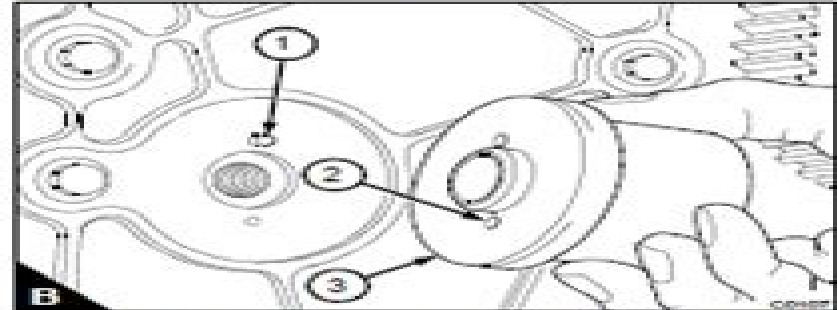
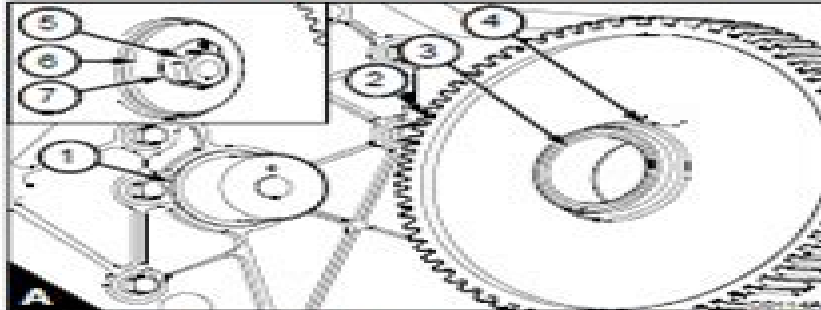


## To fit

## 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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