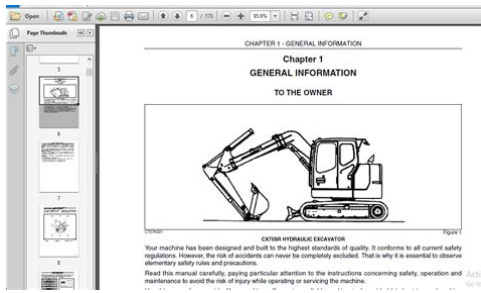


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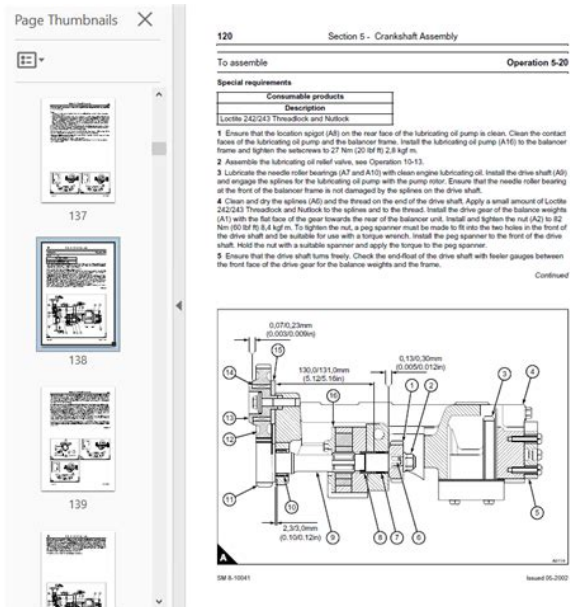
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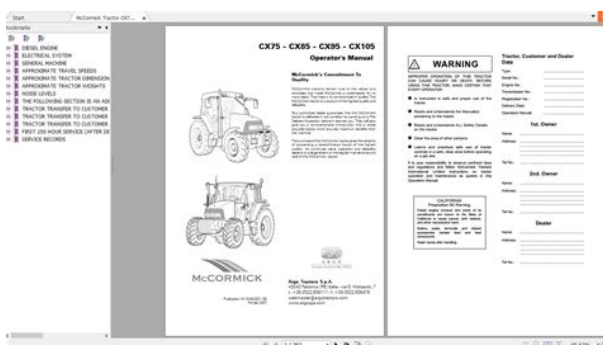


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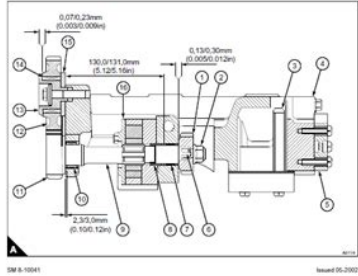
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Special requirements

Consumable products	
Description	
Loctite 242/243 Threadlock and Nutlock	

- 1 Ensure that the location spigot (A8) on the rear face of the lubricating oil pump is clean. Clean the contact faces of the lubricating oil pump and the balancer frame. Install the lubricating oil pump (A16) to the balancer frame and tighten the set screws to 27 Nm (20 lbf ft) 2,8 kgf m.
- 2 Assemble the lubricating oil relief valve, see Operation 15-13.
- 3 Lubricate the needle roller bearings (A7 and A10) with clean engine lubricating oil. Install the drive shaft (A2) and engage the splines for the lubricating oil pump with the pump rotor. Ensure that the needle roller bearing at the front of the balancer frame is not damaged by the splines on the drive shaft.
- 4 Clean and dry the splines (A2) and the thread on the end of the drive shaft. Apply a small amount of Loctite 242/243 Threadlock and Nutlock to the splines and to the thread. Install the drive gear of the balance weights (A1) with the flat face of the gear towards the rear of the balancer unit. Install and tighten the nut (A3) to 52 Nm (50 lbf ft) 8,4 kgf m. To tighten the nut, a peg spanner must be made to fit into the two holes in the front of the drive shaft and be suitable for use with a torque wrench. Install the peg spanner to the front of the drive shaft. Hold the nut with a suitable spanner and apply the torque to the peg spanner.
- 5 Ensure that the drive shaft turns freely. Check the end float of the drive shaft with feeler gauges between the front face of the drive gear for the balance weights and the frame.

Continued



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