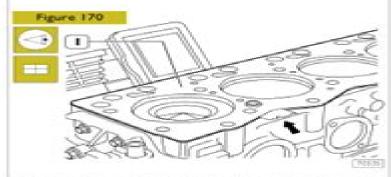


Assemble the electronic gearbox (2) equipped with the exchanger to the engine, fixing it with the screws (1). In case the rubber buffers are cracked or excessively deformed provide replacing them.



Oheck cleanness of cylinder head and engine block coupling surface.

There are two types of head gasket:

- Type A 1.25 mm thick
- Type B = 1.15 mm thick

Check the average protrusion 5 of the pistons as indicated on page 33.

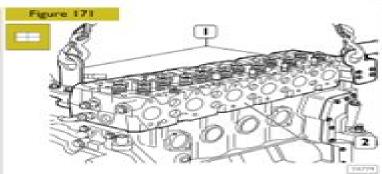
If S > 0:40 mm use gasket type A.

If S ≤ 0:40 mm use gasket type B.

Do not get the cylinder head gasket dirty.

Place the gasket (1) in position with the marking "TOP" (1) facing the head.

The arrow shows the point where the gasket thickness is given.

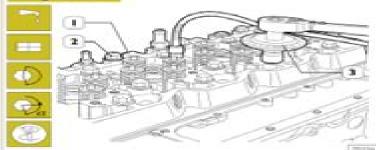


Direct the output shaft (4) and the camshaft (2) so that when fitting the driven gear (1) on the camshaft the marks on the gears (1 and 3) are coinciding.

NOTE Before reusing the fastening screws (I), perform two diameter measurements as shown in figure, registering diameters DI and D2:

if D1-D2 < 0.1 mm the screw may be reused if D1-D2 > 0.1 mm the screw must be replaced





Assemble cylinder head (1), tighten the screws (2) in three following steps, following order and mode shown in the figure below.

NOTE The angle tightening is carried out through tool 99395216 (3).

NOTE Before any assembly operation always verify that the hole and screw threads have no evidence of wear or dirt.

# **Iveco N45 Manual**

**Louis C. Forier** 

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#### **Table of Contents Iveco N45 Manual**

- 1. Understanding the eBook Iveco N45 Manual
  - The Rise of Digital Reading Iveco N45 Manual
  - Advantages of eBooks Over Traditional Books
- 2. Identifying Iveco N45 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 Iveco N45 Manual
  - User-Friendly Interface
- 4. Exploring eBook Recommendations from Iveco N45 Manual
  - Personalized Recommendations
  - Iveco N45 Manual User Reviews and Ratings
  - Iveco N45 Manual and Bestseller Lists
- 5. Accessing Iveco N45 Manual Free and Paid eBooks
  - Iveco N45 Manual Public Domain eBooks
  - Iveco N45 Manual eBook Subscription Services
  - Iveco N45 Manual Budget-Friendly Options

- 6. Navigating Iveco N45 Manual eBook Formats
  - o ePub, PDF, MOBI, and More
  - Iveco N45 Manual Compatibility with Devices
  - Iveco N45 Manual Enhanced eBook Features
- 7. Enhancing Your Reading Experience
  - Adjustable Fonts and Text Sizes of Iveco N45 Manual
  - Highlighting and Note-Taking Iveco N45 Manual
  - Interactive Elements Iveco N45 Manual
- 8. Staying Engaged with Iveco N45 Manual
  - Joining Online Reading Communities
  - Participating in Virtual Book Clubs
  - Following Authors and Publishers Iveco N45 Manual
- 9. Balancing eBooks and Physical Books Iveco N45 Manual
  - Benefits of a Digital Library
  - Creating a Diverse Reading Collection Iveco N45 Manual
- 10. Overcoming Reading Challenges
  - Dealing with Digital Eye Strain
  - Minimizing Distractions
  - Managing Screen Time
- 11. Cultivating a Reading Routine Iveco N45 Manual
  - Setting Reading Goals Iveco N45 Manual
  - Carving Out Dedicated Reading Time
- 12. Sourcing Reliable Information of Iveco N45 Manual
  - Fact-Checking eBook Content of Iveco N45 Manual
  - Distinguishing Credible Sources
- 13. Promoting Lifelong Learning
  - Utilizing eBooks for Skill Development
  - Exploring Educational eBooks
- 14. Embracing eBook Trends
  - Integration of Multimedia Elements

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