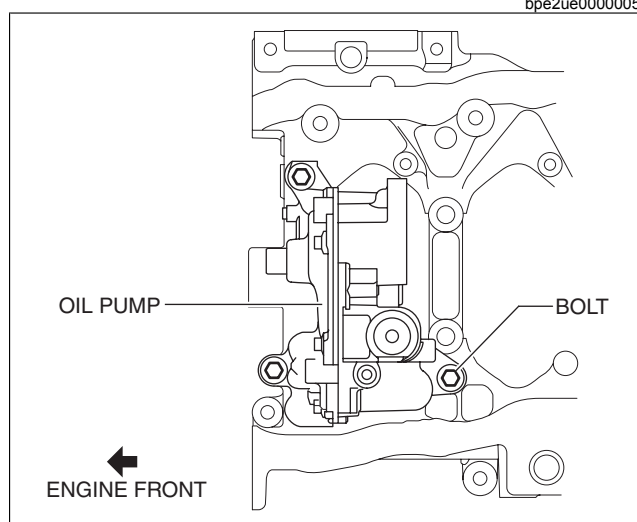


bpe2ue00000051

- (3) Finally, tighten the bolt shown in the figure to the specified torque.

Tightening torque

20—26 N·m {2.1—2.6 kgf·m, 15—19 ft·lbf}

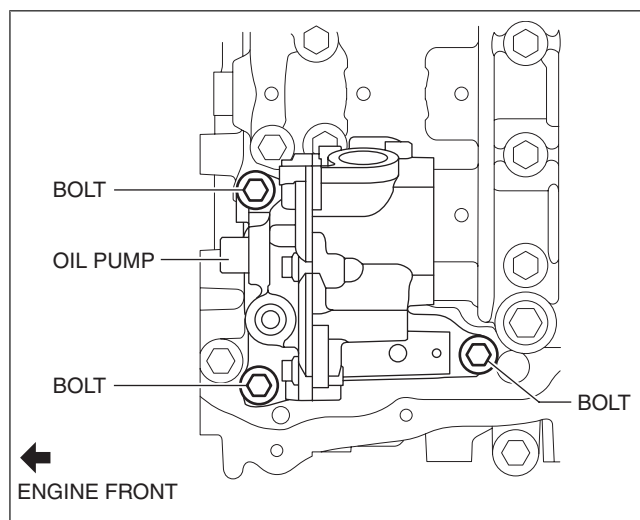


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SKYACTIV-G 2.5

1. Install the oil pump using the following procedure:

- (1) Temporarily tighten the **three bolts** shown in the figure.



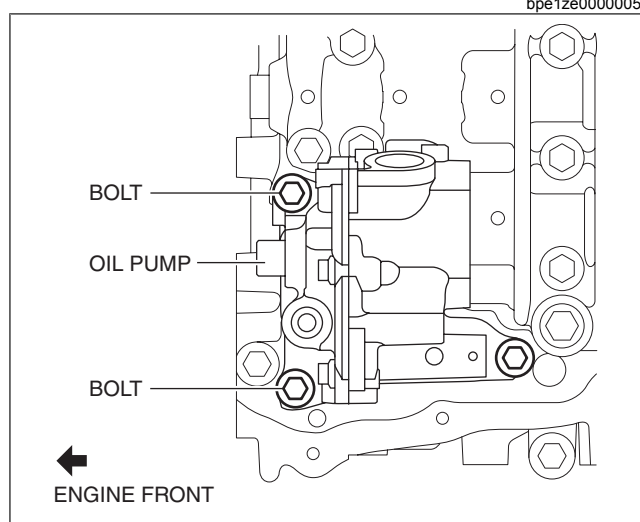
- (2) Tighten the **two bolts** shown in the figure to the specified torque.

Note

- The tightening order for the two bolts is optional.

