



INSTRUCTIONS

HARMONIC BALANCER CRANKSHAFT REPAIR KIT




Thank you for purchasing the ProMAXX® Harmonic Balancer Crankshaft Repair Kit! The repair kit includes: **PPT012 12MM-150 ProMAXX® Gold tap, Platinum PLTL440 tooling bit, and CSB012 Crankshaft ProBushing** – all machine grade premium tooling for precision repair.

1. Clean the harmonic balancer mounting bolt hole in the crankshaft with disc brake cleaner and compressed air to ensure that all debris has been removed prior to inserting the ProMAXX® Crankshaft ProBushing™.
2. Remove the protective cover and carefully insert the Crankshaft ProBushing™ into the crankshaft using caution not to damage the tool. This is a precision tool that relies on close tolerances to deliver accuracy. Any imperfections in the surface will cause the tool to bind.
3. Mount the PLTL440 Platinum tooling in a ½” air or electric powered drill and apply ProMAXX® PPL001 ProLube™ to the cutting edge of the Platinum tooling bit and along the entire surface of the bit. Carefully insert the bit into the ProBushing™ guiding it into the crankshaft clearance hole until the bit contacts the damaged mounting bolt.
4. Toggle (bump) the drill on an off for five one-second intervals before drilling continuously. This step is critical to establish a small divet into the remnant, allowing the bit to establish center and start to engage the cutting edge. Operate your drill at approximately 250-350 RPM and once started, do not stop drilling until you break through the opposite side of the damaged bolt.
5. Remove Platinum tooling bit and Crankshaft ProBushing Guide and reinstall the protective to avoid damage to the tool.
6. Using disc brake cleaner and compressed air, clean and remove all remaining debris and lube.
7. Place two drops of the ProMAXX ProLube on two opposing flutes of the ProMAXX® PPT012 Gold ProTap and insert. Turn ¼ turn clockwise, then counter clock-wise using compressed air frequently to remove any fragments from the tap. Direct the air flow down the tap flutes to dislodge any remaining fragments of the bolt. Repeat this step until the damaged remnant is removed.
8. Using disc brake cleaner and compressed air, finish cleaning and removing any remaining lube and debris from the repair.
9. Congratulations on a successful and productive repair!

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DIAL 724-941-0941

We are only successful when you are

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