



PERFORMANCE ASSEMBLY SOLUTIONS

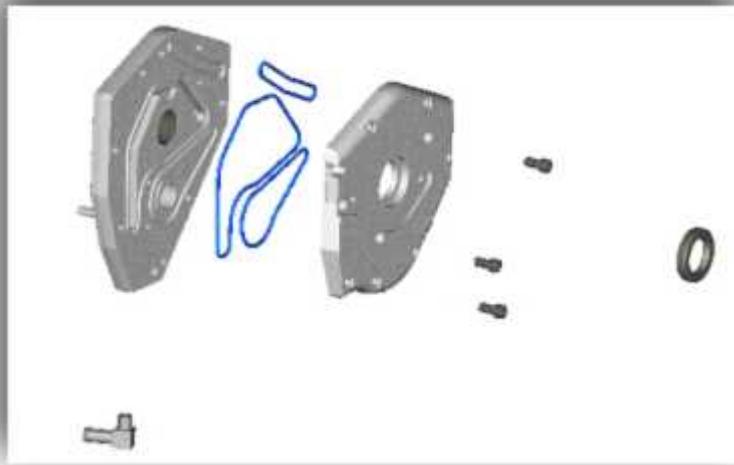
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Work Instruction

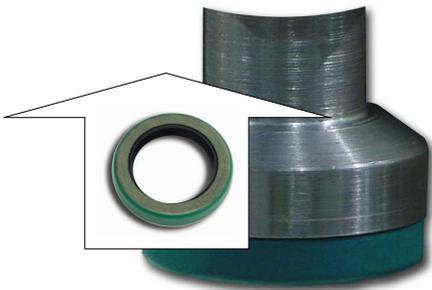
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Operation: 25 Description: Cam Cover Sub-Assembly	Prepared By: Quality Approved by: Manufacturing
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Title: Cam Cover Sub-Assembly	

CAM COVER SUB-ASSEMBLY



1. Inspect all components including O-Rings, for scratches, dents, dirt, oil, debris, cuts, nicks and excess material.
2. Remove the red plug from the end of the oil tube.



3. Insert (1) Cam Cover Seal (PN01-215) in the large, bushed hole in the center of the cover, by using the arbor press at the work station. See figure 1.2 for seal location. Check to see that there was no damage done after the installation is complete.



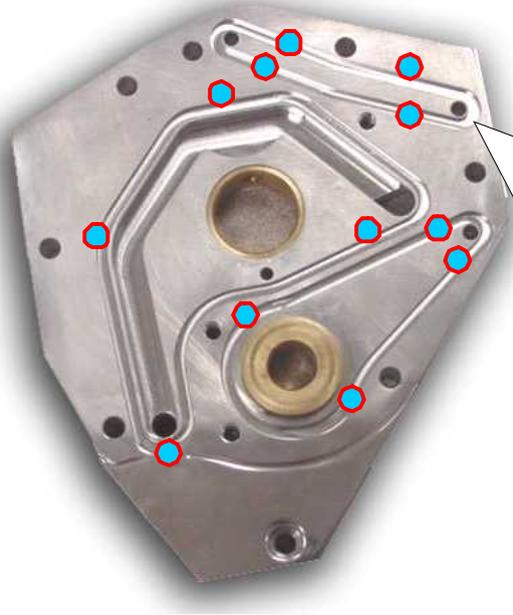
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Figure 1.0

- Using Depth Gage #D-01, measure the depth of the three glands. Gland depth needs to be .077, +/- .003 and measured as illustrated in the photo below.



Check Each Groove in Four Locations as shown. Check Each Pieces 100% before Assembly, Depth Dimension is .077 +/- .003

- Place inner cam cover onto the assembly jig.
- Apply a thin coating of petroleum jelly to the three Formed O-Rings. (PN01-058,059 &057)



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7. Install the “Top”, “Middle” and “Bottom” Formed O-Rings onto the inner cam cover using petroleum jelly to hold them in place.
8. Insert (1) ¼” x ½” manufacturing dowel (PN610008) into the inner cam as shown below.

