



Instruction Sheet For #1017-37TB



Cam BUSHING INSTALLER & DRILLING JIG

Use for JIMS® bushing No.25586-37.

Use on Sportster 1954-90, 45" models 1937-73, 74" & 80" Sidevalves 1937-48.

1. Refer to H.D.® Service Manual to remove old bushing from cam cover.
2. After removal of bushing, measure I.D. of bushing hole. Standard hole will measure $.8375 \pm .001$, this will give a standard bushing a press fit of approximately $.0035$. Use oversize bushing as needed.
3. Before installing new bushing, mark location of old dowel pin hole on face of bushing hole in cam cover.
4. Apply a press fit lube, like JIMS® #2124, to bushing O.D., support cam cover on flat surface on arbor press.
5. Using installer tool, press bushing into cam cover until bushing bottoms on cover. With tool still in bushing rotate tool until drilling hole is at least $.250$ from the old dowel pin hole, as indicated by the mark you put on surface before drilling bushing.
6. Using the #31 drill supplied with tool, while keeping the tool from turning, drill to a depth of $.280$ from top bushing. Drive in new dowel pin to no more than $.020$ below bushing top.
7. Using a $1/8$ flat punch peen over the dowel pin hole, remove any burrs from face of bushing.
8. Drill oiling hole at top of bushing (if your old cam cover bushing has a hole in the bushing I.D.) using a $5/32$ drill through boss in cam cover through one wall only. Ream cam bushing per H.D.® Service Manual.

CAUTION: Wear safety glasses. Excessive force may damage parts and tool.
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