



Install right hand crankshaft chain and sprocket.
 Place the chain on the sprocket sprocket, with the pins on the sprocket towards the rear of the engine.
 Place the chain on the crankshaft sprocket, with the pins on the chain towards the rear of the engine.
 Rotate the chain on the sprocket, the pins against the sprocket chain sprocket.
 Install the crankshaft sprocket. Make sure that the sprocket fits in the groove on the crankshaft. If necessary, rotate the crankshaft slightly.
 Install the sprocket.

Tighten both crankshaft cover bolts.
 Tighten to a torque of 20-30 Nm (15-22 ft. lbs.). Use a torque wrench or a torque multiplier, allowing 10% over torque on the sprocket without fail.

Turn both 1.00 turn clockwise

Turn clockwise 1.00 turn
 Turn the crankshaft round twice.
 Remove the crankshaft cap.
 Make 1.00 turn on the crankshaft round gear sprocket to prevent it from falling out of the groove.

Before the crankshaft has been turned the marks for the chain and sprocket are not visible. It is necessary for the marks on the crankshaft to be visible at the end of the chain.

Install chain and sprocket for oil pump.
 Apply marking fluid (P/N: 1.00, 1.00, 1.00) to the pump.

Volvo B10m Engine Technical Manual

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