



A Division of Thiessen Products, Inc.

# INSTRUCTION SHEET FOR TOOL #94805-57



## PINION BUSHING LINE REAMER

FOR LINE REAMING PINION SHAFT BUSHING ON 1954-1999 BIG TWIN  
USE ON SPORTSTER IDLER GEAR BUSHING - 1957-EARLY 1984 AND 45" - 1937-73

1. Refer to H-D® Service Manual to remove old bushing. Use JIMS® No.1698 TAP MAGIC cutting fluid when performing bushing reaming.
2. Install new bushing using JIMS tool No.1016-37TB Pinion Bushing Installer, Drilling Jig (or refer to H-D Service Manual.)
3. Pinion bushing must be line-reamed after new bushing is installed and pinned, from the right case race. After you have fit the right case race for new bearings.
4. Assemble cam cover onto the right case with at least 4 mounting screws, torque to 90-120 in-lb.
5. Apply a small amount of JIMS No.1698 cutting fluid to O.D. of the pilot you are using. The pilot laser-marked "A" is for Big Twin 1958 thru 1999. Pilot laser-marked "B" is for Big Twin thru 1957. With a full coating of cutting fluid, slip reamer through pilot and rotate pilot clockwise with firm downward pressure from flywheel side of race.
6. Apply a full coat of cutting fluid on the cutting end of reamer shaft. Also apply a small amount of lube on the pilot end of the shaft.
7. Use a 3/8" 12 point socket to turn reamer clockwise with light inward pressure until the reamer is through the bushing, continue to turn clockwise but with outward pulling pressure, slowly until reamer is clear of bushing.
8. This will give you a bushing I.D. size of .5625" to .5630". If using a JIMS pinion shaft you will have a running fit between .0005" to .0015". If you like a little more clearance, run the reamer with cutting fluid through the pilot and bushing a few more times to get the desired fit you like. See H-D Service Manual for specifications.
9. Your bushing is now line reamed within .0006", or better, to centerline of the right case race.
10. Wash all bushing metal from cover and tool and then oil tool.
11. Store this precision tool as you would one of your micrometers, for a lifetime of service.



PARTS AVAILABLE SEPARATELY			
No.	Qty.	Description	Part No.
1	1	REAM	94805-57-1
2	1	PILOT 1 3/4	94805-57-2
3	1	PILOT 1 3/8	94805-57-3

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