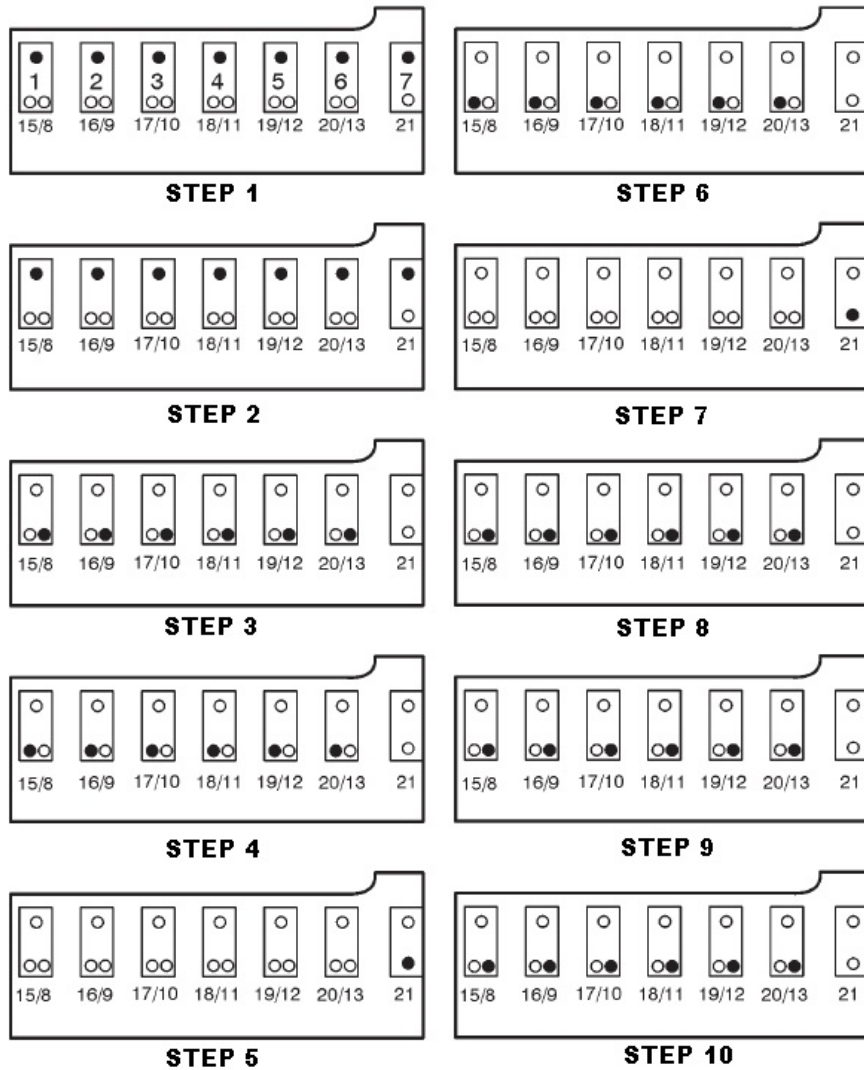




Camshaft Cap Installation for 2004-2015 Mack MP8 & 10 Diesel Engines

The AERA Technical Committee offers the following information regarding the camshaft cap installation procedure for 2004-2015 Mack MP8 & 10 diesel engines. The process is somewhat lengthy and must be followed to prevent rocker shaft damage or breakage.

The proper torque sequence and procedure will assure the rocker shaft is installed without bend or distortion occurring. Be sure to lubricate the rocker and camshaft journals with clean engine oil before installing them in their bores.



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- Step 1. Tighten bolts 1–79-13 ft/lbs (12-18 Nm)
- Step 2. Angle tighten bolts 1–7Rotate 85-95 degrees
- Step 3. Tighten bolts 11, 10, 12, 9, 13, 8 in gradual steps to contact67-81 ft/lbs (90-110 Nm)
- Step 4. Tighten bolts 15–2033-41 ft/lbs (45-55 Nm)
- Step 5. Tighten bolt 21 40-48 ft/lbs (55-65 Nm)
- Step 6. Angle tighten bolts 15–20Rotate 115-125 degrees
- Step 7. Angle tighten bolt 1Rotate 95-105 degrees
- Step 8. Loosen bolts 8–13
- Step 9. Tighten bolts 8–1333-41 ft/lbs (45-55 Nm)
- Step 10. Angle tighten bolts 8–13Rotate 115-125 degrees