

9. Crankshaft balancer (hub)
10. Front cover attaching bolts (Fig. 32)
11. Timing indicator
12. Front cover and water pump assembly
13. Dowel pins. If necessary grind a flat surface on the dowel pins to aid in removal.

**Clean**

- Cylinder block, oil pan and front cover mating surfaces
- Cut excess material from the oil pan gasket on each side of the engine.

**Install or Connect**

1. Apply 1050026 sealer or equivalent around coolant holes of new front cover gasket.
2. Gasket on cylinder block
3. Trim oil pan seal (Fig. 33)
4. Seal onto front cover
5. Apply 1052915, G.E.1673 or equivalent RTV sealer on the oil pan (Fig. 34).
6. Front cover

**Important**

- Press down the cover to compress the oil pan seal.
 - With a small screwdriver guide the seal into the cavity between the oil pan and cylinder block (Fig. 35).
7. Apply engine oil to bolts.
 8. Two bolts finger tight
 9. Dowel pins – chamfer end first, through holes in cover (Fig. 36).
 10. Timing indicator
 - Attaching bolts to specification

**Important**

- If engine front cover oil seal must be replaced, install at this time.

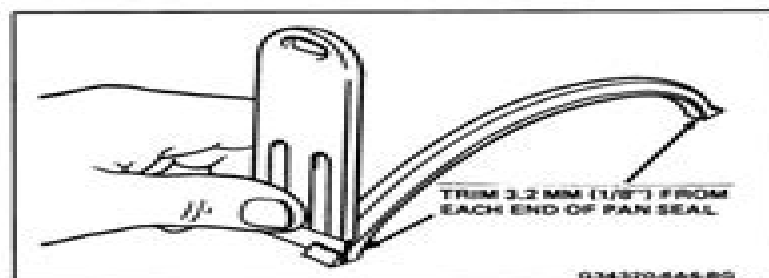


Fig. 33 Trimming Oil Pan Seals

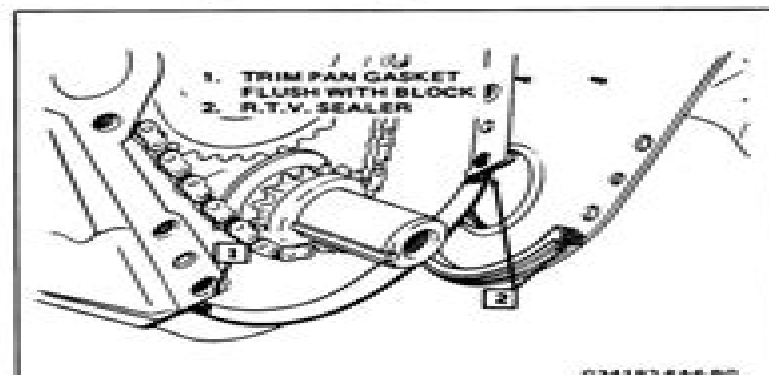


Fig. 34 Applying RTV Sealer and Trimming Oil Pan Gasket

**Install or Connect**

1. Crankshaft Balancer and Bolt – Tighten to 271-420 N·m (200-310 lbs. ft.)
2. Crankshaft Pulley and Bolts – Tighten to 40 N·m (28 lbs. ft.)

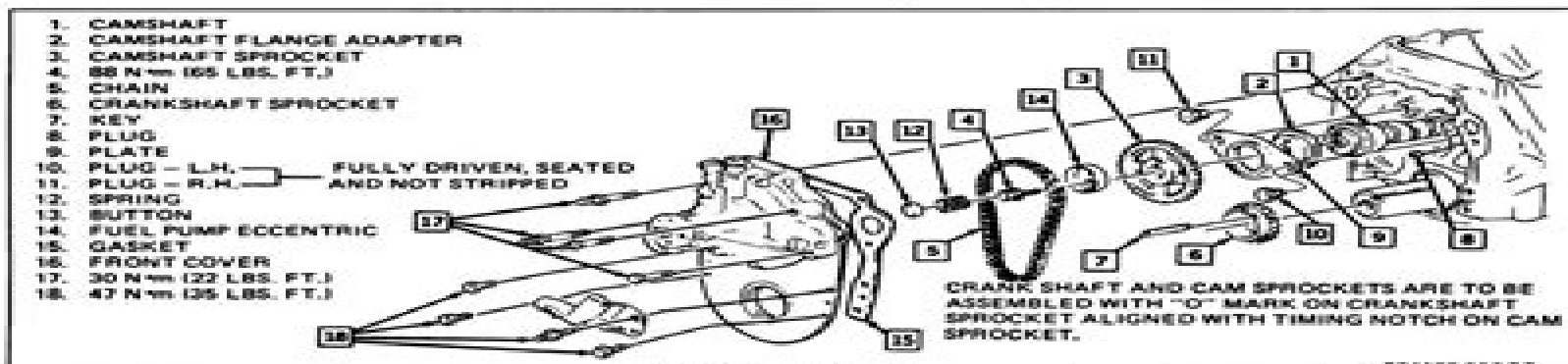


Fig. 32 Front of Engine

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Huangqi Zhang



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