

Flywheel Installation

Install the flywheel. The flywheel on this engine does not have a pin to correctly orient the flywheel timing marks to the crankshaft. A few early engines do not have an arrow stamped on the flywheel indicating "up" to assist in correct installation. Use the following procedures for engines without arrows.

NOTE: The following sequence of flywheel/bellhousing installation steps must be followed on early engines to ensure correct positioning of the flywheel timing marks to the crankshaft. The flywheel can be installed in the wrong position and if not corrected will make it impossible to time the fuel injection pump.

1. Rotate the crankshaft to bring No. 1 crank pin to top dead center.

2. Install the flywheel on the crankshaft and secure it with one bolt. The bolt needs only to be finger tight.
3. Temporarily install the bellhousing and secure it with one or two bolts.

4. Remove the bolt from the flywheel and carefully rotate the flywheel until the TC mark on the flywheel lines up with the pointer on the bellhousing. Do not allow the crankshaft to rotate.
5. Install the locking ring and torque the eight flywheel bolts to 86 ft-lb (117 N•m) in the sequence shown.

NOTE: Later production engines have an arrow stamped on the flywheel indicating "up". Simply rotate the No. 1 crank pin to top dead center and install the flywheel with the arrow pointing up.

Flywheel Interchangeability

There are four possible combinations of 8-pin and 6-pin flywheels with both small and large crankshaft compressors.

Units with *small crankshaft* compressors and 6-pin flywheels are interchangeable with 8-pin flywheels provided you have the correct 8-pin clutch or 8-pin coupling.

Units with *large crankshaft* compressors and 8-pin flywheels are interchangeable with 6-pin flywheels provided you have the correct 6-pin clutch or 6-pin coupling.

NOTE: See TK-50254 for complete information regarding interchangeability of components and Service Part numbers.

Flywheel Positioning

1.	Indicates Up
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Note: 6-pin flywheel shown, 8-pin also used