Tightening torque

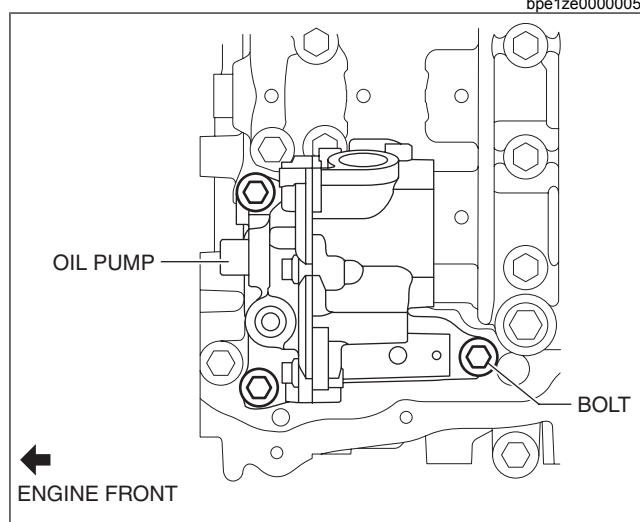
20—26 N·m {2.1—2.6 kgf·m, 15—19 ft·lbf}



- (3) Finally, tighten the bolt shown in the figure to the specified torque.

Tightening torque

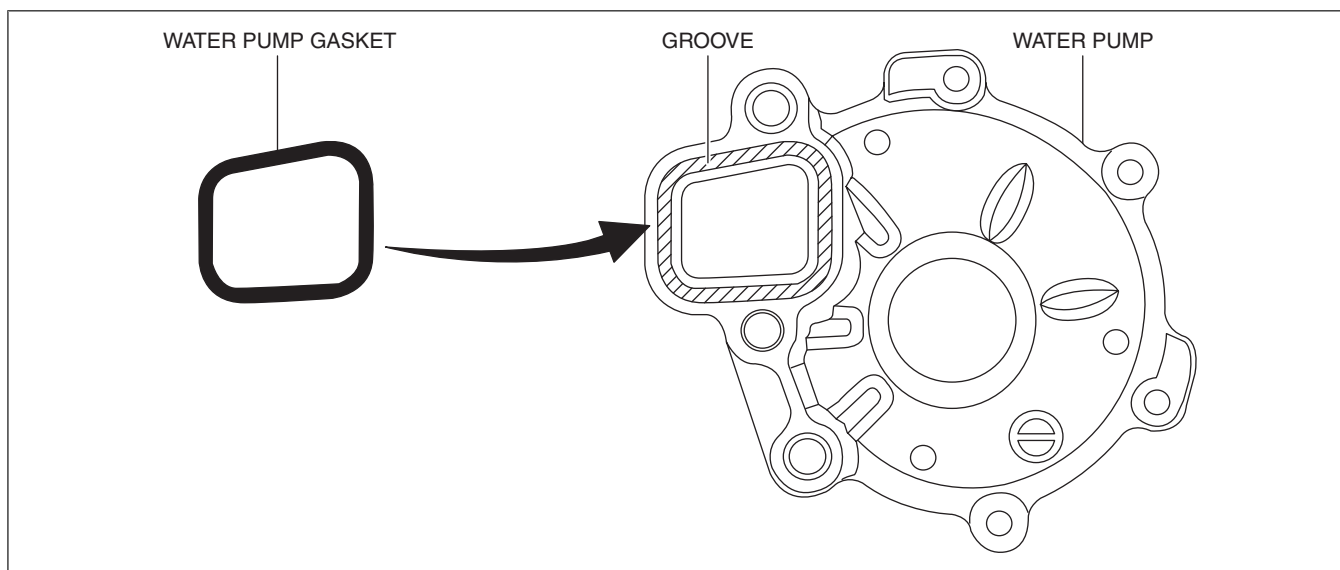
20—26 N·m {2.1—2.6 kgf·m, 15—19 ft·lbf}



Water Pump Assembly Note

Caution

- Assemble the water pump gasket to the correct direction shown in the figure. Otherwise, it could leak engine coolant and damage the engine.

