



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).

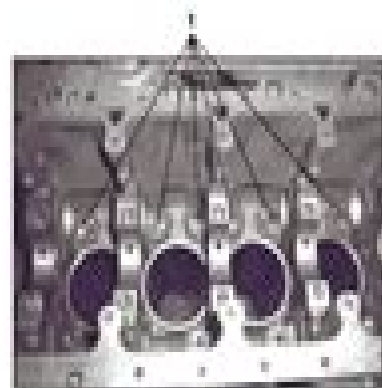


Fig. 5

## 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.

Reel the flywheel of the shaft to the push rods.

Rotate the engine over to the indicator reading. Check the 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) Insert the engine fly into the crankshaft until the core holes in the gear line up with the bolts (3-5) (4-6) securing the crankshaft front plate then remove the bolts and lockwashers.
- f) Withdraw the crankshaft with gear from the crankcase.
- g) Remove the valve tappets (1-6) and identify them so they can be installed in their original positions.

### 2. DISMANTLING

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

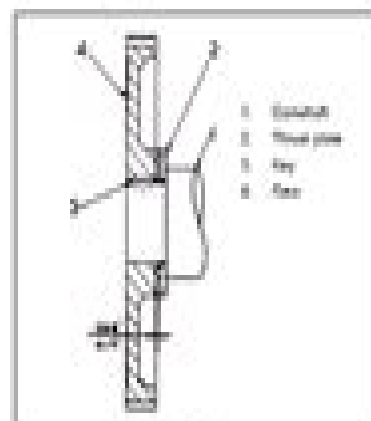


Fig. 6

### 3. INSPECTION AND REPAIR

- a) Inspect the cam lobes and crankshaft journals for wear and scoring. Check the clearance between centres and the crankshaft journals against the centre point of the crankshaft. The crankshaft does not exceed the specified limits. Check the crankshaft gear and thrust plate for wear and scoring. The crankshaft gear and thrust plate must be replaced if excessive wear is found.
- b) Check the crankshaft running clearance against the dimensions given in specifications. If inspection proves it necessary, remove the crankshaft 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 crankshaft.
  - b) Fit a new key to the crankshaft then press in the crankshaft 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 crankshaft 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 crankshaft and crankshaft bearings with clean engine oil.
- c) Install the crankshaft in the crankcase taking care not to damage the bearings and engage the crankshaft gear with the crankshaft pinion 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 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 crankshaft as details in para 4.
- b) Remove the flywheel as detailed in CHAPTER 5, para 8.
- c) Use a long bar from the front of the crankcase and drive off the separation plug (1-7).
- d) Remove the crankshaft 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.

# Mahindra 6000 Repair Manual

**A. K. Legg**



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