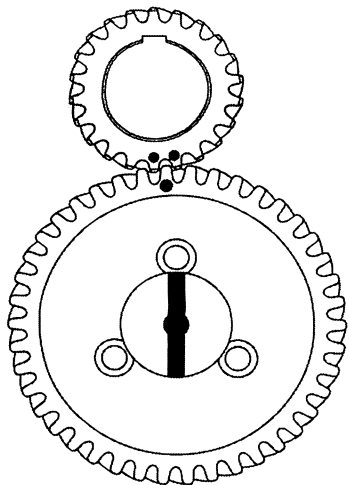




# Instructions for 21-2510 & 21-2515 Cam Gears

1. Fit gear to camshaft hub as pictured below. If gear is too tight on hub lightly sand hub until gear fits. **DO NOT** sand excessively as this could cause gear to fit loosely on hub
2. Install matching color washers to set cam gear timing as pictured below.
3. During mock-up of cam check clearance of cam bolts to oil pump body. Upon final assembly be sure to use Loctite® or a comparable product on the cam bolts.



Retard



Advance

## Washer Code

| Color  | Degrees |
|--------|---------|
| Black  | 0       |
| Silver | 2       |
| Gold   | 4       |