



# INSTALLATION INSTRUCTIONS

## INSTALLATION INSTRUCTIONS FOR THE FOLLOWING:

# 34263 - Chevrolet 396-427 V8

**NOTE:** The PRO/SPORT SFI Bonded Steel Crankshaft Damper has a specially machined inner bore, sized for an interference fit to the crankshaft which requires special attention prior to installing.

1. Engine must be completely cold.
2. Remove original Damper, using a Damper puller or removal tool.
3. Check the end of the crank snout to ensure that it has been drilled and threaded 7/16" UNF (some early model cranks require this modification).
4. Inspect crankshaft snout to 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 key-way groove of the crankshaft, install a new key.
6. Replace the front timing cover oil seal.
7. The PRO/SPORT Damper can be installed just like any other Damper using a Damper installation tool. However, you can make installation much easier by placing Damper 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 oven, using insulated, heat proof gloves. Smear bore of Damper with oil.
11. Immediately locate Damper onto the crankshaft and rotate until the hub locates in the key-way.  
**IMPORTANT - DO NOT ALLOW DAMPER TO COOL.**
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 aluminium to protect the machined face, drive the Damper on the crankshaft.
14. Promptly reinstall the Damper retaining bolt and washer and tension to 65 lb/ft torque.  
**NOTE:** Use LOCTITE to secure the crankshaft and pulley bolts.
15. Check that the pulley alignment is correct.
16. Recheck for adequate clearance of all components before re-starting engine.



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17. Should you have any difficulty installing your PRO/SPORT Damper, please contact your local PRO/SPORT Distributor.

**\* Special Note for Externally Balanced Dampers.**

The 34264 and 34266 Dampers are fitted with a bolt-in counterweight. The counterweight can be removed allowing the Damper to be used on an internally balanced engine. Conversely, counterweights are available separately for the 34263 and 34265 Dampers should it be necessary to convert them for use on an externally balanced engine.

**NOTE:** Chevrolet has used two different TDC locations. The PRO/SPORT Damper is designed to be used in-conjunction with the aftermarket "bolt-on" style timing tab indicator.

If you have any problems installing your PRO/SPORT Damper, please contact:

PRO/RACE Performance Products

Email: [tech@pro-race.com](mailto:tech@pro-race.com)

Website: [www.pro-race.com](http://www.pro-race.com)

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