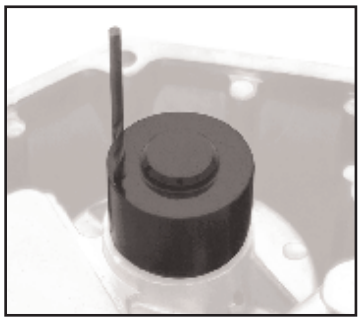
A Division of Thiessen Products, Inc.

Instruction Sheet For #1018-37TB





Pinion Shaft BUSHING INSTALLER & DRILLING JIG

Use for JIMS® bushing No.25582-36.

Use on Big Twin 1936-53.

1. Refer to H.D.® Service Manual to remove old bushing from cam cover with a bushing driver that has an O.D. of 1.125 or by using JIMS® tool #1005.
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 .003. Use oversize bushing as needed.
3. Before installing new bushing, mark location of old dowel pin hole on face of bushing hole on cam cover. Also mark location of oil feed hole on cam cover and at the same time mark on top of bushing for the center of window on side of bushing.
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 bush ing rotate tool until drilling hole is at least .250 from the old dowel pin and oil feed hole, as indicated by the marks you put on surface before installing bushing.
6. Using the #31 drill supplied with tool, while keeping 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. Line ream pinion bushing using JIMS® pinion line reamer #1045-37.

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.

555 Dawson Drive, Camarillo, CA 93012 Phone 805-482-6913 • Fax 805-482-9224