Wipe Out Enterprises Inc.

Work Instructions

Document # WOEI-0001 WOEI Idler Bushing

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Approved Date: Dave Waesch (August 5th, 2015)

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PURPOSE:

Installation of the WOEI 5/8" Idler Bushing into the Front Cover

See Instructions WOEI-H017 for machine work to block for 5/8" threads.

TOOLS:

An O-Ring PIC is needed to install internal O-rings in the Idler Bushing

Torque Wrench

15/16" socket

INSTALLATION PACKAGE CONTENTS:

(1) 5/8 bolt 3.5" long grade 8

(1) 5/8 case hardened washer

(1) 5/8-11X2 SHCS Only on AG Front Cover

Idler bushing – WOEI Part Number #023-0021-00-IH

Idler bushing – Tie Down Front Cover 023-0025-00-IH

Idler bushing- Ag Front Cover 023-0011-00-IH

(2) O-rings, 124 and 208

Reuse bearings, shim, and spacer from stock application

OTHER:

The front cover Idler hole will need to be modified to match the WOEI print 005-0039-00-IH

INSTALLATION STEPS:

1) Install O-ring 208 into the inside grove of the bushing. (lubricate O-ring with oil.)



2) Install O-ring 124 on the outside groove of the bushing.



023-0021-00-IH Is shown in the picture above

3) Insert Idler Bearing onto bushing.



4) Insert the bearing spacer onto the bushing against the bushing.





023-0025-00-IH 023-0011-00-IH no O-rings will be needed

5) Install idler gear onto the bearing on the bushing.



6) Install 2nd bearing onto the other side of the bushing.

7) Place the shim on the bushing against the rear bearing. Shim may not be needed fit check on assembly.



8) Place washer on 3.5” bolt, insert bolt into bushing and continue to turn bolt until flush with front part of bushing.



9) Clean bolt threads and apply 242 Loctite (blue) to bolt threads.

10) Line up timing marks on crank and idler gears and insert the bolt into engine block idler space.



11) Torque 3.5”
    a. 5/8 Bolt to 155 ft/lbs
    b. 3/4 Bolt to 165 ft/lbs
12) After Installation is completed, the Backlash will need to be checked
    a. Should measure approx... .005” with Dial Gauge

13) Install modified front timing cover.



14) Finish the front cover installation.

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