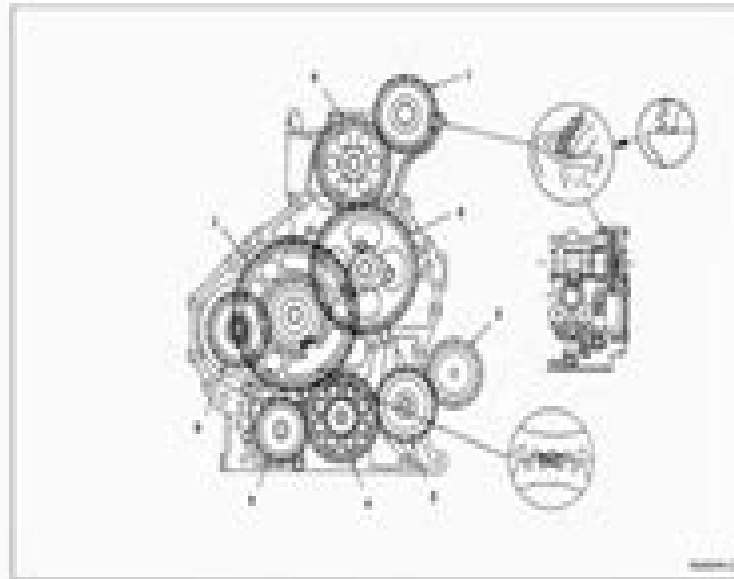


Align Gear Position for Each Gear

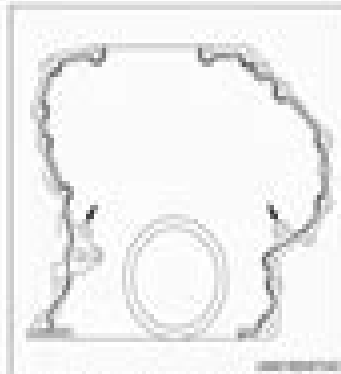


Legend

- | | |
|----------------------------------|------------------------|
| 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. Crankshaft 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 neck pins with the flywheel housing bolt pin holes.

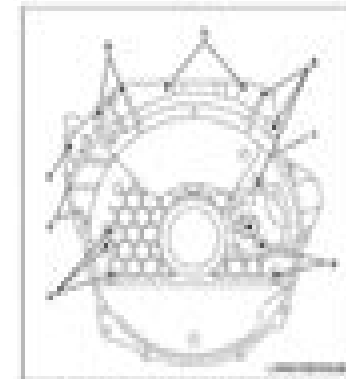
1B-110 Engine Mechanical (EMGT)

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

Tighten

Flywheel housing bolt to

- (a) 36 ft-lb (4.9 kg-m) (1 ft-lb)
- (b) 20 ft-lb (2.7 kg-m) (1 ft-lb)
- (c) 36 ft-lb (4.9 kg-m) (2 ft-lb)
- (d) 48 ft-lb (6.6 kg-m) (3 ft-lb)
- (e) 48 ft-lb (6.6 kg-m) (3 ft-lb)



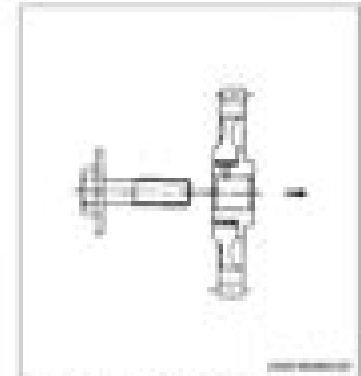
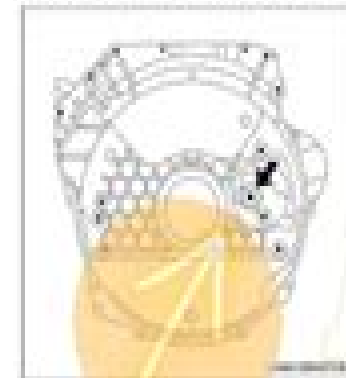
- Tighten the bolts marked with "1" from the injection pump side, and those with "2" from the cylinder block side.

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 position as shown in the illustration.

Tighten

Idle gear shaft bolt to 1.5 ft-lb (2.0 kg-m) (0.5 ft-lb)



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

Tighten

Gear cover bolt to 18 ft-lb (2.5 kg-m) (1.5 ft-lb)



7. O-Ring
8. O-Ring (P/N 1-2)

Tighten

- O-Ring 18 ft-lb to 48 ft-lb (2.5 kg-m) (1.5 ft-lb)
- O-Ring 18 ft-lb to 18 ft-lb (2.5 kg-m) (1.5 ft-lb)

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