A Division of Thiessen Products, Inc.

Instruction Sheet For #1011-36TB



Cam BUSHING INSTALLER & DRILLING JIG

Use for JIMS® bushing No.25581-36 & 25597-36.
Use on Big Twin 1936-69.

1. Refer to H.D.® Service Manual to remove old bushing.
2. After removal of bushing, measure I.D. of bushing hole. Standard hole will measure 1.000 +/- .001, this will give a standard bushing a press fit of approximately .0035. Use oversize bush ing as needed.
3. Before installing new bushing, mark location of old dowel pin hole on face of bushing hole in cam cover or case.
4. Apply a press fit lube, to bushing O.D. support cam cover or case on flat surface of arbor press.
5. Using installer tool, press bushing into cam cover or case until bushing bottoms on cover. With tool still in bushing rotate tool until drilling hole is at least .250 from the old dowel pin hole, as indicat ed by the mark you put on surface before drilling bushing.
6. Using the #31 drill supplied with tool, while keeping the tool from turning, drill to a depth of .280 from top bushing. Drive in new dowel pin to no more than .020 below bushing top.
7. Using a 1/8 flat punch peen over the dowel pin hole, remove any burrs from face of bushing.
8. Drill oiling hole at top of bushing using 5/32 drill through boss in cam cover, through one wall only. Ream cam bushing per H.D.® Service Manual.

CAUTION: Wear safety glasses. Excessive force may damage parts! ,See JIMS® catalog for over 100 other top quality professional tools. The last tools you will ever need to buy.