

## **CRANK PIN DRILL FIXTURE KIT FOR LS1 WITH DISTRIBUTOR**

Part # 918993-1

*Using ATI's Crank Pin 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, timing cover, oil pump, chain and gear. ***The key for the gear must remain in place!***
2. Install the fixture on the crank and position on key for the oil pump and chain gear.
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 ***carefully*** ream the 11/64 hole to 3/16 with ***one pass in*** and ***out*** at ***very low*** RPM drill speed.
7. For a second pin at 180°, rotate the crank. ***Do not loosen bolt!***  
The fixture must stay locked to the crank until both bolt holes are drilled.
8. Repeat steps 4, 5, and 6 on the opposite side if you are installing 2 pins for supercharged applications.
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.
11. Install the damper and pull it tight to 200 ft/lbs with the old bolt.
12. Install a new bolt (GM Part #12557840) with red #262 Loctite and torque the bolt to 240/250 ft/lbs.

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