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TRIUMPH 350 / 500 SWINGARM BUSHING LINE REAMER KIT INSTRUCTIONS



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

TRIUMPH 350 / 500 (UNIT) INSTRUCTIONS (1957-1974)

1. Remove only 1 worn bushing (you choose) from your swingarm and replace it (and install) a new bushing (keep the other old bushing in place)
2. Insert the pilot and reamer into the old bushing - lube shaft prior to installing
3. Make sure that the 5/16" shoulder of the pilot is flush with the outside of the frame - the pilot might be a tight fit into the old bushing, if so, tap in place
4. Using cutting oil, begin to ream the newly installed bushing
5. Once sized, remove the old bushing and replace it with a new bushing
6. Insert the pilot into the sized bushing and repeat steps #2-4
7. Check your work and clean thoroughly



Please see the backside of this page for more details



QUICK TIPS

When installing the reamer into your swing arm, you must insert the reamer backwards into each bushing. Since the reamer is 7/8", most worn bushings are approx .0015-.002" oversize which will allow the new reamer to slide through the existing and also newly sized bushing

Notice that the pilot is slightly "stepped" with a .002-.0025" difference (visually might be hard to see, but you can measure). One step is undersized to fit the newly sized swingarm bushing while the other step is larger to fit the inside of the worn bushing

To drive the 7/8" reamer I like to use a large drill chuck; the shaft diameter is approx 3/4". 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 7/8" 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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