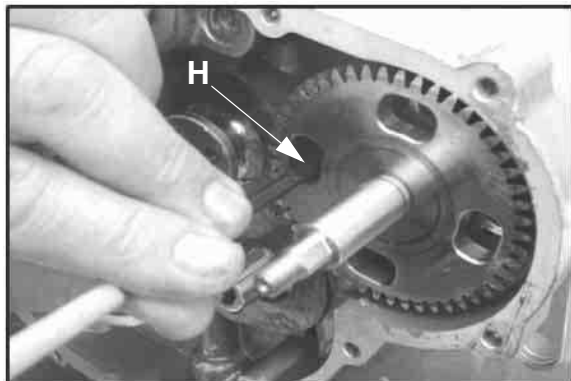



20. Install oil pump housing bolts (H). The new bolts contain patch lock, so Loctite™ is not needed on the new bolts. Torque bolts to specification and follow the torque sequence at beginning of the chapter.



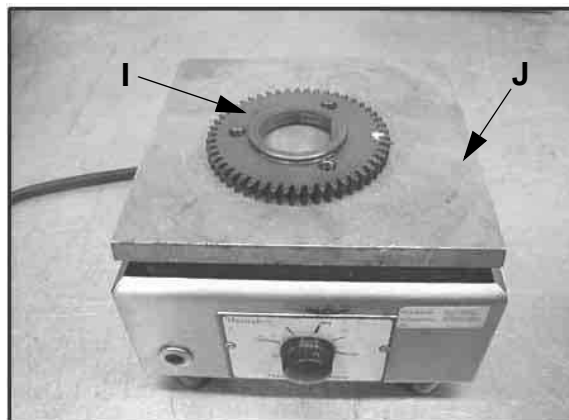
NOTE: Occasionally spin the oil pump when installing bolts to check for binding of the rotors.


 = T
Oil Pump Bolt Torque: 84 ± 8 in.lbs. (9.50 ± 0.90 Nm) * Torque in Sequence

21. Apply Loctite™ 242 (PN 2871949) to the crankshaft.



22. Before installing the crankshaft gear (I), heat the crankshaft gear to 250° F (121°C) on a hot plate (J).



 CAUTION
The crankshaft gear is extremely hot! Severe burns or injury can occur if the gear is not handled with extreme care and caution. Follow the procedure below to help ensure safety.

23. Use extreme caution when removing the crankshaft gear from the hot plate. Use a pair of pliers and leather gloves when handling the crankshaft gear.
24. Install the crankshaft gear (I) onto the crankshaft.

NOTE: For assembly of the gears, the cam gear and the crankshaft gear are stamped with "This Side Out." This indicates the side of the gear that faces outward or away from the case.

