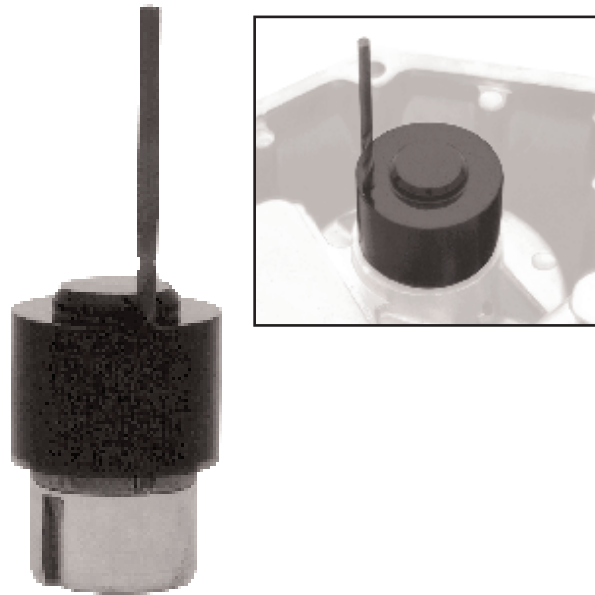




A Division of Thiessen Products, Inc.

## INSTRUCTION SHEET FOR #1013-54TB



### PINION BUSHING INSTALLER & DRILLING JIG

USE FOR JIMS® BUSHING No.25582-54/73. USE ON BIG TWIN 1954-92

1. Refer to H-D® Service Manual to remove old bushing, or use JIMS® tool #95760-TP for easy removal. With cam cover mounted in JIMS® tool #1041-TC.
2. After bushing is removed, measure hole for the right size bushing. Standard cover hole diameter is 1.001". A standard bushing will have a press fit of .0035. Use oversize bushing as needed.
3. Before installing new bushing, mark the top of bushing for the style of oiling you are using. If it is a JIMS® bushing, mark both style oiling locations.
4. Align either the slot for end oiling 1973 through 1992 with oil feed in cam cover or align side oil hole to cam cover for side feed oiling 1954 through 1972.
5. Apply a press fit lube, to bushing O.D. Support cam cover on flat surface, (or use JIMS cam cover holding tool #1041-TC) on arbor press. Using installation tool, press bushing into cam cover until tool bottoms on cam cover surface.
6. With tool still in bushing, rotate tool until drilling hole is at least .250 from the marks you put on top of bushing and any other old pin holes.
7. Using the #31 drill supplied and while keeping tool from turning, drill to a depth of .280 from top bushing.
8. Drive in new dowel pin to no more than .020 below bushing top. Using a 1/8 flat punch, peen over the dowel pin hole. Be sure that oil feed hole is open to bushing I.D.
9. Now is the time to line ream the new bushing with JIMS tool #94805-57.

**CAUTION: WEAR SAFETY GLASSES. EXCESSIVE FORCE MAY DAMAGE PARTS AND TOOL.**

SEE JIMS® CATALOG FOR OVER 100 OTHER TOP QUALITY PROFESSIONAL TOOLS.

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