

LIFTER GUIDE INSTALLATION KIT

Lifter Guide Installation Kit will be used in conjunction with your E-Z Bore Valve Guide Installation Kit. Perform normal valve guide installation set-up with the exception of one item: During installation of drill to reamer, allow chuck of drill to only contact the top 3/8" of the valve guide reamer shank. This will be necessary to allow full travel of reamer during this operation. Cut valve guide bore as normal, except that the entire bore will need to be reamed. After clearing the bottom of valve guide bore, continue down with reamer to the top of the lifter bore (floor of breather chamber). Make a 1/4" deep starter cut at the top of the lifter bore and then remove valve guide reamer and upper support. Install lifter bore reamer supplied with this kit into brass upper support and tighten drill chuck the same as with the first reamer. Leave off the black bar strap and hold upper support in place by hand. Allow reamer to pilot off 1/4" starter cut and cut the entire length of lifter bore.

Standard valve guides will need to be shortened for installation into the lifter bore. A sample guide that has been shortened is provided with the kit. Note: shorten guide so the material is taken off the longest press fit portion of the guide. This kit contains a puller set-up that will allow pressing guide into the bore from the inside of block. Feed threaded rod down through valve guide and lifter bores. Install guide onto threaded rod with relieved portion of guide starting into lifter bore first, pull guide into place.

Tip: During installation of the lifter guide, press guide so that it stops approximately .030 below top of guide bore. This will leave a small oil collection point at the top of lifter guide. Any excess material extending below the lifter boss area can easily be removed using a SHARP lifter bore chamfering tool. Consult WKA Tech Manual for proper cutting in this area.

E-Z Bore recommends using a heavy dark thread cutting oil with a sulfur mix for maximum reamer life. Operate reamer in a 500 to 600 RPM range. If you have any additional questions, please contact our technical team at (757) 898-5645, or email us at jmoore@ezbore.net.

