



Fig. 4
Crankshaft Assembly

- b) Check the fit of the idler gear and shaft to specifications.
- c) Check the condition of the idler gear shaft ball thrust.

3. INSTALLATION

- a) Fit a crank shaft gear bolts to thrust and balls to specified torque.
- b) Assemble the idler gear and shaft, install it in the crankcase ensuring that the double marks on the idler gear line up with the double marks on the crankshaft spin-on. Tighten the bolts to the specified torque.
- c) Install the crankshaft and crankshaft gear and bolt to per spec. torque.
- d) Install the injection pump gear ensuring that the double marking on the injection pump gear is in register with the angle marking on the idler gear, install the three bolts and tighten to the correct torque.
- e) Install the front cover assembly using liquid sealant (Loctite or equivalent).

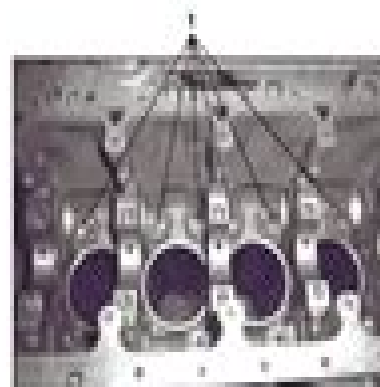


Fig. 5

B. CAMSHAFT

1. REMOVAL

NOTE



1. Before camshaft removal check

- a. Balance of crankshaft drive gear
- b. Crankshaft and fuel
- c. Cam lobe lift

2. Cam lobe lift may be checked by means of a dial indicator.

Reef the style of the dial indicator to the push rods.

Rotate the engine over until the indicator reading is 0 (zero) (Specifications).

- a) Remove the oil pump as detailed in CHAPTER 4, para 5.
- b) Lift out the valve gear so they can be installed in their original positions.
- c) Remove the crankcase front cover as detailed in para 8-1.
- d) Remove the oil pump as detailed in CHAPTER 4.
- e) Loosen the engine then turn the camshaft until the core holes in the gear line up with the bolts (3-5) (4-6) securing the camshaft front plate then remove the bolts and lockwashers.
- f) Withdraw the camshaft with gear from the crankcase.
- g) Remove the valve tappets (1-7) and identify them so they can be installed in their original positions.

2. DISMANTLING

- a) Remove bolt (1-6) and washer, press out the camshaft out of gear then remove the key and thrust plate from the camshaft.

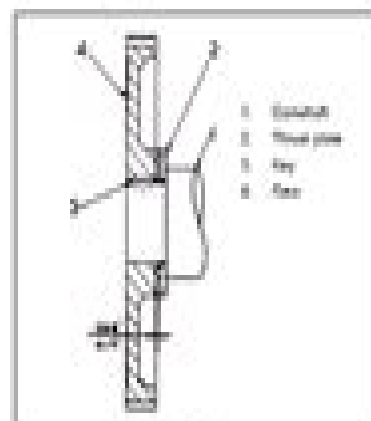


Fig. 6

3. INSPECTION AND REPAIR

- a) Inspect the cam lobes and camshaft journals against the dimensions given in specifications. If inspection proves it necessary, remove the camshaft bearing as detailed in para. 8-1.
- b) Inspect the cam lobe and camshaft journals against the dimensions given in specifications. If inspection proves it necessary, remove the camshaft bearing as detailed in para. 8-1.
- c) Inspect the valve tappets for wear to specifications.

4. ASSEMBLY

- a) Install the thrust plate on the camshaft.
 - b) Fit a new key to the camshaft then press in the camshaft gear to leave a clearance of 0.005-0.017 inch between the gear hub rear face and the thrust plate. Ensure that the thrust plate is located against its abutment shoulder when checking this clearance (Fig. 6). Tighten with washer (2-6) and bolt (1-6) to correct torque.
 - c) Turn the engine on its side or bottom side (B).
- Lubricate valve tappets and camshaft with engine oil and install into the crankcase.



Fig. 7
1. Camshaft

5. INSTALLATION

- a) Install the valve tappets in their original positions.
- b) Coat the camshaft and camshaft bearings with clean engine oil.
- c) Install the camshaft in the crankcase taking care not to damage the bearings and engage the camshaft gear with the crankshaft gear ensuring that the angle timing marks are in register.
- d) Secure the thrust plate to the crankcase with the bolts and lockwashers and tighten the bolts to the specified torque.
- e) Install the oil pump as detailed in chapter 4 para 5.
- f) Install the front cover as detailed in para 8-1.
- g) Install the valve push rods in their original positions.
- h) Install the valve rocker arm shaft assembly as detailed in chapter 2 (a).

6. CAMSHAFT BEARING

1. REMOVAL

- a) Remove the camshaft as details in para 4.
- b) Remove the flywheel as detailed in CHAPTER 8, para 8.
- c) Use a long bar from the front of the crankcase and drive off the separation plug (1-7).
- d) Remove the camshaft bearings (2, 3 & 4-6) from the crankcase.

2. INSTALLATION

- a) Press the camshaft bearing into position aligning the hole in the bearing with the hole in the crankcase.

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web discussion as it is impossible to cover the 5 core tools in a short chapter for more information consult the aiag reference manuals on these 5 tools the 5 core tools are a apap b fmea c spc d msa e ppap control plan is considered part of apap the 5 core tools are not neatly discussed in the standard but mentioned here and there

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