A Division of Thiessen Products, Inc.

Instruction Sheet For #1012-70TB



CAM BUSHING INSTALLER & DRILLING JIG

Use on Big Twin 1970-Present for JIMS® bushing 25581-70

1. Refer to H-D® Service Manual to remove old bushing from cam cover with a bushing driver that has a O.D. of 1.125 or by using JIMS® tool #1005. Remove seal first.
2. Mount cam cover to JIMS tool #1005. After removal of bushing, measure I.D. of bushing hole. Standard hole will measure 1.199 +/-.001, this will give a standard bushing a press fit of approximately .0035. Use oversize bushing as needed.
3. Before installing JIMS new bushing, mark location of old dowel pin hole on face of bushing hole in cam cover.
4. Apply a press fit lube, to bushing O.D. support cam cover on flat surface on arbor press.
5. Using installer tool, press bushing into cam cover 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 indicated by the mark you put on surface before installing 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 a 5/32 drill through boss in cam cover through one wall only.
9. Line ream cam bushing using JIMS cam cover bushing reamer tool #1023-70 and follow 1023-IS reamer instructions.

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

"From the Track... To the Street!"

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