



Instruction Sheet For #1016-37TB



Pinion Shaft BUSHING INSTALLER & DRILLING JIG

Use for JIMS® bushing No.25593-37 and No.25593-57.

Use on 45" 1937-73.

Use on XL 1957-76.

1. Refer to H.D.® Service Manual to remove old bushing from cam cover.
2. After removal of bushing, measure I.D. of bushing hole. Standard hole will measure $.875 \pm .001$, 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, press 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 and oil feed hole, as indicated 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 of 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. Ream pinion bushing per H.D.® Service Manual. Use JIMS® reamer #94812-37A.

CAUTION: Wear safety glasses. Excessive force may damage parts and tool.
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The last tools you will ever need to buy.