

CRANK PIN DRILL FIXTURE KIT FOR HEMI 5.7, 6.1, 392 & 6.4

Part #918008

Using ATI's Crank Pin Drill Fixture Kit, you can install 1 or 2 dowel pins in the HEMI 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.
11. Install the damper.

NOTE: All ATI HEMI dampers have one 3/16" keyway in the hub. ATI can double key a new hub or add a key to your existing damper.

