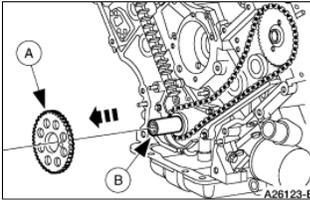


**Timing Chains****Special Service Tool(s)**

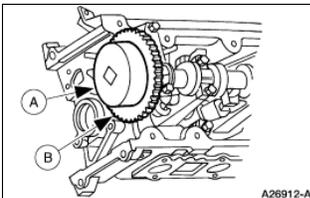
 <p>ST1329-A</p>	Cam Positioning Tool T91P-6256-A
 <p>ST1334-A</p>	Cam Positioning Tool Adapters T92P-6256-A
	Camshaft Holding Tool T96T-6256-B
	Camshaft Positioning Tool T96T-6256-AR

**Removal**

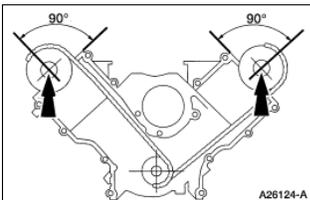
1. Remove the engine front cover; refer to the procedure in this section.
2. Remove the (A) crankshaft sensor ring from the (B) crankshaft (6303).



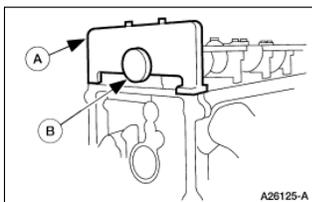
3. On WEP engines, use the (A) Camshaft Positioning Tool to position the (B) camshaft.



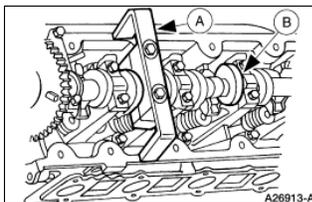
4. on REP engines, rotate the crankshaft until both camshaft keyways are 90° from the cam cover surface. On REP and WEP engines, make sure the copper links line up with the dots on the camshaft sprockets.



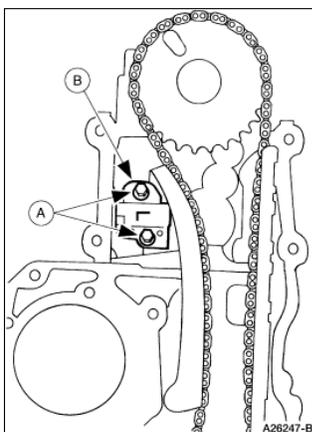
5. On REP equipped engines, install the (A) Cam Positioning Tool and the Camshaft Positioning Tool Adapters on the (B) camshaft.



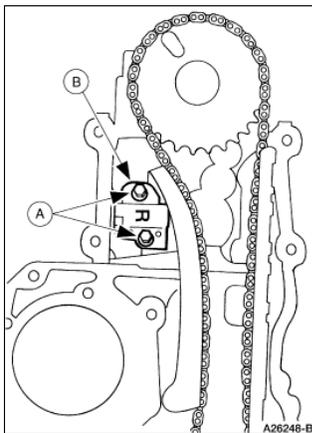
6. On WEP engines, install the (A) Camshaft Holding Tool on the (B) camshaft.



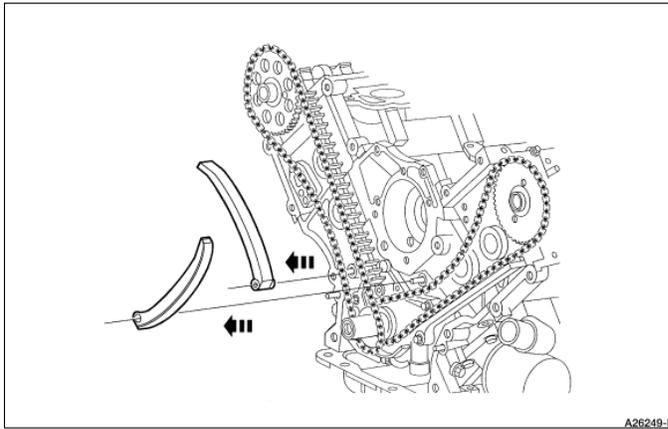
7. Remove the (A) LH timing chain tensioner bolts and the (B) LH timing chain tensioner.



