

13B 2 Piece Eccentric Shaft


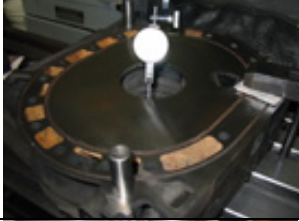




Centre Bearing Fitment Instructions

Important notes before you start:

All machine work should be carried out by a highly-competent fitter and turner.

Ensure the centre plate being used is no less than 49.85mm thick.

Step	Instructions	
1.	Bolt front and centre plates onto mill bed. Fit dowel pins and check for zero movement between the two plates. Clamp down.	
2.	Lock up the front plate stationary gear bore and check alignment against the centre plate bore.	
3.	Bore the centre plate hole top and bottom to 77.65mm diameter x 47mm deep leaving a 3mm step on the lower centre plate bore. Bore the top diameter to 77.75mm. Check clearances for a 0.05mm interference fit.	
4.	Remove the centre plate. Evenly heat to approx 80-90°C. Freeze the bearing assembly for 45min. Fit bearing with oil return holes at 12, 3, 6 and 9 o'clock. The bearing should slide into housing with minimum effort. Be sure it goes in square. Use light pressure in a press to ensure bearing is completely flush. Support the centre plate with a flat piece of aluminum or similar while this is being done.	
5.	Measure around the face with a height gauge and check the bearing housing is square. This is very important. Any misalignment will result in bearing failure.	
6.	Refit the plate onto mill and lock up centre bore again. Use a 1.5mm cutter to mill the circlip groove into the plate at same height as bearing support. Cut the groove 1.5mm wide x 1.5mm deep. Fit the circlip supplied. Ensure there is approx 1.5mm between the circlip and outside face of centre plate.	

Engine assembly – Guru Racing strongly recommends the use of larger thrust bearings and spacers from an FD RX7. Tighten the front pulley nut to 130 ft. lbs. Re-check end float after tensioning.