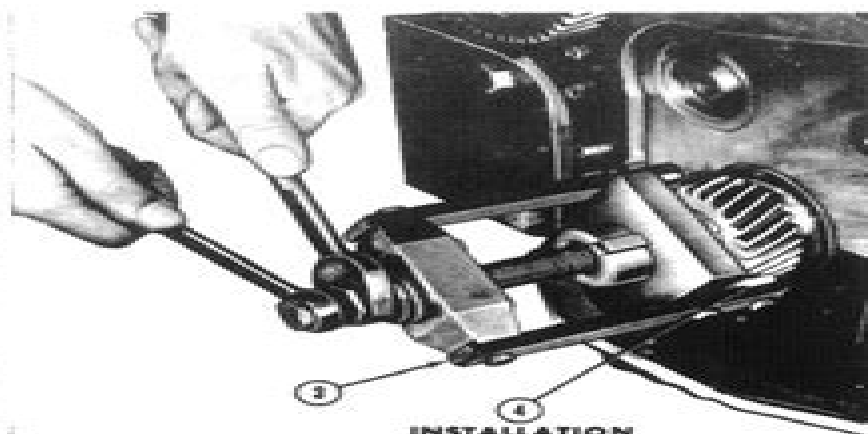


REMOVAL



INSTALLATION

Figure 28
Removing and Installing Crankshaft Gear

1. Remover-Replacer 2134
2. Insert 1237

3. Remover-Replacer 2134
4. Insert 1237

Camshaft Gear

A. Removal

1. Remove the bolt and flat washer, as shown in Figure 24.
2. Remove the camshaft gear from the end of the shaft.

B. Cleaning and Inspection

1. Clean the gear in solvent.
2. Inspect gear teeth for scores, nicks, and the condition of the teeth wear pattern.
3. Check the keyway and key on the end of the camshaft. If the key is damaged in any way, install a new key before installing the gear. Use a carborundum stone to remove minor gear teeth imperfections. If tooth wear or damage is severe install a new gear.

C. Installation

1. Install the camshaft gear spacer.
2. Install the key in the camshaft keyway.
3. Install the camshaft gear with timing marks aligned. Install the flat washer, lock washer, and bolt, and tighten to the specified torque, page 81.

Timing the Gears

When removing and reinstalling any or all of the timing gears, be sure that the timing marks line up correctly, as shown in Figure 22. On all engines, the No. 1 piston must be at T.D.C. on the firing stroke, when the timing marks are aligned.

NOTE: The power steering pump drive gear does not require timing.

Front Cover Installation

1. Position a new gasket on the engine front adapter plate.
2. Install the oil slinger dish out, Figure 24.
3. Install the front cover, being sure the cover aligns with the dowel pins.
4. Install the front cover-to-front engine plate bolts and tighten to the specified torque, page 81.
5. Install the oil pan with a new gasket and tighten the bolts to the specified torque, page 80.
6. Install the alternator support front mounting bolt.
7. Refill the crankcase with the proper grade and quantity of oil.

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