8. Remove the (A) RH timing chain tensioner bolts and the (B) RH timing chain tensioner.



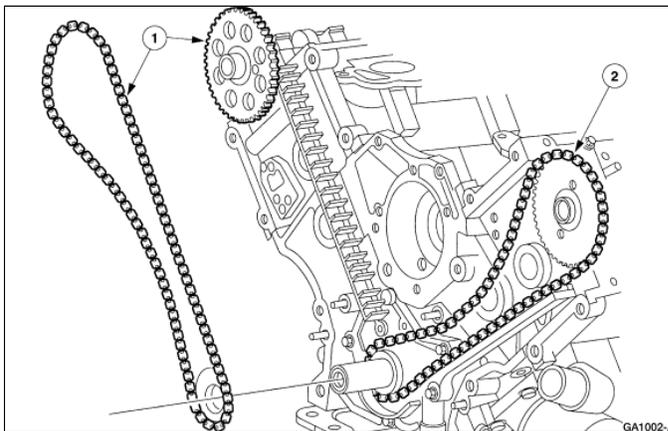
9. Remove the LH and RH timing chain tensioner guides from the dowel pins.



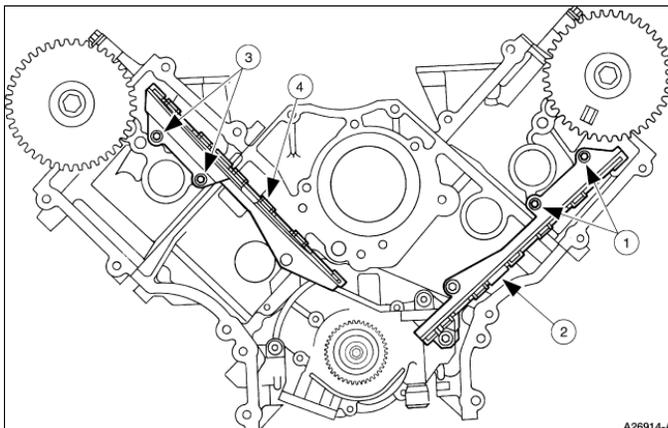
10. **CAUTION:** At no time, when the timing chains are removed and the cylinder heads are installed may the crankshaft or camshaft be rotated. Severe piston and valve damage will occur.

Remove the RH and LH timing chains and crankshaft sprockets.

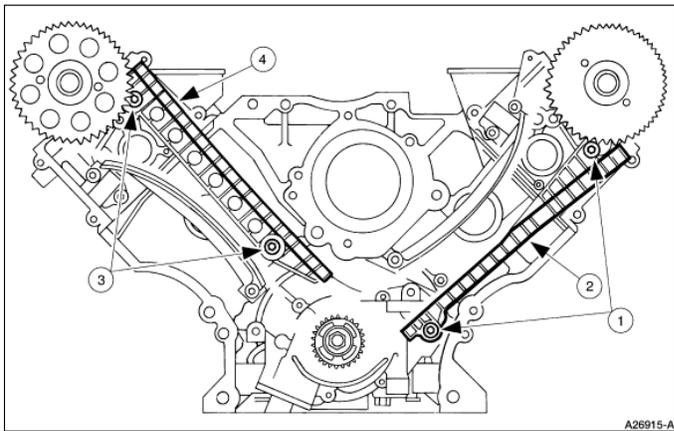
1. Lift RH timing chain off of the camshaft sprocket and slide the timing chain and crankshaft sprocket off of the crankshaft.
2. Lift the LH timing chain off of the camshaft sprocket and slide the timing chain and the crankshaft sprocket off of the crankshaft.



11. On REP engines, remove the chain guides.
1. Remove the LH timing chain guide bolts.
  2. Remove the LH timing chain guide.
  3. Remove the RH timing chain guide bolts.
  4. Remove the RH timing chain guide.



