



# Service Repair Manual

## **Models**

# C27 Industrial Engine

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Product: INDUSTRIAL ENGINE  
Model: C27 INDUSTRIAL ENGINE RAM  
Configuration: C27 Industrial Engine RAM00001-UP

## Disassembly and Assembly C27 and C32 Industrial Engines

Media Number -KENR8167-05

Publication Date -01/08/2015

Date Updated -30/04/2018

i05933887

## Gear Group (Front) - Remove

SMCS - 1206-011

## Removal Procedure

Table 1

Required Tools			
Tool	Part Number	Part Description	Qty
A	8S-2241	Camshaft Bearing Tool Group	1
	6V-4869	Adapter	1
	6V-6174	Plug	1

### Start By:

- Remove the front housing. Refer to Disassembly and Assembly, "Housing (Front) - Remove".

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### NOTICE

**Keep all parts clean from contaminants.**

**Contaminants may cause rapid wear and shortened component life.**

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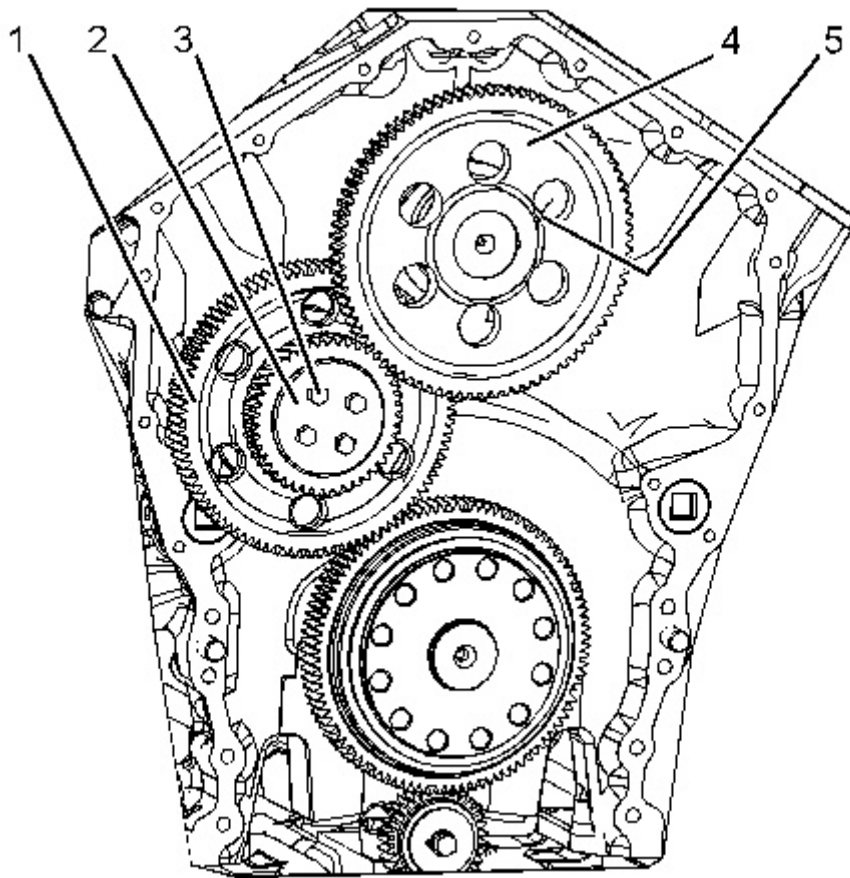


Illustration 1

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1. Remove bolts (5) and gear assembly (4).
2. Remove bolts (3) and plate (2). Remove gear assembly (1).

