



5. Crankshaft Bearing Cap

- 1) Lubricate the bearing cap bolts with engine oil.
- 2) Install the bearing caps to the crankshaft.
The arrow mark must be pointing to the front of the engine.
- 3) Tighten the bearing cap bolts to the specified torque a little at a time in the numerical order shown in the illustration.



Crankshaft Bearing Cap Bolt Torque

kg-m(lb.ft)
 24.0 ± 1 (173.5 \pm 7.2)

- 4) Check that the crankshaft turns smoothly by manually rotating it.



6. Timing Gear Case

- 1) Apply liquid gasket to the timing gear case surfaces contacting the cylinder body.
- 2) Tighten the timing gear case bolts to the specified torque.

Timing Gear Case Bolt Torque

kg-m(lb.ft)
 2.6 ± 0.5 (18.8 \pm 3.6)



8. Camshaft

- Tighten the thrust plate bolts through the camshaft gear hole.

Thrust Plate Bolt Torque

kg-m(lb.ft)
 2.6 ± 0.5 (18.8 \pm 3.6)

Camshaft Gear Bolt Torque

kg-m(lb.ft)
 16 ± 1.5 (115.7 \pm 10.5)



9. Idler Gear Shaft

- Use the thrust collar fixing bolt as a guide to install the idler gear shaft.
The oil port must be facing the camshaft.

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A Gutmann



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