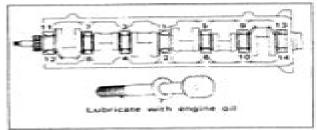




- 5. Crankshaft Bearing Cap
 - 1) Lubricate the bearing cap bolts with engine oil.
 - Install the bearing caps to the crankshaft.

The arrow mark must be pointing to the front of the engine.

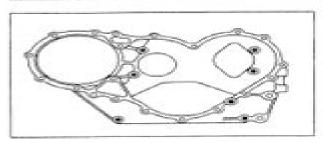
 Tighten the bearing cap bolts to the specified torque a little at a time in the numerical order shown in the illustration.





	kg-m@b.f
Crankshaft Bearing Cap Bolt Torque	24.0 ± 1 (173.5 ± 7.2)

 Check that the crankshaft turns smoothly by manually rotating it.



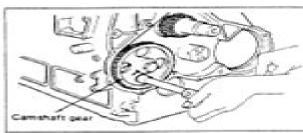


6. Timing Gear Case

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

kg-m(lb.ft)

Timing Gear Case Bolt Torque



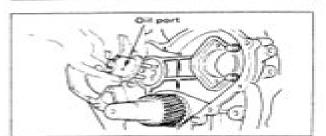


8. Camshaft

Tighten the thrust plate bolts through the camshaft gear hole.

	kg-m(lb.ft
Thrust Plate Bolt Torque	2.6 ± 0.5 (18.8 ± 3.6)

	kg-m(ib.ft
Camshaft Gear Bolt Torque	16 ± 1.5 (115.7 ± 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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Table of Contents Isuzu Engine 4bb1 Workshop Manual

- 1. Understanding the eBook Isuzu Engine 4bb1 Workshop Manual
 - The Rise of Digital Reading Isuzu Engine 4bb1 Workshop Manual
 - Advantages of eBooks Over Traditional Books
- 2. Identifying Isuzu Engine 4bb1 Workshop 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 Isuzu Engine 4bb1 Workshop Manual
 - User-Friendly Interface
- 4. Exploring eBook Recommendations from Isuzu Engine 4bb1 Workshop Manual
 - Personalized Recommendations
 - Isuzu Engine 4bb1 Workshop Manual User Reviews and Ratings
 - o Isuzu Engine 4bb1 Workshop Manual and Bestseller Lists
- 5. Accessing Isuzu Engine 4bb1 Workshop Manual Free and Paid eBooks
 - Isuzu Engine 4bb1 Workshop Manual Public Domain eBooks
 - Isuzu Engine 4bb1 Workshop Manual eBook Subscription Services
 - o Isuzu Engine 4bb1 Workshop Manual Budget-Friendly Options
- 6. Navigating Isuzu Engine 4bb1 Workshop Manual eBook Formats
 - o ePub, PDF, MOBI, and More
 - Isuzu Engine 4bb1 Workshop Manual Compatibility with Devices
 - Isuzu Engine 4bb1 Workshop Manual Enhanced eBook Features
- 7. Enhancing Your Reading Experience
 - o Adjustable Fonts and Text Sizes of Isuzu Engine 4bb1 Workshop Manual
 - Highlighting and Note-Taking Isuzu Engine 4bb1 Workshop Manual
 - o Interactive Elements Isuzu Engine 4bb1 Workshop Manual
- 8. Staying Engaged with Isuzu Engine 4bb1 Workshop Manual

- Joining Online Reading Communities
- Participating in Virtual Book Clubs
- Following Authors and Publishers Isuzu Engine 4bb1 Workshop Manual
- 9. Balancing eBooks and Physical Books Isuzu Engine 4bb1 Workshop Manual
 - Benefits of a Digital Library
 - Creating a Diverse Reading Collection Isuzu Engine 4bb1 Workshop Manual
- 10. Overcoming Reading Challenges
 - Dealing with Digital Eye Strain
 - Minimizing Distractions
 - Managing Screen Time
- 11. Cultivating a Reading Routine Isuzu Engine 4bb1 Workshop Manual
 - Setting Reading Goals Isuzu Engine 4bb1 Workshop Manual
 - Carving Out Dedicated Reading Time
- 12. Sourcing Reliable Information of Isuzu Engine 4bb1 Workshop Manual
 - Fact-Checking eBook Content of Isuzu Engine 4bb1 Workshop Manual
 - Distinguishing Credible Sources
- 13. Promoting Lifelong Learning
 - Utilizing eBooks for Skill Development
 - Exploring Educational eBooks
- 14. Embracing eBook Trends
 - $\circ \ \ Integration \ of \ Multimedia \ Elements$
 - Interactive and Gamified eBooks

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