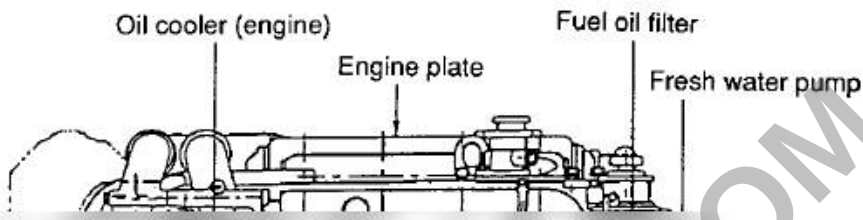
2.2 Appearance and Names of Parts

● **Operation Side** (Right side as viewed from the propeller.) Contains the main parts necessary for operation



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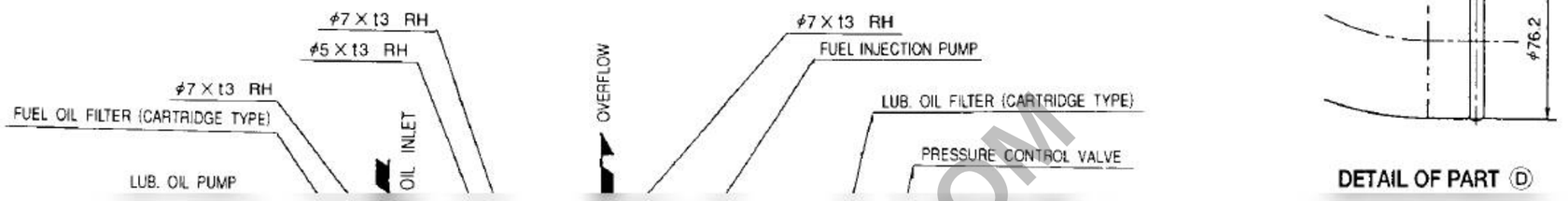
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2.4 Piping Diagram

- 4JH3-TE,

MARKS OF PIPING	NAME
RH	RUBBER HOSE
SGP STS	STEEL PIPE
C1201T	COPPER PIPE
⊣⊢	(UNION) SCREW JOINT



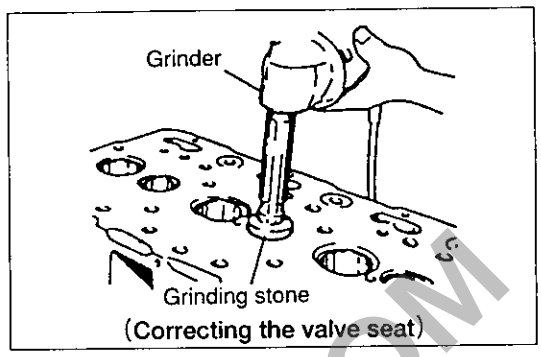
DETAIL OF PART Ⓓ

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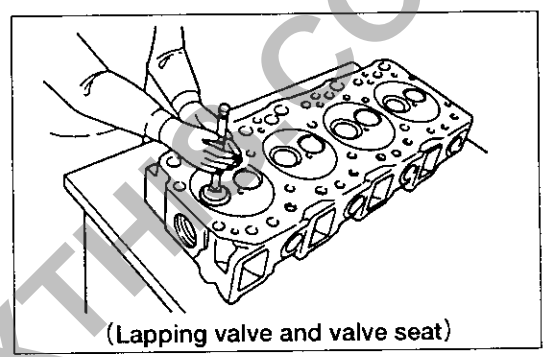
③Knead a valve compound with oil and lap the valve and valve seat using it.
④Tap it with oil only and finish.

[NOTICE]

- **After correcting the valve seat, fully clean the valve and cylinder head with fuel oil until a residual lapping compound or abrasive is removed completely.**
- **For slightly poor smoothness, the steps ③ and ④ will do.**

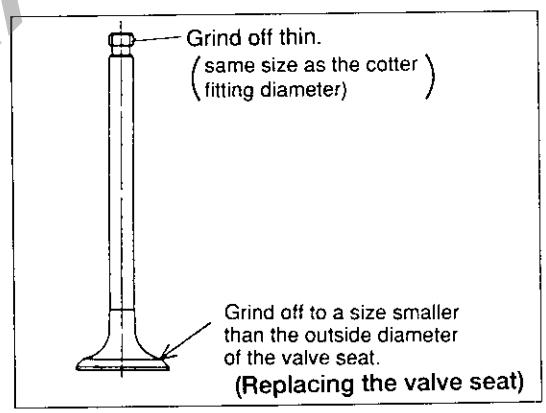


(Correcting the valve seat)

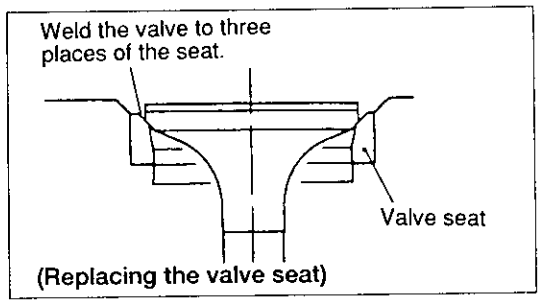

(Lapping valve and valve seat)

⑤Replacing the valve seat
If the valve seat cannot be corrected due to great wear or eccentric wear, replace the valve seat

- Pulling out valve seat
  - ■ Grind off the valve head of a intake/exhaust valve in use or out of service to a size smaller than the outside diameter of the valve seat.
  - ■ Grind off the end of valve stem until its outside diameter is the same as the diameter where the cotter is fitted.
  - ■ Weld three places of the valve head of the intake/exhaust valve to the valve seat.
  - ■ Tap the end of the intake/exhaust valve stem and tap out the valve seat.