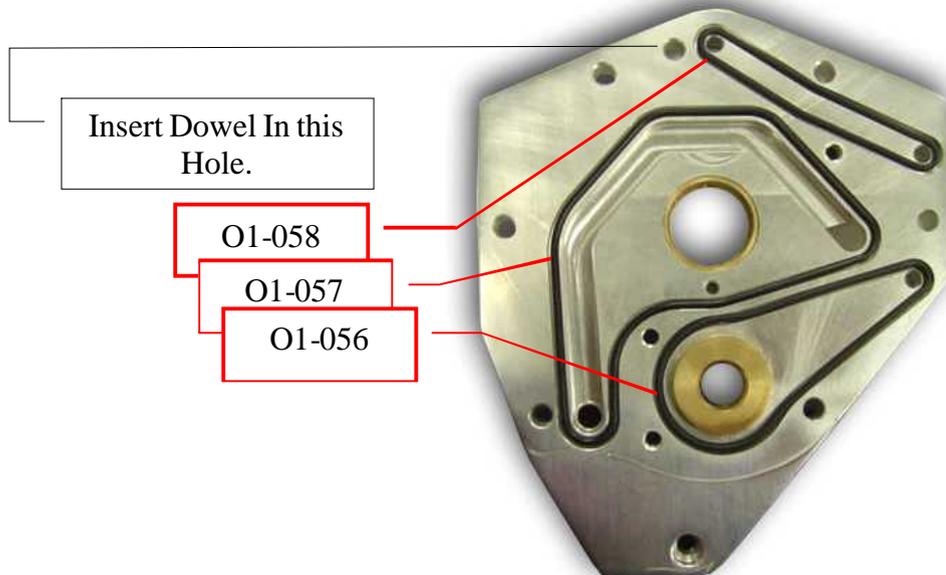
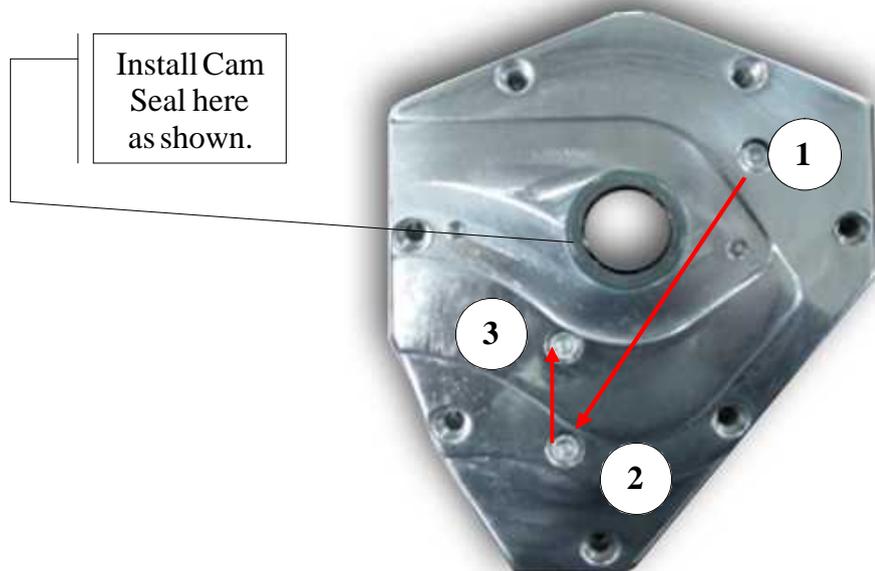


Figure 1.1

9. Carefully place the outer cover onto the inner cover using the dowel pin as a guide. Make certain that the O-Rings stay in the sealing grooves.





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Figure 1.2

- Apply a .380 x .264 x .240 washer (PN#96-045) and a small amount of blue thread lock on the last few threads of the three (3) 1/4-20 x 1/2 inch socket head screws fasteners.

(REPLACE THIS FITTING ON VISUAL AID WITH A PIPE PLUG)

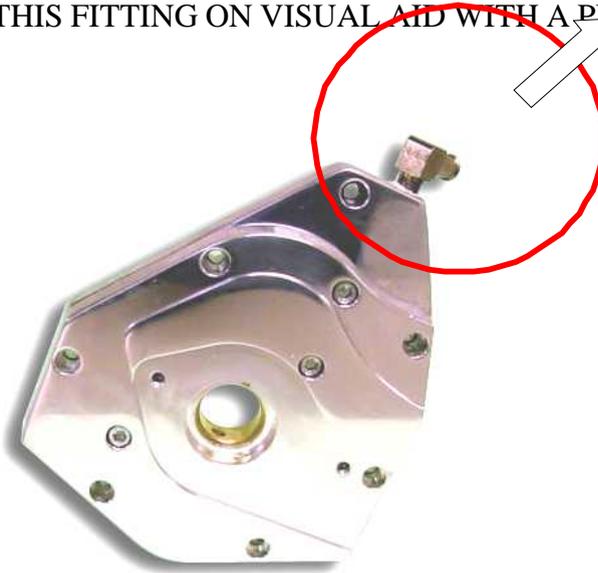


Figure 1.3

- Install three (3) 1/4-20 x 1/2 inch socket head screws with washers into the designated holes and snug, employing a crossing pattern as shown in figure 1.2 above. Torque to 8-12 foot pounds,  using Tool# I-08. Employ a crossing pattern as shown in figure 1.2 above.
- Using the designated .006"-thickness plastic card, check the seam between the cam cover halves to ensure there is no gap. You should not be able to insert this gauge between the halves. If you can insert a gauge, there is likely a pinched o-ring.
- Apply a thin coating of pipe sealant to (1) 1/8" pipe plug (p/n 640000) and thread into the tapped hole on the bottom of the assembly as shown in Figure 1.3. Torque 8-12 foot-lbs.

MAPICS PART #	INDIAN PART #	QTY/DESCRIPTION
280023	01-055	(1)CAM COVER ASSEMBLY
280016	01-134	(1)Inner Cam Cover
280015	01-905	(1)Outer Cam Cover



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760015	01-215	(1)Cam Cover Seal
710000	01-056	(1)Bottom O-Ring
710001	01-057	(1)Middle O-Ring
750002	01-058	(1)Top O-Ring
750025	96-031	(3)Socket Head Screw
610008	01-141	(1)Dowel Pin
960038	96-045	(9).38x.264x.040 Washer