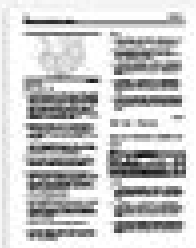




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## To Disassembly and Assembly Section

REPAIRS

### NOTICE

Care must be taken to ensure that fluids are contained during performance of inspection, maintenance, testing, adjusting and repair of the product. Be prepared to collect the fluid with suitable containers before opening any compartment or disassembling any component containing fluids.

Dispose of all fluids according to local regulations and ordinances.

**Note:** Care must be taken in order to ensure that the fuel injection pump timing is not lost during the removal of the front gear group. Carefully follow the procedure in order to remove the gear group.

1. Use Tooling (A) in order to rotate the crankshaft so that number one piston is at the top center position on the compression stroke. Refer to Systems Operation, Testing and Adjusting, "Finding Top Centre Position for No. 1 Piston".

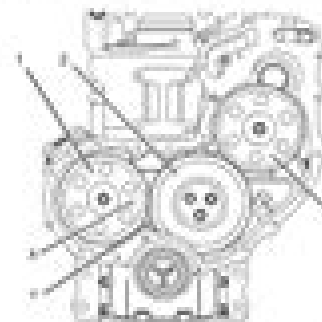


Illustration 128  
Typical example

2. Install Tooling (B) through hole (X) in crankshaft gear (1) into the front housing. Use Tooling (B) in order to lock the crankshaft in the correct position. Install Tooling (C) into hole (Y) in the front housing. Use Tooling (C) in order to lock the crankshaft in the correct position. Refer to Systems Operation, Testing and Adjusting, "Finding Top Centre Position for No. 1 Piston".

**Note:** Do not use excessive force to install Tooling (C). Do not use Tooling (C) to hold the crankshaft during repairs.

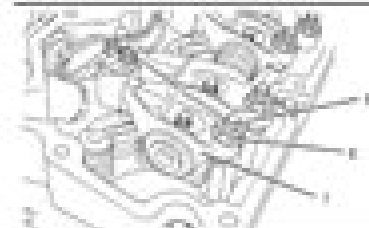


Illustration 129  
Typical example

3. Loosen nuts (5) on all rocker arms (7). Unthread adjusters (2) on all rocker arms (7) until all valves are fully closed.

**Note:** Failure to ensure that ALL adjusters are fully unthreaded can result in contact between the valves and pistons.

4. Apply sufficient pressure to fuel injection pump gear (3) in a counterclockwise direction in order to remove the backlash. Lock the fuel injection pump in this position. Refer to Disassembly and Assembly, "Fuel Pump Gear - Removal" for the correct procedure.

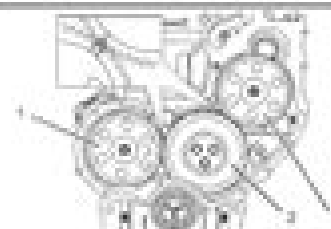


Illustration 130  
Typical example

5. Mark gears (1), (2) and (3) in order to show alignment. Refer to Illustration 130.

**Note:** Identification will ensure that the gears can be replaced in the original alignment.

6. Remove fuel pump gear (3). Refer to Disassembly and Assembly, "Fuel Pump Gear - Removal" for the correct procedure.

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