

ENGINE PRO

Engine Parts At Any Speed



ENGINE PRO TECHNICAL BULLETIN

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Engine Pro LS Chevrolet Bushing Trunnion Kits



ENGINE PRO LS CHEVROLET BUSHING TRUNNION KITS

These new bushing style LS Chevy trunnion kits for factory LS rocker arms are now available. The bushing design provides superior lubrication to the trunnion while also providing maximum load capability. Our innovative design prevents premature failures caused by the weak O.E. or replacement needle bearings, eliminating the possibility of debris from a bearing failure that can cause severe engine damage.

Our special C932 bushing material is bathed in oil via grooves at 2 different locations on the trunnion. These channels constantly feed

oil to the bushing surface ensuring proper lubrication. The greater surface of our bushed trunnion will support 300 times more load than a needle bearing trunnion. Our bushing gets more lubrication and has less load applied to it than the bushing in the small end of a connecting rod, giving it long service life.



KIT INCLUDES:

- Micropolished hardened shafts
- C932 Bearing bronze bushings
- C Clips

Kit may be used with early or upgraded GM bolts (not included).

Engine Pro Part #07-13702-16



Shop Solutions



ASSEMBLY INSTRUCTIONS: ENGINE PRO #07-13702-16 LS CHEVROLET BUSHING TRUNNION KIT

Tools Required:

Drill Press, Vice or Press; 5/8" 6-Point Shallow Well Socket ; 1/2" 6-Point Deep Well Socket; 7/8" 6-Point Shallow Well Socket; Snap Ring Pliers; Safety Glasses; Motor oil (same as being used in engine build)

Disassembly:

1. Remove items from packaging and visually inspect all parts. You should have 16 trunnions, 32 bushings and 32 snap rings. If you purchased our bolt kit (Part #06-13702-16) you should have 16 8mm bolts.
2. Clean rocker assemblies, removing any oil or dirt before assembly.
3. Use a 7/8" 6-Point Shallow Well Socket on one side of the rocker to catch the trunnion and bearings, and a 1/2" 6-Point Deep Well Socket on the opposite side to push the trunnion assemblies out when using a vice or a press. If you are using a drill press, center the rocker over the "through hole" of the drill press instead of using the 7/8" socket. The assemblies will remove easily by using just a little force. Repeat this for all 16 rockers.
4. After all rockers are disassembled, wash them using Dawn or another dish washing soap to remove remaining oil and dirt from the rockers. Blow dry with high pressure air.

Assembly:

1. Apply a small amount of oil around the housing bore of the rocker where the bushing will be pressed.
2. Set the rocker on the flat surface of the press or drill press. If using a vice, take a rocker, a bushing and a 5/8" 6-Point Shallow Well Socket, align one bushing against the side of the rocker where you are going to install the first bushing. Place the "driver side" of the 5/8" socket against the bushing. Slowly apply pressure from the vice or press to start the bushing into the housing. Once it has started, press the bushing until it is flush with the side of the rocker.
3. Place the rocker with pressed in bushing on the open side of a 7/8" shallow well socket, or if using a drill press, place over the "through hole".
4. Drop the trunnion in place in the rocker. Place the second bushing on the rocker body.
5. Using a 5/8" shallow well socket, place the open end toward the bushing. Center the socket and slowly apply pressure until the bushing starts to press into the rocker body. Once it is started, press the bushing until it is flush with the rocker body.
6. Hold the rocker by the ends of the trunnion and make sure it spins freely.
7. Use snap ring pliers to install a snap ring on either side of the rocker. Apply a small amount of oil to the rocker area so that it reaches the oil channel in the trunnion.
8. Repeat this 15 more times and you are done! If using our bolt kit, torque to 24 foot pounds with lube.