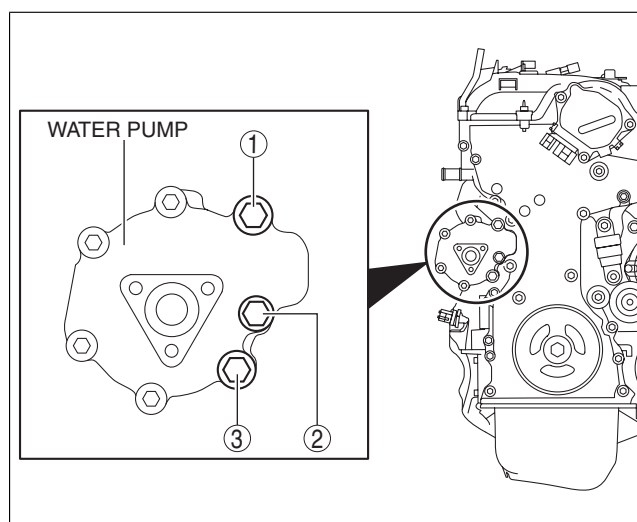


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1. Insert a new water pump gasket into the water pump groove.
2. Install the water pump.
3. Tighten the bolts in the order shown in the figure.

Tightening torque

20—26 N·m {2.1—2.6 kgf·m, 15—19 ft·lbf}

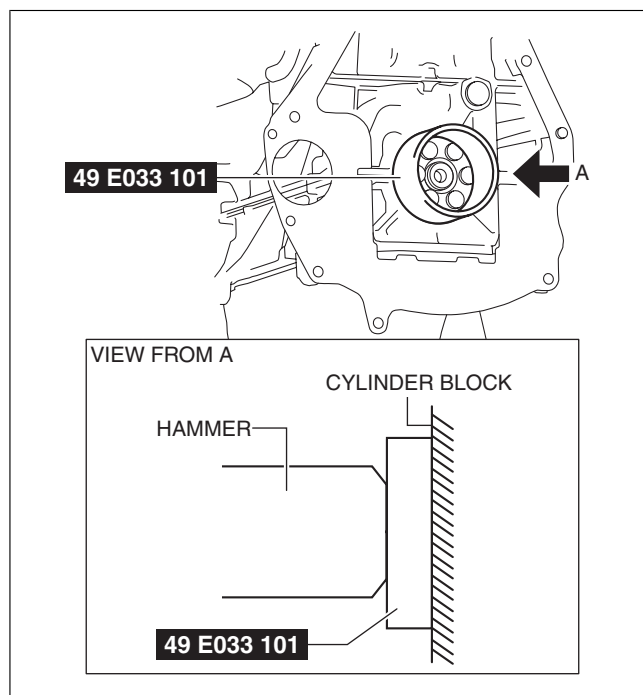


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Rear Oil Seal Assembly Note

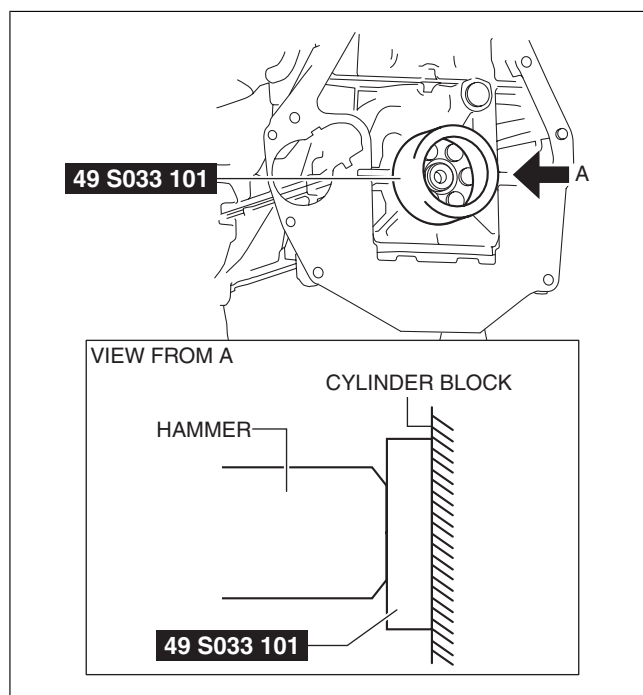
1. Apply clean engine oil to the inner surface of a new rear oil seal.
2. Insert the rear oil seal into the cylinder block by hand.
3. Tap the oil seal in evenly using the **SST** and a hammer.