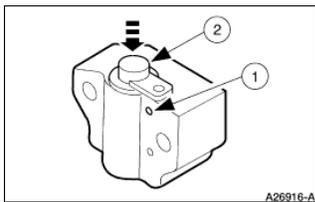
12. On WEP engines, remove the chain guides.
1. Remove the LH timing chain guide bolts.
  2. Remove the LH timing chain guide.
  3. Remove the RH timing chain guide bolts.
  4. Remove the RH timing chain guide.



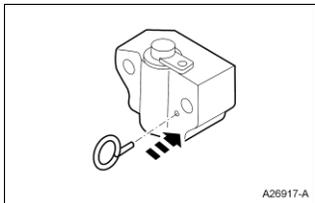
**Installation**

**CAUTION:** Timing chain procedures must be followed exactly or damage to valves and pistons will result.

1. Compress the timing chain tensioners (6L266).
  1. Release the lock assembly on the timing chain tensioners.
  2. Compress the timing chain tensioners.

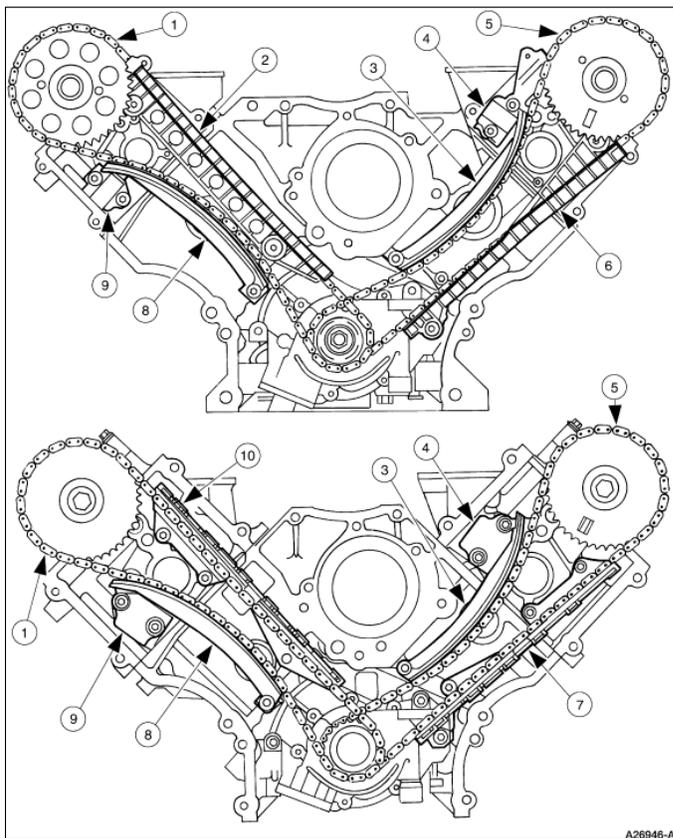


2. Install the retaining pins.



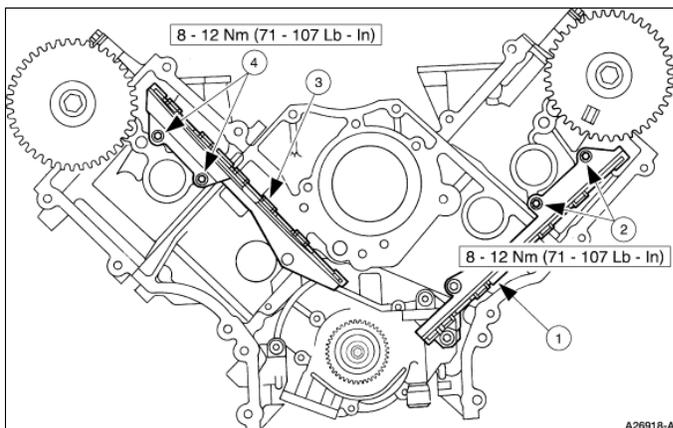
3. Check the following components for part number orientation.