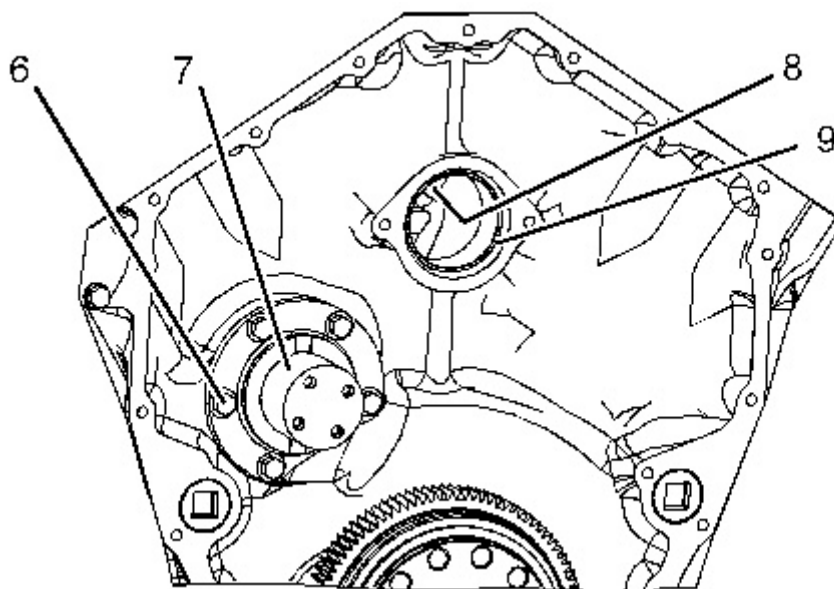


Illustration 2

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3. Remove bolts (6) and shaft (7).

**Note: The crankshaft will have to be removed to remove and install bushings (8) and (9).** Refer to Disassembly and Assembly, "Crankshaft - Remove".

4. If necessary, use Tooling (A) to remove bushing (8) and (9).

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## Disassembly and Assembly C27 and C32 Industrial Engines

Media Number -KENR8167-05

Publication Date -01/08/2015

Date Updated -30/04/2018

i06280625

## Gear Group (Front) - Install

SMCS - 1206-012

## Installation Procedure

Table 1

Required Tools			
Tool	Part Number	Part Description	Qty
A	8S-2241	Camshaft Bearing Tool Group	1
	6V-4869	Adapter	1
	6V-6174	Plug	1

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### NOTICE

**Keep all parts clean from contaminants.**

**Contaminants may cause rapid wear and shortened component life.**

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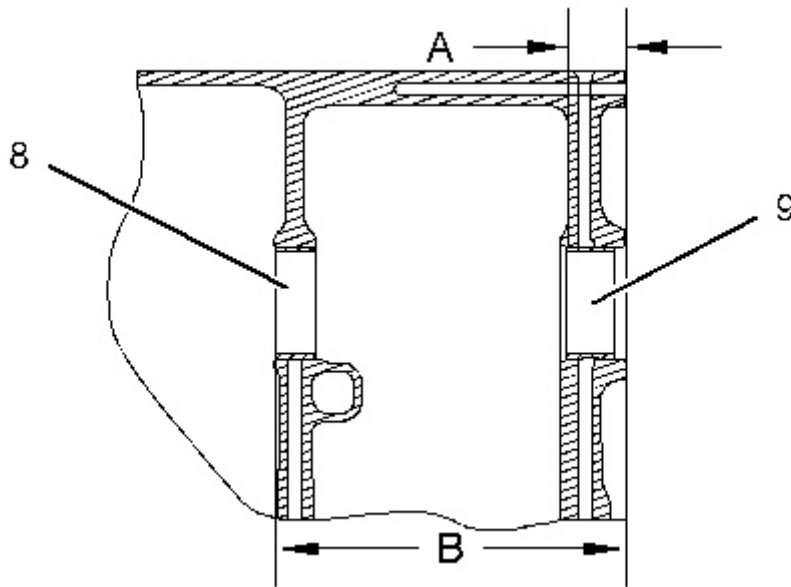


Illustration 1

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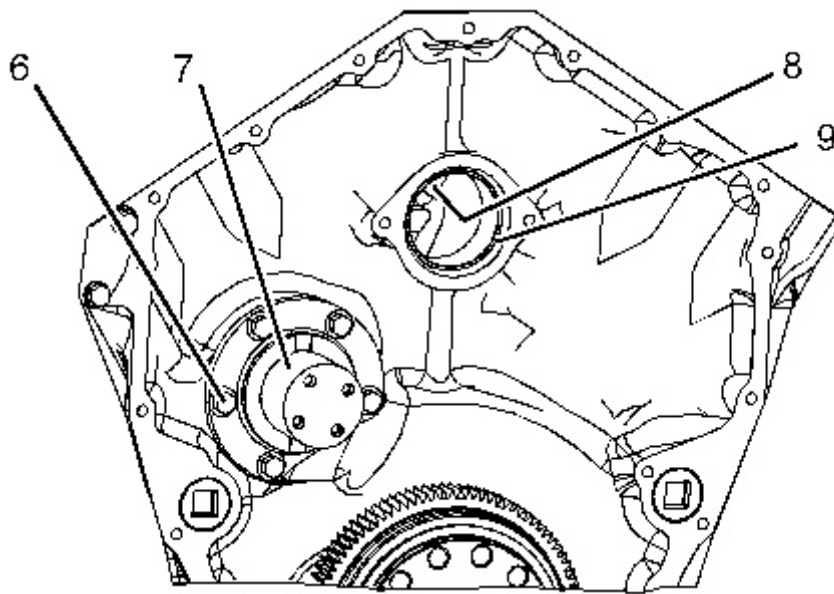


