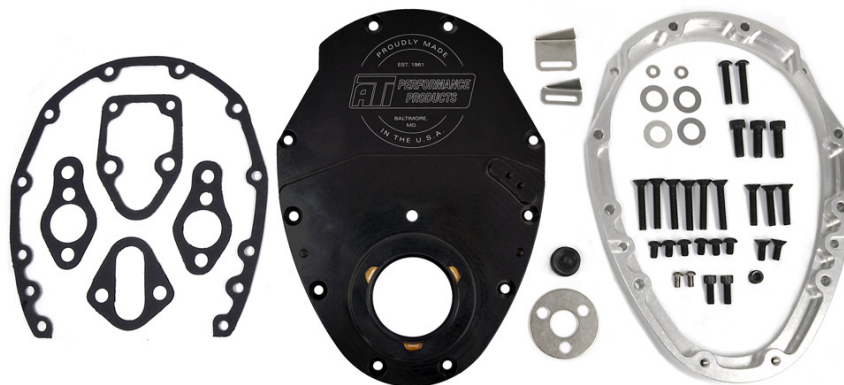


**Two-Piece Billet Small-Block Chevy Timing Cover
With Big-Block Chevy Crank Seal**

Part # 925502



Thank you for choosing ATI Performance Products for your high performance needs. Please be sure to read these instructions thoroughly before beginning installation.

1. Inspect the block side of your cam gear to ensure it is smooth and free of any burrs. Should the gear or block need smoothing, use 600 grit sandpaper. Some engine builders machine the back side of the cam gear in order to use a wear plate.
2. Install the timing cover ring on the block using the (2) 1/2" standard socket cap screw bolts and gasket supplied. You should set the end-play before installing the timing chain. This is done by placing the cam gear onto the cam with a wear plate (not included) in place if using in your build.

Install the cam thrust button, sandwiching (1) .010 shim (included) between it and the cam. Place the button retaining plate over the cam button and install the supplied 3/4" socket head cam bolts.

Install the front cover using all eight (8) bolts and tighten firmly. **DO NOT** use any sealer at this point!

Measure camshaft end-play with a dial indicator through the checking hole in the front cover. Use a screwdriver through a lifter bore to move the cam back and forth. Recommended movement (end-play) is .005" - .010".

Install the proper shims between the end of the cam and the front thrust button to achieve the correct amount of end-play.

NOTE: Tighten all 8 bolts each time you check end-play!

3. Before removing the cam gear, check the alignment between the cam and the crank gears with a straight edge. The gear alignment should be within .005". If corrective alignment measures need to be made, start by moving the crank gear. Once the gear alignment is correct, verify the cam end-play. After the desired end-play (.005"-.010") is achieved, apply a small amount of Loctite® on the supplied allen bolts and secure to the cam button retention plate and cam gear to the cam.

You should clean both the timing cover base and cover plate prior to installation. Be sure to also lubricate the cam thrust button. Apply a thin layer of oil resistant silicone to the cover before installing.

4. If use of a timing tab is desired, there are 3 options included.
5. If using a stock GM type water pump, it will be necessary to replace the stock bolts that secure the backing plate to the water pump with the supplied six (6) 1/4" button head allen bolts. Some aluminum water pumps may require minor adjustments to the backside to get proper clearance. **Make sure the water pump backing plate is not contacting the front of your timing cover!**