

Enginetech Inc
Tech Assistance 800-410-3664 ext. 340 or 237

TECHNICAL BULLETIN	
	May 2004
	TB 2163
Mfg:	CHRYSLER
Model:	DODGE
Liter:	5.9L
V I N:	6
Year:	98-04

Camshaft Gear Replacement For
1985-2003 Cummins B Series 5.9L Diesel Engines

The AERA Technical Committee offers the following information regarding camshaft gear replacement for 1985-2003 Cummins B Series 5.9L diesel engines. Throughout the use of this engine two methods have been used to retain the gear to the camshaft.

One method simply requires sufficient interference between the gear and camshaft snout diameter. The other uses an interference fit plus a bolt and washer. The proper disassembly, checking, heating of the gear and reassembly listed below must be followed for proper operation.

Disassembly;

1. ☐ Remove camshaft bolt and washer.
2. ☐ Remove gear and camshaft key.

Assembly;

1. ☐ Install key into camshaft.
2. ☐ Lubricate camshaft surface, using Lubriplate #105.
3. ☐ Heat gear for non-bolted 1991 camshafts to oven temperature 300°F (149°C).
4. ☐ Heat gear for bolted 1991 camshafts and 1994 automotive to an oven temperature 350°F (177°C).
5. ☐ Install timing gear with timing marks away from the camshaft.
6. ☐ Verify gear is seated against camshaft shoulder.
7. ☐ Install camshaft bolt and washer if required and torque to 20 ft/lbs, and then rotate cap screw an additional 180°.

Caution; Camshaft gear will be permanently distorted if overheated. The oven temperature should never exceed 350°F (177°C)

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Note A; If frets or burrs cannot be removed with Scotch-Brite 7448, or equivalent, replace the camshaft.

Note B; Bolted camshafts where only used on 1991 engines equipped with an in-line pump.

The AERA Technical Committee

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