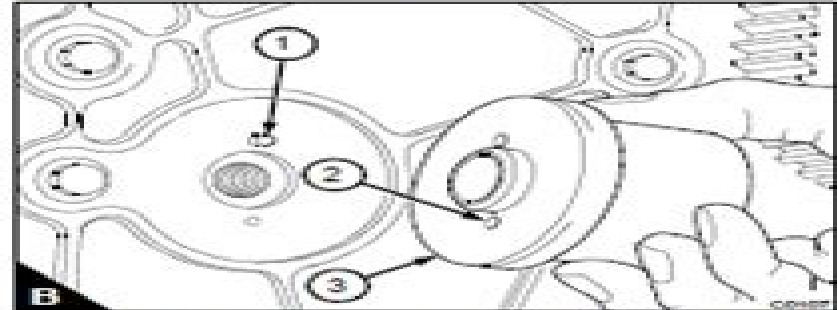
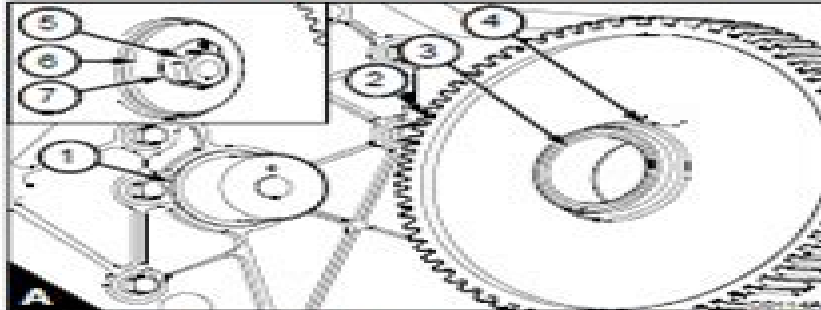


To fit

Operation 6-5

Note: Some engines have an idler gear that has a bush (A3).

- 1 If a new bush is to be fitted, ensure that the hole in the bush aligns with the hole in the gear (A4). Press in the bush with a suitable adaptor. Check that the hole in the bush is aligned with the hole in the gear.
- 2 If the hub (B3) has been removed, put the hub in position on the cylinder block. Ensure that the oil hole (B2) in the hub is at the bottom and that the hub is correctly fitted on its dowel (B1).



- 3 Lubricate the bore of the idler gear, or the bush, with clean engine lubricating oil. Align the timing marks on the idler gear with the marks on the crankshaft, the camshaft and the fuel pump gears, and slide the idler gear into position.

Note: If the crankshaft or the camshaft has to be rotated, it will be necessary to remove the rocker shaft to ensure a piston does not contact a valve.

- 4 Check that all the timing marks are in correct alignment.

Note: The latest engines do not have a tab washer and use an M12 M.E.A.S. setscrew instead of a $\frac{1}{2}$ UNF setscrew.

- 5 Fit the large washer (A6), a new tab washer (A7) and the setscrew (A5) that retains the idler gear to the hub. Tighten the $\frac{1}{2}$ UNF setscrew to 65 Nm (48 lbf ft) 6,6 kgf m. For engines with an M12 setscrew, tighten the setscrew to 78 Nm (57 lbf ft) 8,0 kgf m. If a tab washer is used, bend the tab of the tab washer to lock the setscrew.

Continued

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Patrick Vollmar



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 - The Rise of Digital Reading Perkins Generator Repair Manual W54414n1475254
 - Advantages of eBooks Over Traditional Books
2. Identifying Perkins Generator Repair Manual W54414n1475254
 - 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 Perkins Generator Repair Manual W54414n1475254
 - User-Friendly Interface
4. Exploring eBook Recommendations from Perkins Generator Repair Manual W54414n1475254
 - Personalized Recommendations
 - Perkins Generator Repair Manual W54414n1475254 User Reviews and Ratings
 - Perkins Generator Repair Manual W54414n1475254 and Bestseller Lists

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7. Enhancing Your Reading Experience
 - Adjustable Fonts and Text Sizes of Perkins Generator Repair Manual W54414n1475254
 - Highlighting and Note-Taking Perkins Generator Repair Manual W54414n1475254
 - Interactive Elements Perkins Generator Repair Manual W54414n1475254
8. Staying Engaged with Perkins Generator Repair Manual W54414n1475254
 - Joining Online Reading Communities
 - Participating in Virtual Book Clubs
 - Following Authors and Publishers Perkins Generator Repair Manual W54414n1475254
9. Balancing eBooks and Physical Books Perkins Generator Repair Manual W54414n1475254
 - Benefits of a Digital Library
 - Creating a Diverse Reading Collection Perkins Generator Repair Manual W54414n1475254
10. Overcoming Reading Challenges
 - Dealing with Digital Eye Strain
 - Minimizing Distractions
 - Managing Screen Time
11. Cultivating a Reading Routine Perkins Generator Repair Manual W54414n1475254
 - Setting Reading Goals Perkins Generator Repair Manual W54414n1475254
 - Carving Out Dedicated Reading Time
12. Sourcing Reliable Information of Perkins Generator Repair Manual W54414n1475254
 - Fact-Checking eBook Content of Perkins Generator Repair Manual W54414n1475254
 - 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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