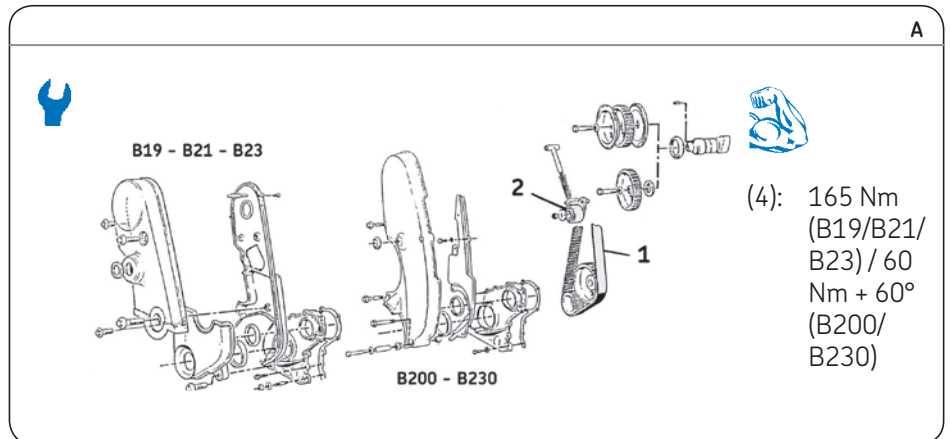


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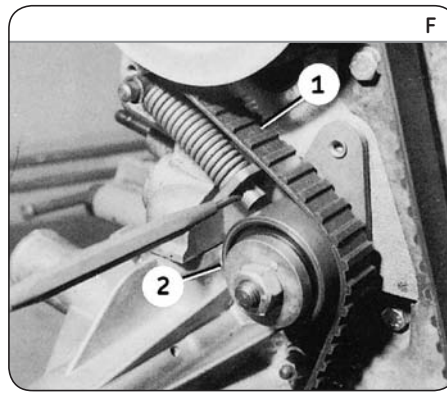
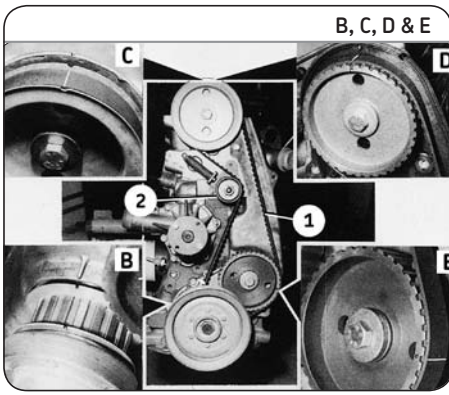


Removal

- 1) Disconnect the battery according to the vehicle manufacturing guidelines.
- 2) Prepare the vehicle for the timing replacement according to the vehicle manufacturing guidelines.
- 3) Clamp flywheel, then remove crankshaft pulley.
- 4) Remove timing covers.
- 5) Bring engine to timing position (cylinder N° 1 at TDC) and check that:
 - Mark on crankshaft sprocket is aligned with mark on engine (**Fig. B**),
 - Mark on camshaft sprocket is aligned with mark on cylinder head as shown in **Fig. C** (for motor types B19, B21, and B23) or in **Fig. D** (for motor types B200 and B230).
- 6) Loosen tensioning pulley nut.
- 7) Compress spring of tensioning pulley by pulling on belt run opposite tensioning pulley. With spring thus compressed, jam tensioning pulley using a 3 mm rod (**Fig. F**) or retighten tensioning pulley nut.
- 8) Remove timing belt (**1**).
- 9) Remove tensioning pulley (**2**).

Install Confidence





Refitting

Caution! First carefully clean thoroughly the bearing surfaces of the rollers and of the tensioning device.

- 10) Fit new tensioning pulley (2) in disengaged position.
- 11) Check direction of arrow on new timing belt (1), then fit belt by passing it first around crankshaft and intermediate shaft sprockets and then around camshaft sprocket and tensioning pulley.
- 12) Check alignment of timing marks on belt (1) with those on sprockets (Fig. B, C, D and E).
- 13) Release nut of tensioning pulley (2), so pulley automatically tensions timing belt, then retighten nut.
- 14) Turn crankshaft clockwise through 2 turns
- 15) Check again that timing marks on belt (1) are aligned with those on sprockets (Fig. B, C, D and E).
- 16) Release nut of tensioning pulley nut, then retighten.
- 17) Check the tension of the belt (1).
- 18) Refit timing covers.
- 19) Clamp flywheel and refit crankshaft pulley. Tighten pulley bolt (4) to **165 Nm** for motor types B19, B21 and B23 or to **60 Nm + 60°** for motor types B200 and B230.
- 20) Refit the removed elements in reverse order to removal :
- 21) Fill the cooling circuit with the permanent fluid recommended.
- 22) Check the circuit's leak-tightness when the engine reaches its running temperature and secure the level of coolant when the engine is at ambient temperature (20 °C).

Notice: Always follow the vehicle manufacturer instructions when working on the engine. The SKF KITS are designed for the automotive repair professional and must be fitted using tooling used by these professionals. These instructions are to be used as a guideline only. This document is the exclusive property of SKF. Any representation, partial or full reproduction, is forbidden without prior written consent from SKF.

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