



INSTALLATION INSTRUCTIONS

INSTALLATION INSTRUCTIONS FOR THE FOLLOWING:

#64277. Chrysler 273-360 "A" series V8 Internally Balanced

Important: Before attempting installation, please read these instructions.

Note: The PRO/RACE "All Steel" Crankshaft Vibration Damper has a precision machined inner bore which requires special attention prior to fitting. It is also important to note that your PRO/RACE Damper is supplied "IN BALANCE" condition, therefore, if any balancing operations are to be carried out on the engine, weight must be added or removed from the crankshaft only.

Important: DO NOT drill any holes in your PRO/RACE Damper.

For special purpose races engines with an **internally balanced crankshaft**, simply unscrew the $\frac{5}{16}$ " socket head cap screw and remove the counterweight.

1. Engine must be completely cold.
2. Remove original Damper carefully, using Damper Puller or removal tool.
3. Check the end of the crankshaft to ensure the snout has been drilled and threaded.
4. Inspect crankshaft snout and ensure there are no burrs or rust. If required, polish with very fine emery paper or steel wool, wash clean.
5. Examine key, should the key be damaged or loose in the keyway groove of the crankshaft, install a new key.
6. Replace the front timing cover oil seal.
7. The PRO/RACE Damper can be installed just like any other Damper using a Damper installation tool. However, you can make installation much easier by immersing the Damper in boiling water for 15 minutes or placing in a pre-heated oven at the lowest temperature (max. 250°F or 120°C) for 15 minutes. This process will expand the hub of the Damper.
8. If you are NOT using a professional installation tool, it is **ESSENTIAL** that the Damper be pre-heated as outlined in step 7. above, to expand the hub. All subsequent steps will need to be followed carefully.
9. Smear crank snout and the timing case oil seal with clean oil.
10. If you are not using a Damper installation tool, remove Damper from boiling water (or oven), using insulated, heat proof gloves. Smear bore of Damper with oil.
11. Immediately locate Damper on to the crankshaft and rotate until the hub locates in the key-way.

IMPORTANT - DO NOT ALLOW DAMPER TO COOL



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12. If using a professional Damper installation tool, install the Damper following the instructions supplied with your installation tool and ignore step 13.
13. If you are not using an installation tool, quickly, utilizing a block of aluminum to protect the machined face, drive the Damper on the crankshaft.
14. Promptly reinstall the Damper retaining bolt and washer and tension to 90 lb/ft torque. Use LOCTITE to secure the crankshaft and pulley bolts.
15. Check that the pulley alignment is correct.

NOTE: Some early model pulleys had an "offset" bolt hole. This must be elongated with a suitable tool e.g., "rat tail" file to allow proper attachment to the Damper face.

16. Re-check for adequate clearance of all components before re-starting engine.

SPECIAL NOTE FOR RACE AND STREET HEMI ENGINES:

Due to the numerous TDC timing pointer locations used by Chrysler, it is necessary to make the following adjustments during timing operations on Race and Street Hemi engines.

On RACE HEMI engines, it is necessary to SUBTRACT 7 degrees from the reading shown on the damper. (E.g., if the damper shows 7 degrees, the engine is at TDC).

On STREET HEMI engines, it is necessary to ADD 2 degrees to the reading shown on the damper. (E.g., if the damper shows 10 degrees, the engine is at 12 degrees).

Should you have any difficulty fitting your PRO/RACE "All Steel" Crankshaft Vibration Damper, please contact:

PRO/RACE Performance Products
Email: tech@pro-race.com
Website: www.pro-race.com

OR alternatively please contact your place of purchase or closest Distributor.