



### 5. Crankshaft Bearing Cap

- 1) Lubricate the bearing cap bolts with engine oil.
- 2) Install the bearing caps to the crankshaft.  
The arrow mark must be pointing to the front of the engine.
- 3) Tighten the bearing cap bolts to the specified torque a little at a time in the numerical order shown in the illustration.



#### Crankshaft Bearing Cap Bolt Torque

kg-m(lb.ft)  
 $24.0 \pm 1$  (173.5  $\pm$  7.2)

- 4) Check that the crankshaft turns smoothly by manually rotating it.



### 6. Timing Gear Case

- 1) Apply liquid gasket to the timing gear case surfaces contacting the cylinder body.
- 2) Tighten the timing gear case bolts to the specified torque.

#### Timing Gear Case Bolt Torque

kg-m(lb.ft)  
 $2.6 \pm 0.5$  (18.8  $\pm$  3.6)



### 8. Camshaft

- Tighten the thrust plate bolts through the camshaft gear hole.

#### Thrust Plate Bolt Torque

kg-m(lb.ft)  
 $2.6 \pm 0.5$  (18.8  $\pm$  3.6)

#### Camshaft Gear Bolt Torque

kg-m(lb.ft)  
 $16 \pm 1.5$  (115.7  $\pm$  10.5)



### 9. Idler Gear Shaft

- Use the thrust collar fixing bolt as a guide to install the idler gear shaft.  
The oil port must be facing the camshaft.

# Isuzu 6bb1 Manual

**Isuzu Jidōsha Kabushiki Kaisha, Isuzu  
Motors**

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