

INSTRUCTIONS

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913-81106 - LS Cam Bearing Installation Tool

NOTE: As a matter of personal preference bearings can be replaced from front to rear or from rear to front. Bearing size positions are numbered from front to rear. Make certain that bearings are in their proper location and that oil holes are aligned with groove in block, per manufacturers specifications, or engine damage may result.

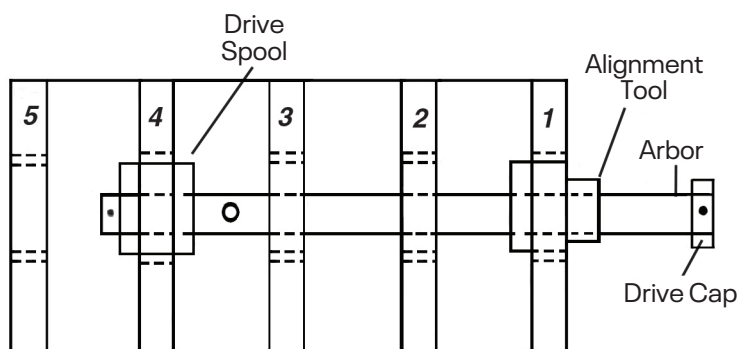
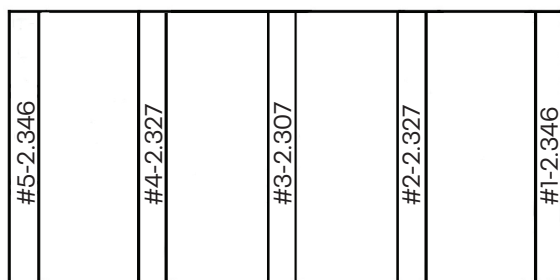
Remove Old Cam Bearings:

1. Insert the o-ring side of the tapered alignment spool into the front cam bearing.
2. Carefully slide drive arbor through the alignment spool toward rear of block.
3. Insert the o-ring side of drive spool into the #5 cam bearing.
4. Engage drive arbor into drive spool, strike drive cap end of drive arbor to remove the rear cam bearing and Welch plug.
5. Repeat for bearing #'s 4, 3, and 2.
6. Remove alignment spool & drive arbor from front cam bearing and position tapered end of alignment spool into the rear cam bearing bore of block.
7. Engage drive arbor & drive spool into bearing #1, and drive it out of front of block.

Install New Cam Bearings:

IMPORTANT: Thoroughly clean block of any debris. Ensure cam bore surfaces are free of nicks, scratches, or other damage. Lightly lubricate bearing bores and o-rings with oil.

1. Position tapered end of alignment spool into the rear cam bearing bore of block.
2. Insert drive arbor through alignment spool toward the front of the block.



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3. Install #1 bearing on drive spool, position drive spool (with bearing) into cam tunnel between 1st and 2nd bulkhead, engage drive arbor into drive spool.
4. Maintain pressure on tapered alignment spool to keep it centered in rear bearing bore, position oil hole of bearing in proper orientation and gently tap drive cap end of drive arbor with a soft mallet until bearing is centered in bulkhead (oil hole aligned).

CAUTION: Do not use excessive force. If it feels tight stop and double check bearing dimensions and alignment before proceeding.

5. Insert the o-ring side of the tapered alignment spool into the front cam bearing.
6. Carefully slide drive arbor through the alignment spool toward rear of block.
7. Install #5 bearing on drive spool, position drive spool (with bearing) into cam tunnel between 4th 5th bulkhead, engage drive arbor into drive spool. Position bearing and gently tap into place until oil hole is properly aligned.
8. Repeat previous step for bearing #'s 4, 3, and 2.

IMPORTANT

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