ATI PERFORMANCE PRODUCTS

Installation Instructions

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CRANK PIN DRILL FIXTURE KIT FOR LS & LT (NON DRY SUMP LS)

Part #918993

Using ATI's Crank Pln Drill Fixture Kit, you can install 1 or 2 dowel pins in the LS1 crank to eliminate the damper twist on the shaft - a must for engines used for circle track racing or supercharging!

Please note!
All drilling and reaming dry - No lubricants or cutting oils are necessary!

1. Remove the damper.
2. Install the fixture to the crank and position 1 bushing hole for best drill access.
3. Using the old crank bolt, lock the fixture to the crank so it can not move.
4. Install the 11/64" bushing in the adapter and snug the holding screw.
5. Using the 11/64" drill bit, drill through the crank to the center bore.
6. Change the bushing to the 3/16" bushing and ream the 11/64" hole to 3/16" with one pass **in** and **out** at low RPM.
7. For a second pin at 180°, rotate the crank. ***Do not loosen bolt!***
   The fixture must stay locked to the crank until both holes are drilled.
8. Repeat steps 4, 5, and 6 on the opposite side if you are installing 2 pins.
9. Blow the outside and center bore clean of all chips before removing adapter. Then remove adapter.
10. Install the 3/16 pin, allowing it to protrude above the crank surface .093" to fit the keyway in the hub.

Refer to ATI Super Damper installation instructions (page 3) for LS Damper installation.

NOTE: All ATI LS1 Dampers have one 3/16" keyway in the hub or ATI can key your existing damper.