Illustration 2

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1. Use Tooling (A) to install bushings (8) and (9) . Install bushing (8) to a Dimension (B) . Dimension (B) is  $236.7 \pm 0.5$  mm ( $9.32 \pm 0.02$  inch). Install bushing (9) to a Dimension (A) . Dimension (A) is  $40.4 \pm 0.5$  mm ( $1.59 \pm 0.02$  inch). Install the crankshaft. Refer to Disassembly and Assembly, "Crankshaft - Install".
2. Apply clean engine oil to shaft (7) , the bearing bore, and the thrust faces prior to installation. Install shaft (7) and bolts (6) . Tighten bolts (6) to a torque of  $55 \pm 10$  N·m ( $41 \pm 7$  lb ft).

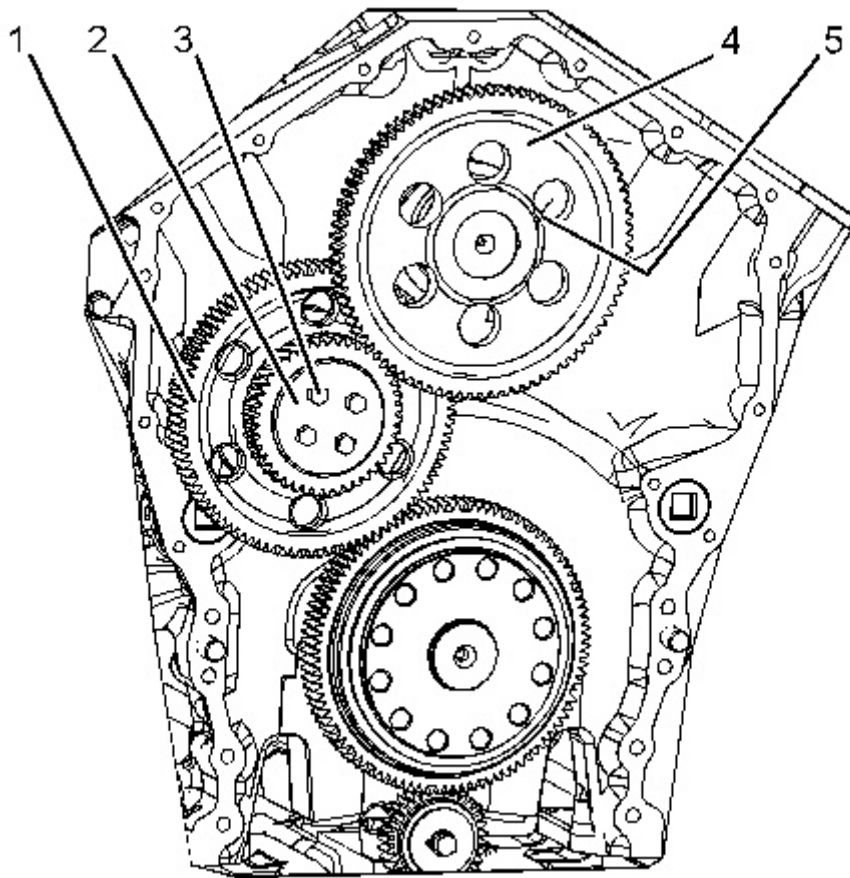


Illustration 3

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3. Position gear assembly (1) on the shaft. Install plate (2) and bolts (3) .
4. Install gear assembly (4) and bolts (5) .

**End By:** Install the front housing. Refer to Disassembly and Assembly, "Housing (Front) - Install".

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