



**SERVICE BULLETIN**

**APPLICABILITY:** 1999~04MY Forester 2.5L SOHC N/A,  
1999~04MY Impreza 2.5L SOHC N/A,  
2000~04MY Legacy 2.5L SOHC N/A  
(Except 2004MY Legacy U5 Specification  
Vehicles)  
2003~06MY Baja 2.5L SOHC N/A

**NUMBER:** 02-94-05R  
**DATE:** 12/01/06

**SUBJECT:** Revised Cylinder Block Specifications

**INTRODUCTION**

This service bulletin is to inform you that Fuji Heavy Industries, Ltd. (FHI) has revised the maximum bore diameter and the out of roundness limits of the cylinder bore. In conjunction with this, they have also released 60-micrometer (0.0024”) oversized pistons.

**AFFECTED VEHICLES AND PARTS INFORMATION**

YEAR	ENGINE TYPE	MODEL	OVERSIZE PISTON PART NUMBER	GRADE
1999	2.5L SOHC N/A	Impreza/Forester	12006AC930	A
			12006AC940	B
2000~04	2.5L SOHC N/A	All	12006AC910	A
			12006AC920	B
2003~06	2.5L SOHC N/A	Baja	12006AC910	A
			12006AC920	B
RING SET FOR 2 PISTONS			12033AB880	
GASKET SET FOR REPLACING ONE SIDE ONLY			10104AA040	

**REPAIR PROCEDURES/INFORMATION**

When engine disassembly for repair is necessary the revised specifications must be used. The revised maximum bore diameter and the out of roundness limits of the cylinder bore are:

Maximum Bore Diameter	Out of Roundness Limit
“A” = 3.9207”	0.0028”
“B” = 3.9203”	

*continued...*



**CAUTION: VEHICLE SERVICING PERFORMED BY UNTRAINED PERSONS COULD RESULT IN SERIOUS INJURY TO THOSE PERSONS OR TO OTHERS.**

Subaru Service Bulletins are intended for use by professional technicians ONLY. They are written to inform those technicians of conditions that may occur in some vehicles, or to provide information that could assist in the proper servicing of the vehicle. Properly trained technicians have the equipment, tools, safety instructions, and know-how to do the job correctly and safely. If a condition is described, DO NOT assume that this Service Bulletin applies to your vehicle, or that your vehicle will have that condition.



Refer to the appropriate service manual for the measuring process.

*Note: Slight scuffing/scoring or discoloration to the cylinder bore is normal and should not result in an engine block replacement.*

During reassembly if the OE piston to cylinder bore clearance is found to be excessive the pistons listed in this bulletin should be used to obtain the correct clearance.

## **CLAIM REIMBURSEMENT/WARRANTY INFORMATION**

For vehicles within the Basic New Car or Powertrain Limited Warranty, refer to the Subaru Warranty Wizard<sup>®</sup> for claim submission information. All engine measurements must be noted on the repair order.