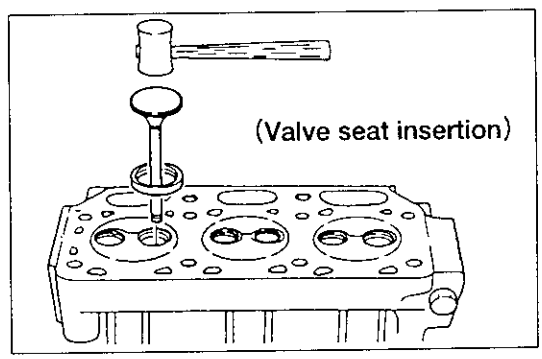


(Replacing the valve seat)



(Replacing the valve seat)

- Inserting a valve seat
  - ■ Put a valve seat in liquid nitrogen to cool it fully. Alternatively, put dry ice in a container filled with ether or alcohol and put the valve seat in the container.
  - ■ Heat the periphery of the valve seat insertion position on the cylinder head to 80 to 100℃ using a dryer.
  - ■ Securely insert the fully cooled valve seat into the cylinder head using a new intake/exhaust valve by tapping the valve head of the intake/exhaust valve.
  - ■ Let the entire cylinder head stand until it cools uniformly to the surrounding temperature.


(Valve seat insertion)

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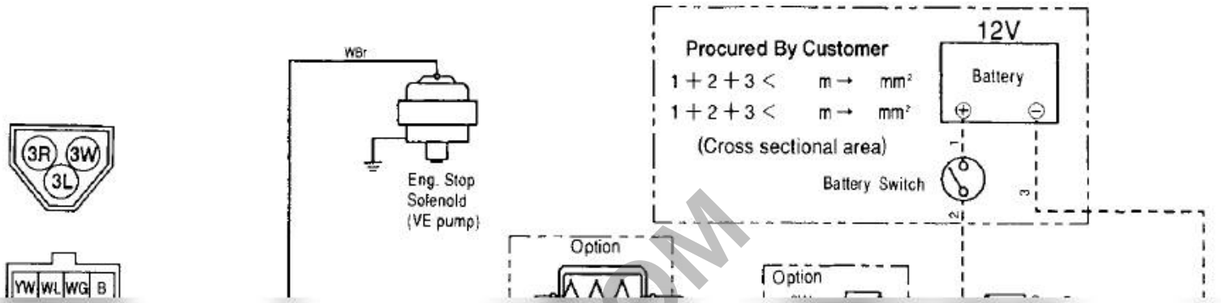
3.3.11 Electrical Equipment

(1) Wiring Diagram

- 4JH3-TE, HTE, DTE (12V New B type)

Color coding

R	Red
B	Black
W	White
Y	Yellow
L	Blue



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4. Troubleshooting

Note: Since fuel injection pump disassembly and adjustment requires special knowledge and equipment, please contact ZEXEL service shop for the job.

4.1 Does not Start or Difficult to Start

action	(I-1) Tighten. (I-2) Correct with sandpaper or replace. (I-3) Replace. (I-4) Correct with sandpaper	(II-1) Tighten. (II-2) Correct with sandpaper (II-3) Replace. (II-4) Correct with sandpaper # 500 to #600.	(III-1) Carry out sufficient priming. (III-2) Readjust. (III-3) Replace with a new part. (III-4) Add fuel to the tank.	(IV-1) Replace with a new part. (IV-2) Replace with a new part. (IV-3) Replace with a new part. (IV-4) Replace with a new part. (IV-5) Readjust.

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7. Service Specifications

7.1 Engine Adjusting Standards

①Engine

Item	Unit	4JH3-TE	4JH3-HTE,DTE	Remarks
Top clearance	mm	0.8±0.09		
Valve clearance	mm	0.2±0.05		Cold

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7.2 Service Standards

①Cylinder head

● Cylinder head

Check item			Standard	Limit	Reference
Combustion surface distortion		(mm)	0.05 or less	0.15	3.3.1(1)
Valve sink	(mm)	Intake	0.4±0.1	1.5	3.3.1(3)

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⑦Lubricating oil pump

Check item		Standard	Limit	Reference
Clearance between driven rotor and pump casing	(mm)	0.10~0.17	0.25	3.3.8(2)
Clearance between driven rotor and drive rotor	(mm)	0.05~0.11	0.15	
Rotor side clearane	(mm)	0.03~0.09	0.13	

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