



www.classicbritishspares.com (661)951-2120

TRIUMPH CAMSHAFT BUSHING LINE REAMER KIT **INSTRUCTIONS**



*Congratulations on your new tool kit! - should you have any questions
please contact us*

TRIUMPH 350 / 500 (UNIT) INSTRUCTIONS

1. Install both camshaft bushings (2) into the drive-side crankcase half
2. Bolt both crankcase halves together
3. Insert the reamer into the pilot (use heavy duty grease on shaft)
4. Take the pilot / reamer and insert it into the timing side camshaft housing
5. Begin to ream your drive side bushing (always apply lube or oil when cutting; cut in a clockwise direction)
6. Check your work and clean thoroughly



Please see the backside of this page for more details



TRIUMPH 650 / 750 (UNIT) & 500 (PRE-UNIT) **INSTRUCTIONS**

1. Install all camshaft bushings into both cases; drive side and timing side
2. Lube the 7/8 ball bearing and push the chrome ball bearing through both timing side camshaft bushings; you may need to do this a few times to allow the pilot to fit
3. Once the timing side bushings are broached, you will need to unbolt your crankcase halves
4. Insert the reamer sleeve (pilot) from the outside of the the timing bushing
5. Insert your 13/16 reamer through the inside of the timing bushing and bolt your crankcase halves back together
6. Proceed to ream your drive side bushing until both are sized (always apply lube or oil when cutting; cut in a clockwise direction)
7. Check your work and clean thoroughly

QUICK TIPS

You may find that the steel pilot may be a tight fit on the 13/16" reamer as it gets closer to the cutting flutes; this is caused by the 13/16" reamers shaft being sightly tapered and larger towards the cutting flutes. We try to keep no more .0013" clearance on all pilots once sized to allow a smooth and rigid set-up. The slight interference near the taper is nothing to worry about..

To drive the 13/16" reamer I like to use a large drill chuck; the shaft diameter is approx 5/8". There are many other ways to drive the reamer. I recommend performing the cutting by hand and monitoring your work at all times

When removing the 13/16" reamer from the sized bushing, make sure to rotate the reamer in as clockwise direction as you begin to remove the reamer. NEVER turn the reamer counterclockwise

QUESTIONS?

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