Item	Part Number	Description
1	6268	Timing Chain/Belt (RH)
2	—	RH Timing Chain Guide (WEP)
3	6L253	Timing Chain Tensioner Arm (LH)
4	6L266	Timing Chain Tensioner (LH)
5	6268	Timing Chain/Belt (LH)
6	—	LH Timing Chain Guide (WEP)
7	6K297	Timing Chain Guide, (REP) RH
8	6L253	Timing Chain Tensioner Arm (RH)
9	6L266	Timing Chain Tensioner (RH)
10	6K297	Timing Chain Guide, (REP) RH



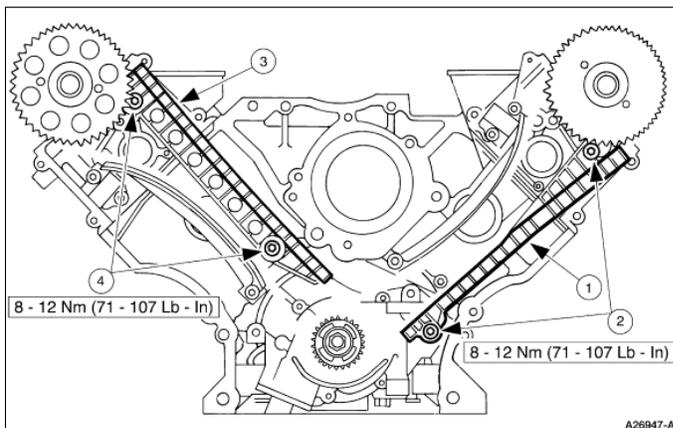
A26948-A

4. On REP engines, install the timing chain guides.
1. Position LH timing chain guide.
  2. Install and torque the LH timing chain guide bolts.
  3. Position the RH timing chain guide.
  4. Install and torque the RH timing chain guide bolts.

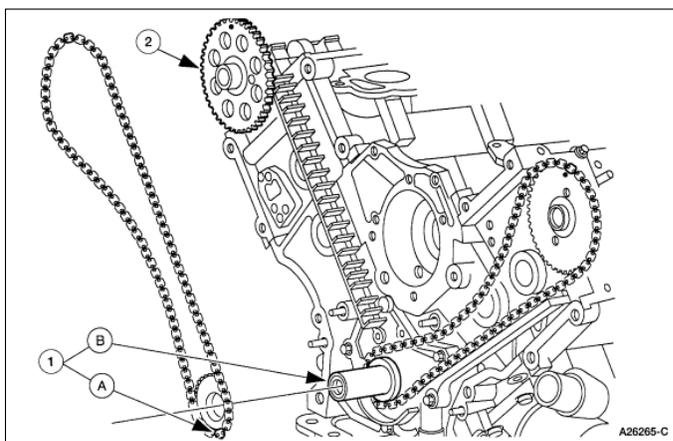


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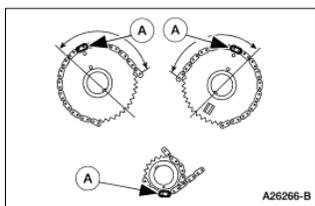
5. On WEP engines, install the timing chain guides.
1. Position the LH timing chain guide.
  2. Install and torque the LH timing chain guide bolts.
  3. Position the RH timing chain guide.
  4. Install and torque the RH timing chain guide bolts.



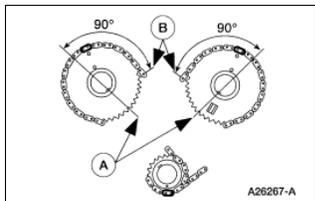
6. Install the timing chain/belts (6268) and crankshaft sprockets (6306).
  1. Slide the (A)crankshaft sprocket onto the (B) crankshaft, aligning the copper link on the timing chain/belt with the dot on the crankshaft sprocket.
  2. Position the timing chain/belt over the camshaft sprocket, aligning the copper link with the dot on the camshaft sprocket.



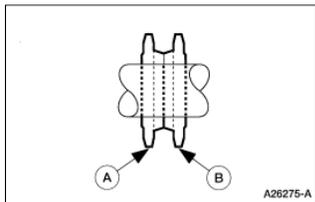
7. Make sure that the (A) copper marks on the timing chain/belts are lined up with the corresponding dots on the crankshaft and camshaft sprockets.



