

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

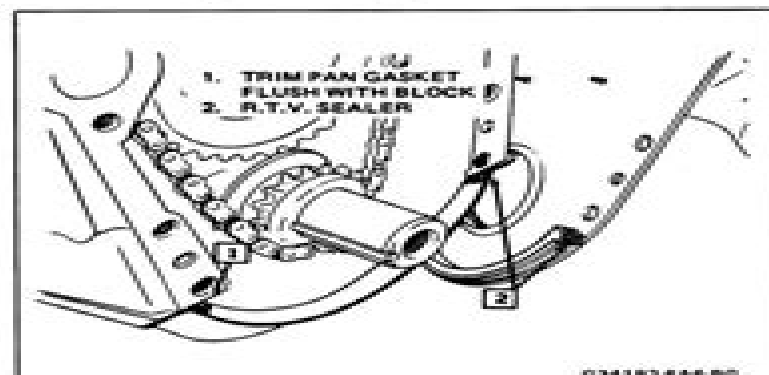


Fig. 34 Applying RTV Sealer and Trimming Oil Pan Gasket

**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.)

1. CAMSHAFT
2. CAMSHAFT FLANGE ADAPTER
3. CAMSHAFT SPROCKET
4. 88 N·m (65 LBS. FT.)
5. CHAIN
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7. KEY
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9. PLATE
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12. SPRING
13. BUTTON
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17. 30 N·m (22 LBS. FT.)
18. 47 N·m (35 LBS. FT.)

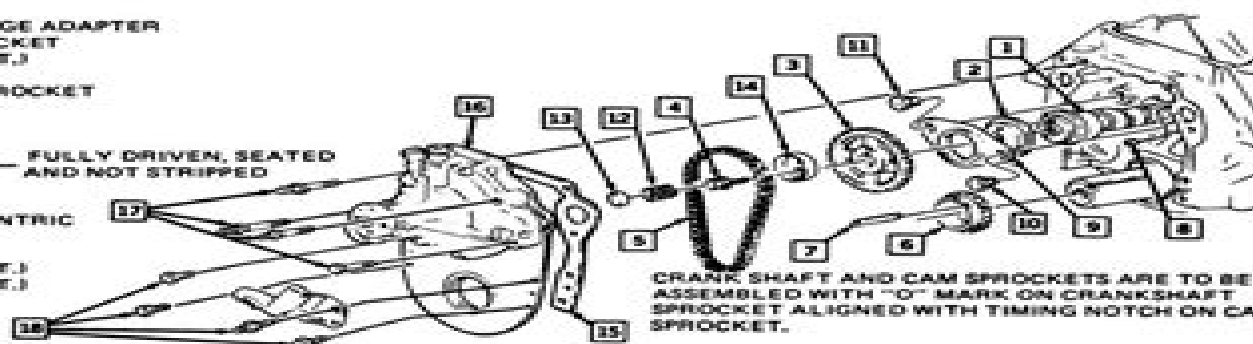


Fig. 32 Front of Engine

024182-6A5-B0

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 - The Rise of Digital Reading 1986 Oldsmobile Cutlass Ciera Repair Manual
 - Advantages of eBooks Over Traditional Books
2. Identifying 1986 Oldsmobile Cutlass Ciera Repair Manual
 - Exploring Different Genres
 - Considering Fiction vs. Non-Fiction
 - Determining Your Reading Goals
3. Choosing the Right eBook Platform
 - Popular eBook Platforms
 - Features to Look for in an 1986 Oldsmobile Cutlass Ciera Repair Manual
 - User-Friendly Interface
4. Exploring eBook Recommendations from 1986 Oldsmobile Cutlass Ciera Repair Manual
 - Personalized Recommendations
 - 1986 Oldsmobile Cutlass Ciera Repair Manual User Reviews and Ratings

- 1986 Oldsmobile Cutlass Ciera Repair Manual and Bestseller Lists
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 - 1986 Oldsmobile Cutlass Ciera Repair Manual Enhanced eBook Features
- 7. Enhancing Your Reading Experience
 - Adjustable Fonts and Text Sizes of 1986 Oldsmobile Cutlass Ciera Repair Manual
 - Highlighting and Note-Taking 1986 Oldsmobile Cutlass Ciera Repair Manual
 - Interactive Elements 1986 Oldsmobile Cutlass Ciera Repair Manual
- 8. Staying Engaged with 1986 Oldsmobile Cutlass Ciera Repair Manual
 - Joining Online Reading Communities
 - Participating in Virtual Book Clubs
 - Following Authors and Publishers 1986 Oldsmobile Cutlass Ciera Repair Manual
- 9. Balancing eBooks and Physical Books 1986 Oldsmobile Cutlass Ciera Repair Manual
 - Benefits of a Digital Library
 - Creating a Diverse Reading Collection 1986 Oldsmobile Cutlass Ciera Repair Manual
- 10. Overcoming Reading Challenges
 - Dealing with Digital Eye Strain
 - Minimizing Distractions
 - Managing Screen Time
- 11. Cultivating a Reading Routine 1986 Oldsmobile Cutlass Ciera Repair Manual
 - Setting Reading Goals 1986 Oldsmobile Cutlass Ciera Repair Manual
 - Carving Out Dedicated Reading Time
- 12. Sourcing Reliable Information of 1986 Oldsmobile Cutlass Ciera Repair Manual
 - Fact-Checking eBook Content of 1986 Oldsmobile Cutlass Ciera Repair Manual
 - Distinguishing Credible Sources

13. Promoting Lifelong Learning
 - Utilizing eBooks for Skill Development
 - Exploring Educational eBooks
14. Embracing eBook Trends
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