

!R!PSRC100;EXIT;!R!MTYP99;EXIT;!R!spsz6;stm0;exit;

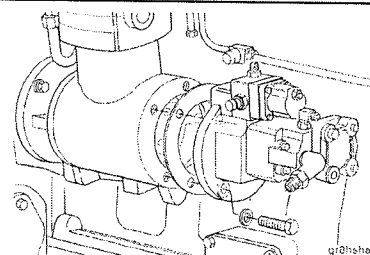
(/qs3/pubsys2/xml/en/manual/3666139/3666139-titlepage.html)

## Remove

Remove the fuel pump. Refer to Procedure 005-016 in Section 5. (</qs3/pubsys2/xml/en/procedures/36/36-005-016.html>)

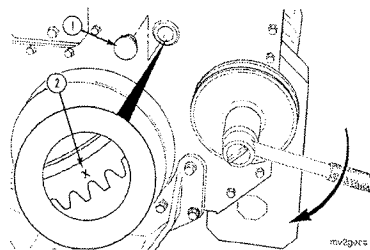
Remove the air compressor, if equipped. Refer to Procedure 012-014 in Section 12.

(</qs3/pubsys2/xml/en/procedures/36/36-012-014-tr.html>)

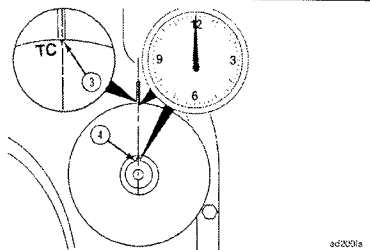


To mark the accessory drive pulley position:

- Remove the inspection hole plug (1) in the gear cover.
- Use the accessory driveshaft to rotate the engine until the camshaft gear timing mark (2) is visible through the inspection hole.



When the timing mark is visible through the inspection hole, cylinders No. one and six are at top dead center. The accessory drive pulley T-C mark (3) and keyway (4) are at the 12-o'clock location.



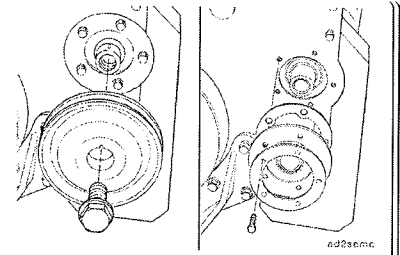
Remove the pulley retainer capscrew.

Remove the accessory drive pulley.

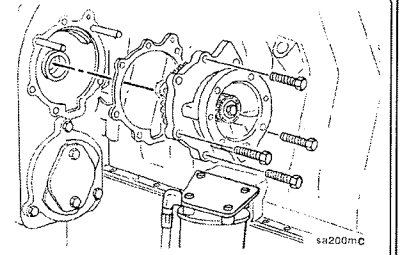
**Note :** This is a slip-fit pulley and does **not** require the use of a puller.

Remove the five seal retaining capscrews, clamping ring, and accessory oil drive seal. Refer to Procedure 001-003 in Section 1.

(/qs3/pubsys2/xml/en/procedures/36/36-001-003.html)

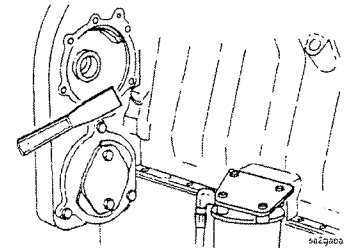


Remove the six capscrews and the accessory drive assembly.

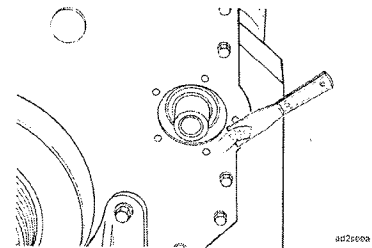


## Clean

Clean the accessory drive to gear housing gasket surface.



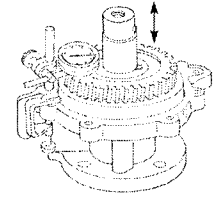
Clean the accessory drive oil seal surface on the front of the gear cover.



## Inspect for Reuse

Measure the drive shaft end clearance.

Drive Shaft End Clearance			
	mm		in
	0.10	MIN	0.004
	0.30	MAX	0.012



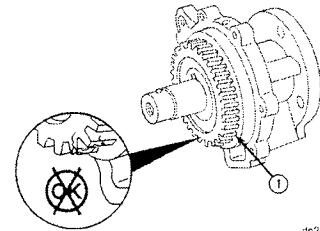
If the shaft end clearance does **not** meet these specifications, rebuild or replace the drive unit. Use the M11 Shop Manual, Bulletin 3666075.

Visually inspect the housing for cracks and non-uniform front and rear gasket sealing surfaces.

Replace the housing or the drive unit if cracks are found or the gasket sealing surfaces **cannot** be made uniform using Scotch-Brite™ 7448 or its equivalent.

