

Step 21 (cont)**ASSEMBLY** (continued from previous page)

- d.** Put camshaft through bushing install cam #131, hub to housing tighten set screws lightly.
- e.** Install ignition cam #129. Put breaker points (Chrysler 6 - 8 cylinder 1962 - 1972) on bracket #133 and locate mounting holes in base.
- f.** Assemble parts #132 - #130 and #126 - #127 - #128, and install.
Shoulder bolts may be purchased at most hardware stores.
- g.** Assemble on crankshaft, governor weights #135, governor cone #127, links #136 with bushing #138. Mark parts #135 and flywheel #143-L for reassembly. Check measurement between cone and hub with weights held together with rubber band. File or grind the $\frac{3}{16}$ " dia. x $\frac{1}{2}$ " stops on part #135 to get $\frac{5}{16}$ " between hub and cone. Install springs as shown on sheet #12. Set flywheel #134-L on crankshaft per sheet #11.
- h.** Install piston/rings, wristpin and connecting rod.
- i.** Install crank guard #157.
- j.** Install valve guides #110 in head, use Loc-tite.
- k.** Lap valves, install springs and retainers with $\frac{1}{16}$ " dia. x $\frac{11}{32}$ " pins.
- l.** Install rocker arm support #122 and align rocker arm #118 to center of exhaust valve.
- m.** Install head studs #125 using Loc-tite. Cut head gasket, $\frac{1}{32}$ " - $\frac{3}{64}$ " soft sheet packing and install head.
- n.** Make push rod as shown on sheet #11. Install spring and spring retainer. Set valve clearance 0.012" - 0.030" ($\frac{1}{2}$ turn of yoke = 0.017").
- o.** Adjust cam #131. Valve should start to open 25 to 35 degrees before out D.C. and close at in D.C. At this point halfdog cam to shaft.
- p.** Install grease cups on rod and mains, oiler on cylinder and oil all other moving parts.
- q.** Mount on bench and belt flywheel to $\frac{1}{3}$ H.P. electric motor with $2\frac{1}{2}$ " - 3" sheave. Adjust governor to operate just as motor reaches top speed. Try this several times to make sure it works well. **Maximum speed 525 RPM. Suggest 375 - 425 RPM.** (assembly continued on next page)