SKYACTIV-G 2.0



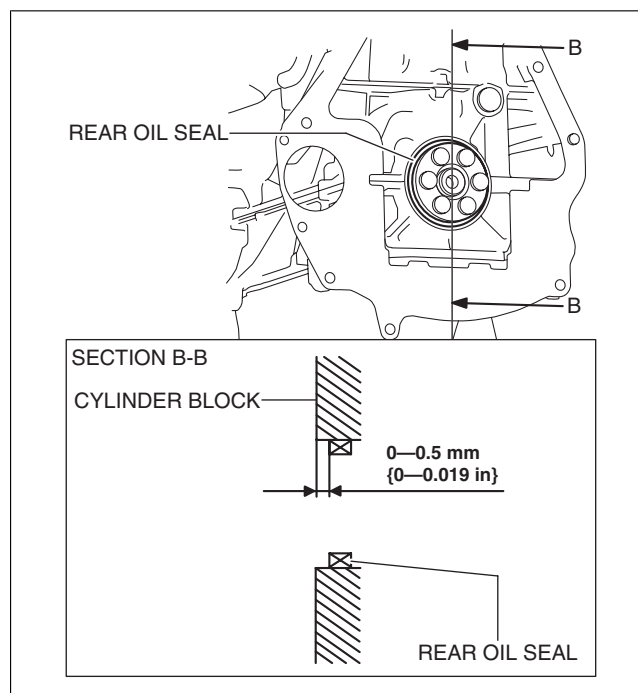
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SKYACTIV-G 2.5



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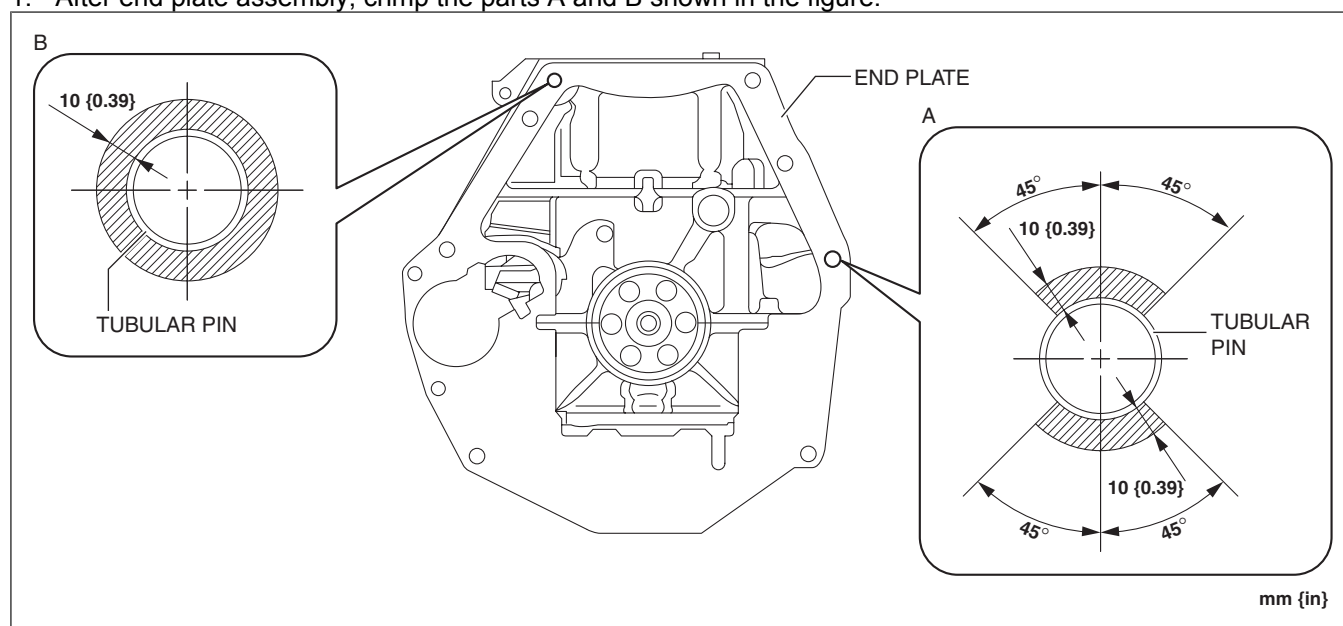
Rear oil seal press-in amount
0—0.5 mm {0—0.019 in}



