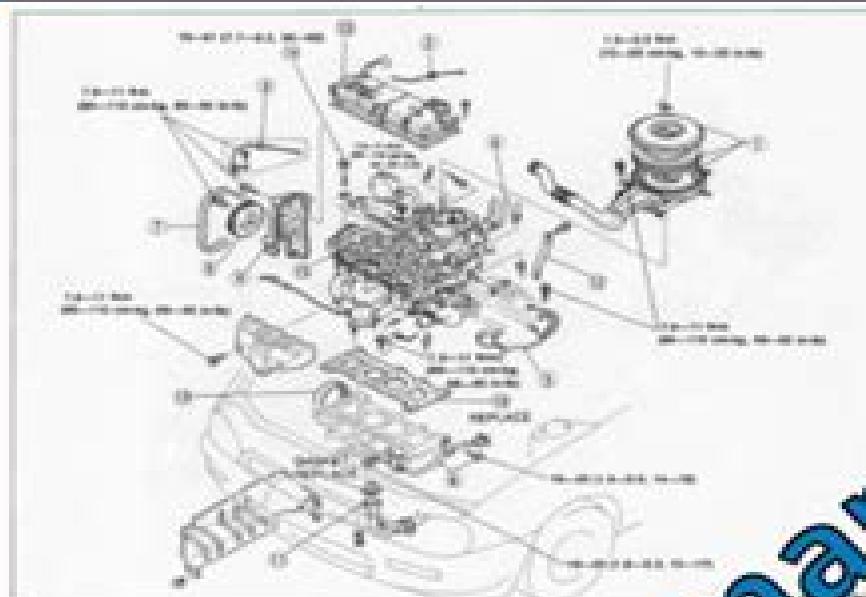


Mazda 121 Workshop Manual 1990-1998



| | |
|---|-----------|
| 1. Oil cleaner assembly | page B-20 |
| 2. Adjustment cable Installation Notes | page B-20 |
| 3. Throttle cable | |
| 4. Power | |
| 5. Removal / Installation Notes | page B-19 |
| 6. Power | |
| 7. Removal / Installation Notes | page B-19 |
| 8. Water bypass pipe nuts and bolts | |
| 9. Adjustment drive belt | |
| 10. Water pump pulley | |
| 11. Timing belt cover, lower Torque Specifications | page B-72 |
| CYLINDER BLOCK (EXTERNAL, PLATES) | |
| Torque Specifications | |



1. Before installing the cylinder block, measure the oil clearance as follows.
2. Oil clearance Inspection
(1) Remove the cylinder block.
3. Measure the present oil clearance with a dial caliper. If the present oil clearance is greater than the maximum oil clearance, replace the cylinder block.
- Caution:
 - Do not rotate the cylinder block.
4. Position the bearing cap with the journal in the same direction.
5. Install the lower main bearing and the main bearing cap according to the cap number and in order.
6. Tighten the main bearing cap bolts in two or three steps in the order shown in the figure.
7. Remove the main bearing cap, and measure the Photo paper at each journal at the center point for the shafted clearance and at the highest point for the largest clearance.
8. If the oil clearance exceeds specification, press the cylinder block and use cylinder main bearings.
(Refer to page B-363.)
- Oil clearance: 0.016–0.030mm (0.0007–0.0014 in)
Maximum: 0.16mm (0.006 in)
9. Apply a liberal amount of clean engine oil to the main bearing cap, main bearing, and main journals.
10. Install the cylinder block and the main bearing cap according to the cap number and in order.

11. Tighten the main bearing cap bolts in two or three steps in the order shown in the figure.

Tightening torque:
50–60 Nm (3.6–4.2 kgf-m, 45–48 lbf-in)

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Table of Contents 97 Mazda 121 Service Manual

1. Understanding the eBook 97 Mazda 121 Service Manual
 - The Rise of Digital Reading 97 Mazda 121 Service Manual
 - Advantages of eBooks Over Traditional Books
2. Identifying 97 Mazda 121 Service Manual
 - Exploring Different Genres
 - Considering Fiction vs. Non-Fiction
 - Determining Your Reading Goals
3. Choosing the Right eBook Platform
 - Popular eBook Platforms
 - Features to Look for in an 97 Mazda 121 Service Manual
 - User-Friendly Interface
4. Exploring eBook Recommendations from 97 Mazda 121 Service Manual
 - Personalized Recommendations
 - 97 Mazda 121 Service Manual User Reviews and Ratings
 - 97 Mazda 121 Service Manual and Bestseller Lists

5. Accessing 97 Mazda 121 Service Manual Free and Paid eBooks
 - 97 Mazda 121 Service Manual Public Domain eBooks
 - 97 Mazda 121 Service Manual eBook Subscription Services
 - 97 Mazda 121 Service Manual Budget-Friendly Options
6. Navigating 97 Mazda 121 Service Manual eBook Formats
 - ePUB, PDF, MOBI, and More
 - 97 Mazda 121 Service Manual Compatibility with Devices
 - 97 Mazda 121 Service Manual Enhanced eBook Features
7. Enhancing Your Reading Experience
 - Adjustable Fonts and Text Sizes of 97 Mazda 121 Service Manual
 - Highlighting and Note-Taking 97 Mazda 121 Service Manual
 - Interactive Elements 97 Mazda 121 Service Manual
8. Staying Engaged with 97 Mazda 121 Service Manual
 - Joining Online Reading Communities
 - Participating in Virtual Book Clubs
 - Following Authors and Publishers 97 Mazda 121 Service Manual
9. Balancing eBooks and Physical Books 97 Mazda 121 Service Manual
 - Benefits of a Digital Library
 - Creating a Diverse Reading Collection 97 Mazda 121 Service Manual
10. Overcoming Reading Challenges
 - Dealing with Digital Eye Strain
 - Minimizing Distractions
 - Managing Screen Time
11. Cultivating a Reading Routine 97 Mazda 121 Service Manual
 - Setting Reading Goals 97 Mazda 121 Service Manual
 - Carving Out Dedicated Reading Time
12. Sourcing Reliable Information of 97 Mazda 121 Service Manual
 - Fact-Checking eBook Content of 97 Mazda 121 Service Manual
 - Distinguishing Credible Sources
13. Promoting Lifelong Learning

- Utilizing eBooks for Skill Development
 - Exploring Educational eBooks
14. Embracing eBook Trends
- Integration of Multimedia Elements
 - Interactive and Gamified eBooks

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