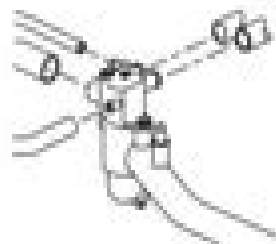


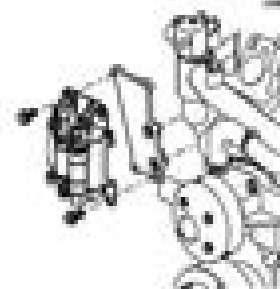
- view
8. Install the thermal bypass hose clamps onto the thermal bypass hose.
  9. Install the thermal bypass hose.
- NOTE:** Properly position the bypass hose clamps to avoid water pump pulley interference.
10. Position the thermal bypass hose clamps.



- view
11. Reconnect all the hoses to the thermostat housing.



- view
12. Install the idler pulley.
  13. Install the alternator and steering pump bracket. There are six bolts.



- view
14. Reinstall the fuel rail and fuel rail bracket.



- view
15. Install the drive belt tensioner.
  16. Install the drive belt tensioner bolts.
  17. Tighten the drive belt tensioner bolts to 50 Nm (37 ft. lb.).

#### Preparing Gasket Surfaces



#### CAUTION

Clean threads in the mounting holes are critical for tightening of the rear bolts, and the seal between the rear and manifold.

- Check all rear mounting holes in manifold for debris or excessive coating on threads.
- Bolts should enter completely into hole by hand. If not, run tap in holes to clear debris and coating.
- Use shop vacuum to remove debris from holes.



#### CAUTION

The gasket mounting surfaces must be clean and flat to ensure a correct seal between the rear and manifold. Carefully follow the steps below to ensure a good seal.

**NOTE:** Before proceeding, place shop towels in the manifold openings to prevent debris from entering the engine. When the cleaning process is done, use a shop vacuum to remove debris from the manifold, rear, and engine.

# Volvo Penta Marine Engine Manual

**Ying Liu**



## **Volvo Penta Marine Engine Manual:**

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