



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 single 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).

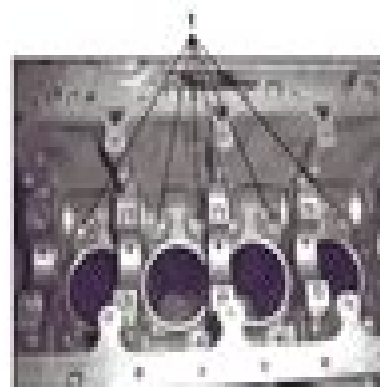


Fig. 5

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 gear.

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

Rotate the engine one revolution and the indicator reading. Check the reading to 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 5-1.
- 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.

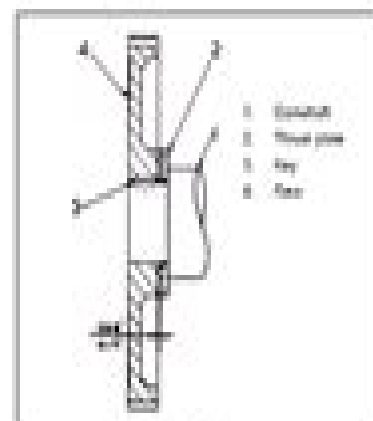


Fig. 6

3. INSPECTION AND REPAIR

- a) Inspect the cam lobes and camshaft journals for wear and scoring. Check the clearance between cam lobes and push rods against the camshaft journal. If the clearance is excessive, the camshaft does not exceed the specified clearance. If the clearance is excessive, replace the camshaft gear and thrust plate for the camshaft. If the clearance is excessive, replace the camshaft gear and thrust plate for the camshaft. If the clearance is excessive, replace the camshaft gear and thrust plate for the camshaft.
- b) 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 single 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 5B.
- 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 4b.
- b) Remove the flywheel as detailed in CHAPTER 5, para 5.
- 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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Table of Contents Mahindra 550service Manual

1. Understanding the eBook Mahindra 550service Manual
 - The Rise of Digital Reading Mahindra 550service Manual
 - Advantages of eBooks Over Traditional Books
2. Identifying Mahindra 550service 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 Mahindra 550service Manual
 - User-Friendly Interface
4. Exploring eBook Recommendations from Mahindra 550service Manual
 - Personalized Recommendations
 - Mahindra 550service Manual User Reviews and Ratings
 - Mahindra 550service Manual and Bestseller Lists

5. Accessing Mahindra 550service Manual Free and Paid eBooks
 - Mahindra 550service Manual Public Domain eBooks
 - Mahindra 550service Manual eBook Subscription Services
 - Mahindra 550service Manual Budget-Friendly Options
6. Navigating Mahindra 550service Manual eBook Formats
 - ePub, PDF, MOBI, and More
 - Mahindra 550service Manual Compatibility with Devices
 - Mahindra 550service Manual Enhanced eBook Features
7. Enhancing Your Reading Experience
 - Adjustable Fonts and Text Sizes of Mahindra 550service Manual
 - Highlighting and Note-Taking Mahindra 550service Manual
 - Interactive Elements Mahindra 550service Manual
8. Staying Engaged with Mahindra 550service Manual
 - Joining Online Reading Communities
 - Participating in Virtual Book Clubs
 - Following Authors and Publishers Mahindra 550service Manual
9. Balancing eBooks and Physical Books Mahindra 550service Manual
 - Benefits of a Digital Library
 - Creating a Diverse Reading Collection Mahindra 550service Manual
10. Overcoming Reading Challenges
 - Dealing with Digital Eye Strain
 - Minimizing Distractions
 - Managing Screen Time
11. Cultivating a Reading Routine Mahindra 550service Manual
 - Setting Reading Goals Mahindra 550service Manual
 - Carving Out Dedicated Reading Time
12. Sourcing Reliable Information of Mahindra 550service Manual
 - Fact-Checking eBook Content of Mahindra 550service 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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