Wipe Out Enterprises Inc.

Work Instructions

Document # WOEI-0043 IH DT 466 Adjustable Cam Gear Installation

Originator: BH

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PURPOSE:

Proper Procedure for installing a WOEI IH DT 466 Adjustable Cam Gear

TOOLS/COMPONENTS:

Torch with a Rosebud Tip
Channel Lock Pliers
Vice
Steel Table
TIG Welder
Right Angle Grinder
Engine oil
Hammer
Drill press
82° chamfering tool
Torx Socket T40
Press

Instructions:

1. If cam is still in engine remove it.
2. Remove stock gear and thrust plate. (use a press to press off the gear)
3. Grind a bevel on the end of your cam shaft.



4. Install the key in end of cam if not already in.




5. Place cam in a press.
6. Apply oil to end of cam in the thrust plate area.
7. Place thrust plate on cam with the chamfers facing the gear end of cam.




8. Place the gear hub heated in oil or on a steel table and heat with a torch.



9. When hot use channel lock pliers to pick up hub and slide onto the end of the cam shaft. Press hub down onto cam. (make sure it goes all the way down and sets on the step on cam). Press on with cam hub.



10. If the hub does not go all the way to the step on cam use a press to press it back off and repeat step 7.
11. With the hub setting on the step of cam and still warm check the clearance between the thrust plate and hub speck is .002”-.010”. If the clearance is in speck TIG weld the groove between the hub and cam shaft. (Start at the key and go all the way around back to the key) do not weld in the key area. Let the cam cool. **Keep your weld small if the weld is big you will have to sand back off.**



12. When the cam cools try the gear on the hub you may have to sand the hub for clearance.

Spacer plate

1. Remove the front cover spacer plate.



2. Take the front cover spacer plate and chamfer the two bold holes around the cam that hold the plate to the engine block, make the chamfer deep enough so the bolt head is flush when in hole.



Assembly

3. Reinstall front cover spacer plate use 242 loctite on bolts torque to 20 FT LBS.
4. Install cam per WOEI-0034 Installing Cam Shaft DOC.
5. Degree cam per WOEI-0016 IH Cam Degreeing DOC.
6. Loctite the six 3/8” bolts and torque to 35 to 40 FT LBS.
7. Wipe off tools and put them away.
8. Enter labor and parts on the labor and expense spreadsheet, for customer the work was done for.