

31. Install key if removed.



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32. Install crankshaft gear using the following heat method or by driver method. The heat method is recommended.

NOTE: For driver method, go to Step 33.

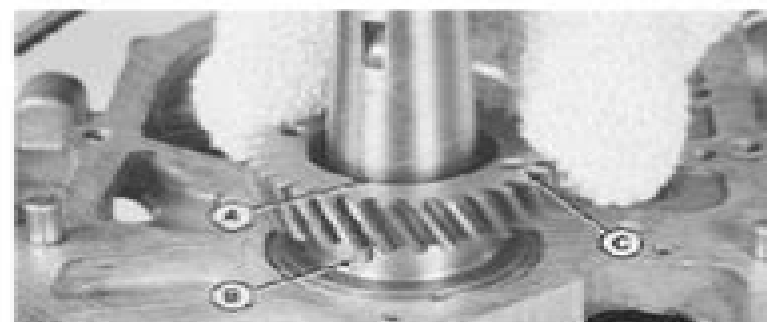
HEAT METHOD

a. Heat crankshaft gear to 232° C (450°F) for 1/2 hour using a bearing oven.

N **CAUTION:** Gear is hot. Be careful not to burn hands while installing gear.

b. Align slot (A) in gear with key (B) in crankshaft.

c. Install gear with holes (C) outward on crankshaft. Push gear tight against crankshaft shoulder.



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