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.
Step 1. Tighten bolts 1–7 ................................................................. 9-13 ft/lbs (12-18 Nm)

Step 2. Angle tighten bolts 1–7 .......................................................... Rotate 85-95 degrees

Step 3. Tighten bolts 11, 10, 12, 9, 13, 8 in gradual steps to contact .......... 67-81 ft/lbs (90-110 Nm)

Step 4. Tighten bolts 15–20 ................................................................. 33-41 ft/lbs (45-55 Nm)

Step 5. Tighten bolt 21 ..................................................................... 40-48 ft/lbs (55-65 Nm)

Step 6. Angle tighten bolts 15–20 .......................................................... Rotate 115-125 degrees

Step 7. Angle tighten bolt 1 .................................................................. Rotate 95-105 degrees

Step 8. Loosen bolts 8–13

Step 9. Tighten bolts 8–13 ................................................................... 33-41 ft/lbs (45-55 Nm)

Step 10. Angle tighten bolts 8–13 ............................................................. Rotate 115-125 degrees