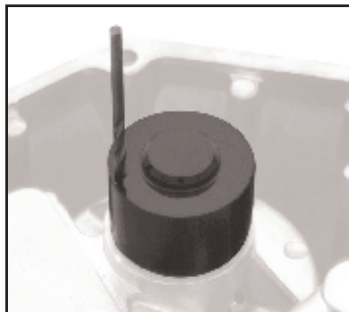




A Division of Thiessen Products, Inc.

## INSTRUCTION SHEET FOR #1015-37TB



### PINION SHAFT BUSHING INSTALLER & DRILLING JIG

USE FOR JIMS® BUSHING NO.25591-37.

USE ON 74" & 80" SIDEVALVES 1937-48.

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  $.9375 \pm .001$ , this will give a standard bushing a press fit of approximately  $.0035$ . 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 top of bushing for center of oil feed window on side of bushing. Mark the oil feed hole location on 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 with window on side of bushing aligned with oil feed hole in cam cover until bushing bottoms on cover. With tool still in bushing rotate tool until drilling hole is at least from old dowel pin hole and oil feed hole, as indicated on by the marks you put on surface before drilling hole.
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. 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.