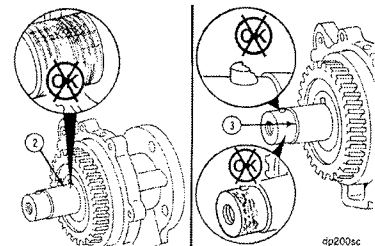
Visually inspect the drive gear (1) for cracked or severely worn teeth.

Replace the drive gear or the drive unit if the drive gear is cracked or abnormally worn teeth are found.



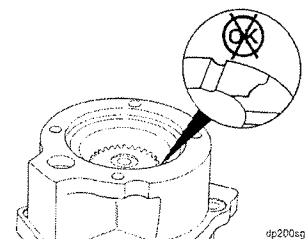
Visually inspect the shaft surface (2). Pay special attention to the pulley hub to shaft shoulder contact area (3). Replace the shaft if scratches, scoring, or fretting is found.

Inspect the dowel pin for damage. Replace if required.



Visually inspect the rear thrust washer for cracks.

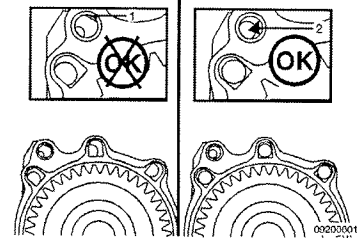
Replace the washer if cracks are found. Refer to the M11 Shop Manual, Bulletin No. 3666075.



## Install

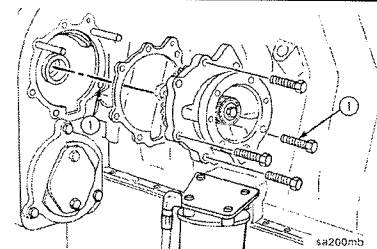
### ⚠ CAUTION ⚠

Care must be used when installing the accessory drive gasket. If the gasket is twisted during the installation of the accessory drive, a leak path (1) will exist between the gasket and the oil passage port at point(2).



Use a small amount of grease or sealant to hold the gasket in place during installation. Use care **not** to block the oil passage.

The accessory drive shaft dowel pin **must** be at the 12 o'clock location when the accessory drive is installed. Make sure the camshaft gear timing mark "X" is visible through the inspection hole in the front of the gear cover.



Use a new gasket to install the accessory drive assembly.

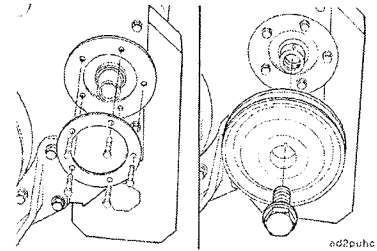
Install the six capscrews and tighten.

**Torque Value:** 47 n•m [ 35 ft-lb ]

**Note :** The cap screw (1) located in the lower corner nearest the cylinder block **must** be installed with a new copper sealing washer, Part Number 3882885, and thread sealant, Part Number 3823494, applied to the threads.

Install the accessory drive oil seal. Refer to Procedure 001-003 in Section 1.  
(/qs3/pubsys2/xml/en/procedures/36/36-001-003.html)

Install the accessory drive pulley. Refer to Procedure 009-004 in Section 9. (</qs3/pubsys2/xml/en/procedures/36/36-009-004.html>)

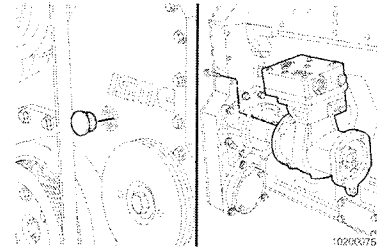


Install the inspection hole plug in the gear cover.

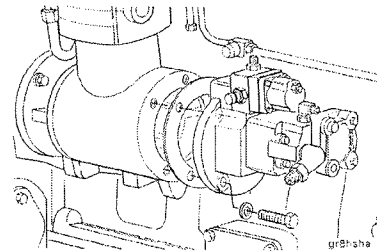
**Note :** The air compressor **must** be timed to the accessory drive.

Install the air compressor, if equipped. Refer to Procedure 012-014 in Section 12.

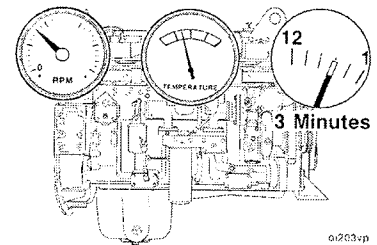
(</qs3/pubsys2/xml/en/procedures/36/36-012-014-tr.html>)



Install the fuel pump. Refer to Procedure 005-016 in Section 5. (</qs3/pubsys2/xml/en/procedures/36/36-005-016.html>)



Operate the engine to normal operating temperature and check for leaks.



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Last Modified: 08-May-2014

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