



239295/239296/239297

FITTING INSTRUCTION FOR RACING CRANK PIN AND BEARING

1. Hone rods .0015" to .002" (0.04 to 0.05 mm) clearance in direction that the bearing rotates finish polish.
2. Check side clearance between rods and flywheel. Must be .015" to .020" (0,4 to 0,5 mm) Don't grind bearing bush sides as this may lift plating.
3. Grind small grooves in female rod side similar to bearing sleeve.
4. Hand finish all sharp edges in rod eyelets
5. .004" to .006" (0,10 to 0,1 5 mm) interference fit pin/flywheel drive side
6. 3/16" minimum oil passage diameter in main shaft plus flywheel. If possible 7/32" preferably
7. Use a good 50 weight oil. (We had the best results with Spectro 50, Zodiac partnumber 235207)
8. Pump must deliver 70 psi. minimum. Most Automotive type Rally or other competition car pumps will deliver this. Oil tank should hold no less than 2 quarts (2 liter).
9. A Low-restriction in-line filter is a must (Zodiac Part Number 120026 plate, with 231292 filter). Also a small car screw-on-type is suitable. Vertical mount. Fill filter prior to installation.
10. ONLY ONE PASS PER OIL CHANGE !!!!! If engine has been fired up in the pits more than once we also recommend an oil change.
11. Crank motor till oil pressure registers. DO NOT RUN THE ENGINE TO GET PRESSURE .
12. A scraper type 2nd ring is required. There is probably three times more oil delivered to big end. We all know what happens when just a little bit of oil fires up around the top of the piston.

GENERAL COMMENT

DO NOT straighten rods while fitted to flywheels in engine. It may cause compression fracture between plating and steel inner bushing

NOTE: NO WARRANTY ON RACING PARTS



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