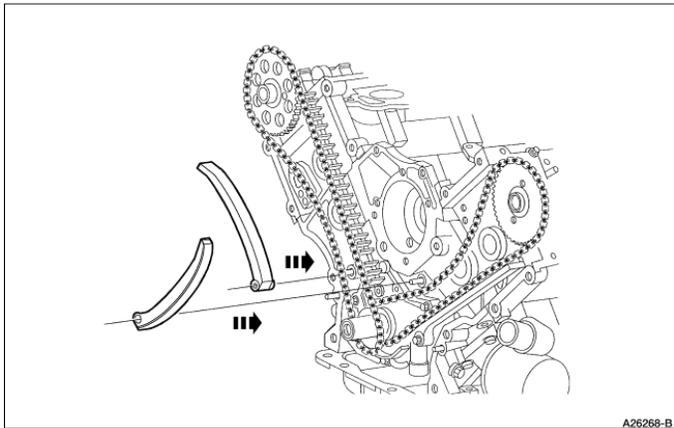
8. Make sure that the (A) camshaft sprocket keyway is 90° from the (B) cam cover mounting surface.



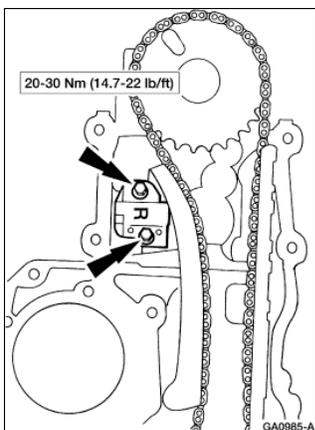
9. Make sure that the (A) RH timing chain sprocket is on the front of the (B) LH timing chain sprocket with the hubs facing each other.



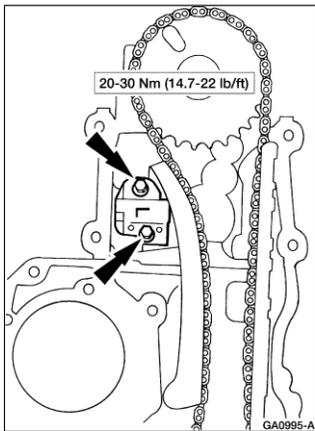
- Position the LH and RH timing chain tensioner guides on the dowel pins.



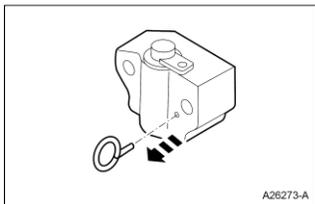
- Position the RH timing chain tensioner and install the timing chain tensioner bolts.



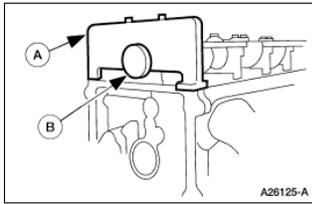
- Position the LH timing chain tensioner and install the timing chain tensioner bolts.



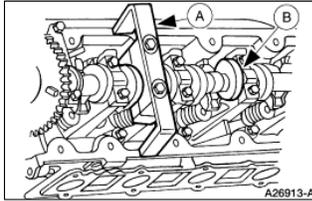
- Remove both the RH and LH retaining pins from the timing chain tensioners.



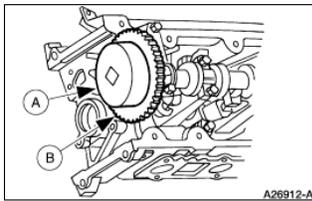
- On REP engines, remove (A) Cam Positioning Tool and the Camshaft Positioning Tool Adapters on the (B) camshaft (6250).



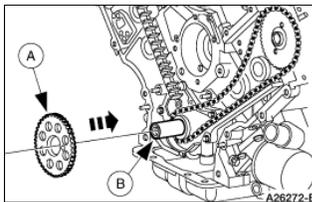
15. On WEP engines, remove the (A) Camshaft Holding Tool from the (B) camshaft.



16. On WEP engines, remove the (A) camshaft positioning tool from the (B) camshaft.



17. Install the (A) crankshaft sensor ring on the (B) crankshaft.



18. Install the engine front cover; refer to the procedure in this section.
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