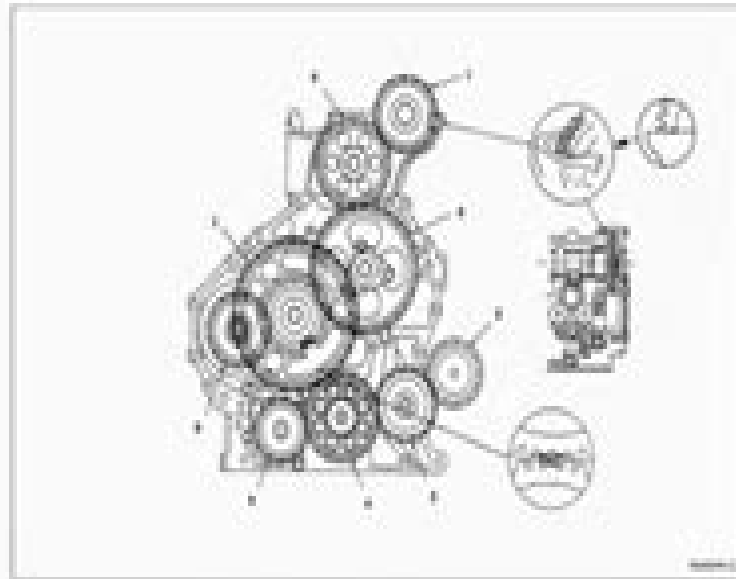


Align Gear Position for Each Gear

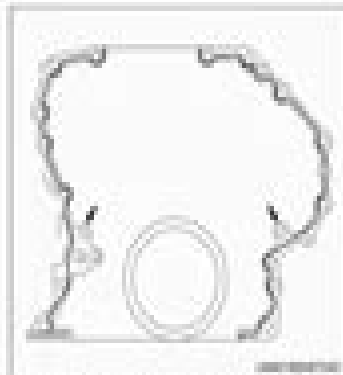


Legend

- | | |
|----------------------------------|------------------------|
| 1. Crankshaft gear | 6. Injection pump gear |
| 2. Power steering pump gear | 7. Idle gear A |
| 3. Power steering pump idle gear | 8. Idle gear B |
| 4. Camshaft gear | 9. Idle gear C |
| 5. Oil pump drive | |

4. Tighten Housing

- 1) Carefully wipe any foreign material from the cylinder block top face.
- 2) As shown in the diagram, uniformly apply liquid gasket (Permatex® 12076) to the inside of the bolt hole surrounding the top face of the cover.



- 3) Align the cylinder block main pins with the flywheel housing bolt pin holes.

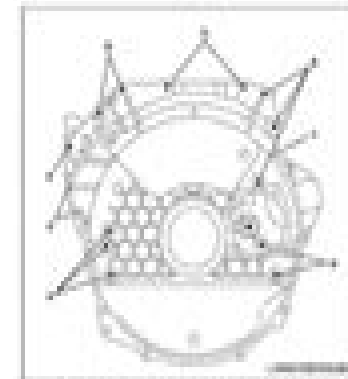
1B-110 Engine Mechanical (BHC1)

- 4) Tighten the flywheel housing bolts to the specified torque shown in the illustration.

Tighten

Flywheel housing bolt to

- (a) 36 Nm (26.5 kg-m/19.4 ft-lb)
- (b) 20 Nm (14.8 kg-m/10.9 ft-lb)
- (c) 36 Nm (26.5 kg-m/19.4 ft-lb)
- (d) 48 Nm (35.0 kg-m/25.8 ft-lb)
- (e) 48 Nm (35.0 kg-m/25.8 ft-lb)
- (f) 48 Nm (35.0 kg-m/25.8 ft-lb)



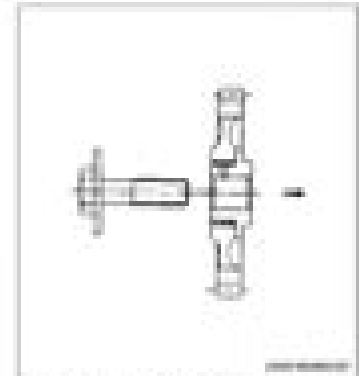
- Tighten the bolts marked with "1" from the injection pump side, and those with "2" from the cylinder block side.

5. Power Steering Pump Idle Gear

- 1) Apply the engine oil to the idle gear shaft.
- 2) Install the idle gear shaft (1) with the idle gear (2) to the cylinder block portion as shown in the illustration.

Tighten

Idle gear shaft bolt to 1.54 Nm (11.0 kg-cm/8.4 in-lb)



3. Power steering Pump idle Gear Cover
Install the gear cover with the O-ring.

Tighten

Gear cover bolt to 10 Nm (7.2 kg-m/5.2 ft-lb)



7. O-Ring
8. O-Ring (P/N 1-6)

Tighten

- O-Ring 10 Nm (7.2 kg-m/5.2 ft-lb)
- O-Ring 10 Nm (7.2 kg-m/5.2 ft-lb)

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