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install a 3 8 in 24 nf bolt 1 2 in 12 7 mm long in one of the holes in the drive gear put a torque wrench on this bolt with the wrench in a line with the center of the drive gear and give it a torque of 45 to 50 lb ft 60 to 70 n m in a clockwise direction as seen from the front of the engine

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