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End Plate Assembly Note

1. After end plate assembly, crimp the parts A and B shown in the figure.



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Crimp procedure

Crimp depth: 0.1—1.0 mm {0.004—0.039 in}

Crimp width: 0.5—10.0 mm {0.02—0.39 in}

Crimp locations: Part A is 1 or more on one-side within shaded area and part B is 2 or more within shaded areas

2. After crimping, verify that there is no damage and removal of the end plate.

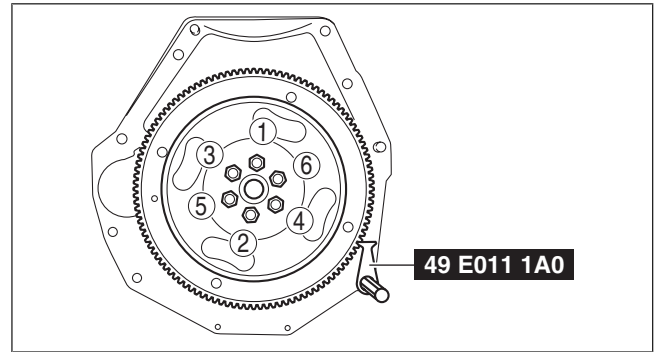
Flywheel (MTX), Drive Plate (ATX) Assembly Note

1. Hold the crankshaft using the **SST**.

2. Tighten the new installation bolts in two or three passes in the order shown in the figure.

Tightening torque

108—116 N·m {11.1—11.8 kgf·m, 80—85 ft·lbf}

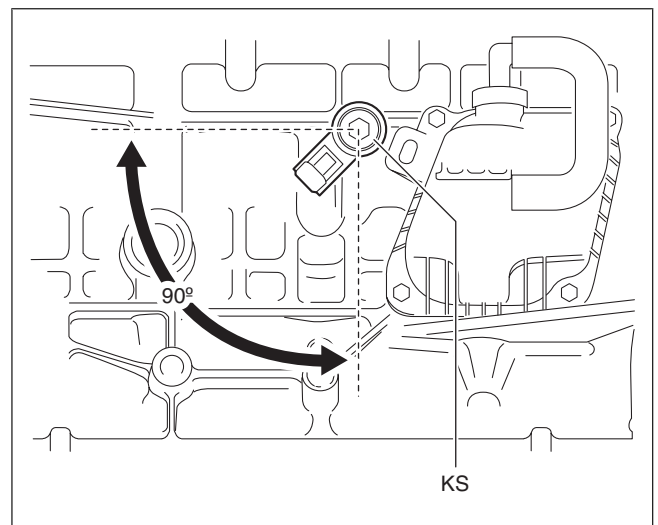


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Knock Sensor (KS) Assembly Note

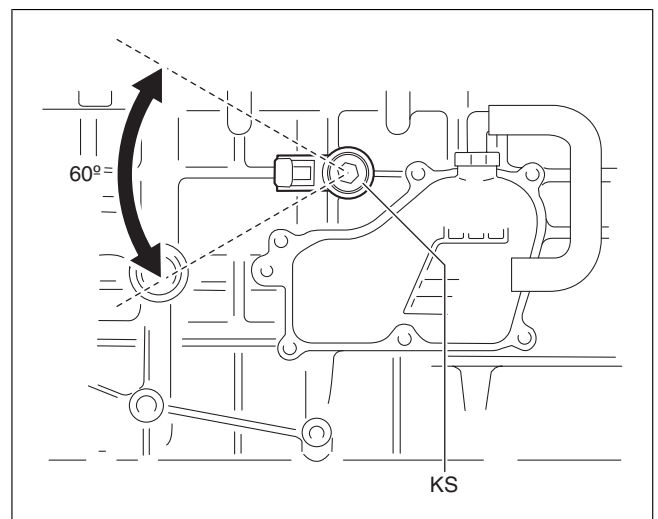
- Verify that there is no foreign matter caught between the KS unit and cylinder block.
- The direction of the knock sensor connector must be within the range shown in the figure.

SKYACTIV-G 2.0



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SKYACTIV-G 2.5



am6zzw00008568