

# Cam Chain Tensioner Rollers for CB/CL/CA Engines

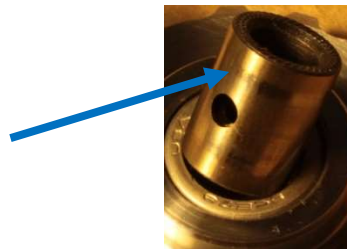
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## For Removal of Worn out Upper Roller Wheel

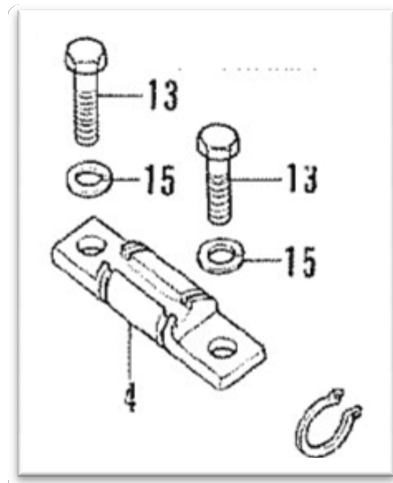
The rivet holding the upper roller wheel into the steel housing must be drilled out. This is accomplished by drilling out the flange head of the rivet using a .272in diameter drill bit (Anything a bit smaller works as well such as a 17/64in drill, but do not go larger than .275in or you may damage the steel housing). Once the rivet head is drilled out, you can use a punch to knock out the rivet.

## Parts You Must Re-Use From Factory Components

The following are not supplied and must be re-used:



OEM Upper Roller Bushing (If Excessively Worn, Replace)



OEM Lower Roller Axle and Hardware (If Excessively Worn, Replace)

## For Assembly of New Roller Sprocket and Roller Wheel

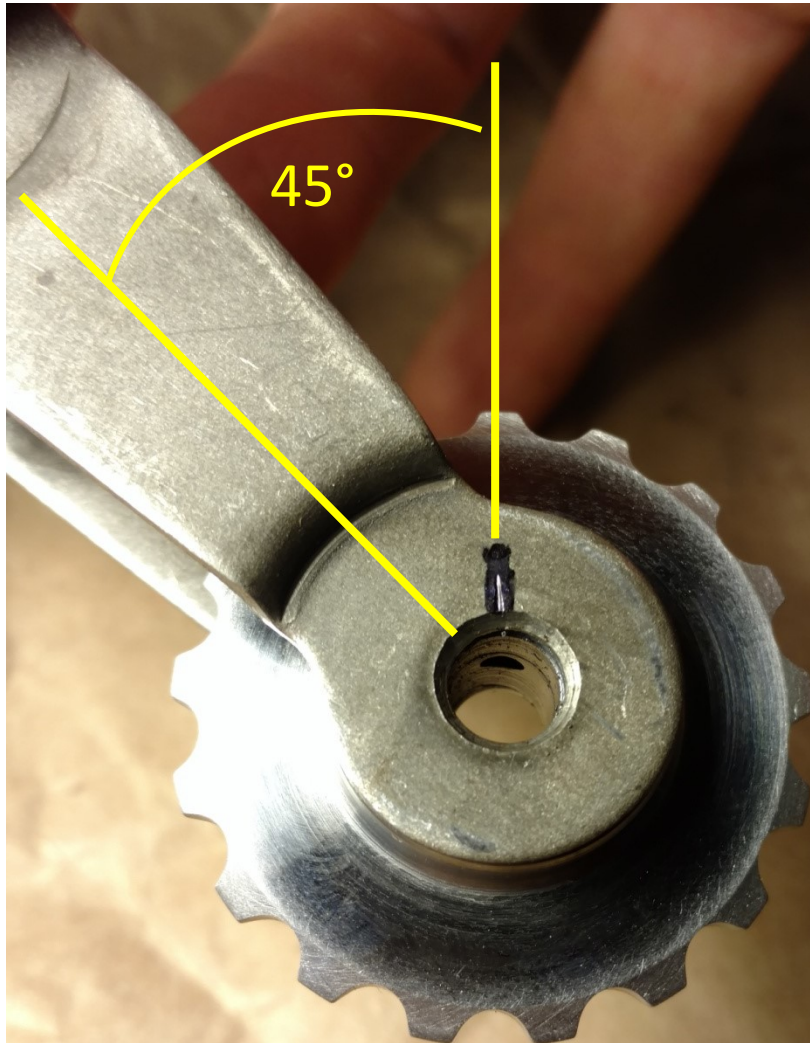
- 1) Mark the flange end of the rivet to be in line with the oil passage hole.



- 2) Install the upper roller sprocket with upper roller bushing inside of the bearing.



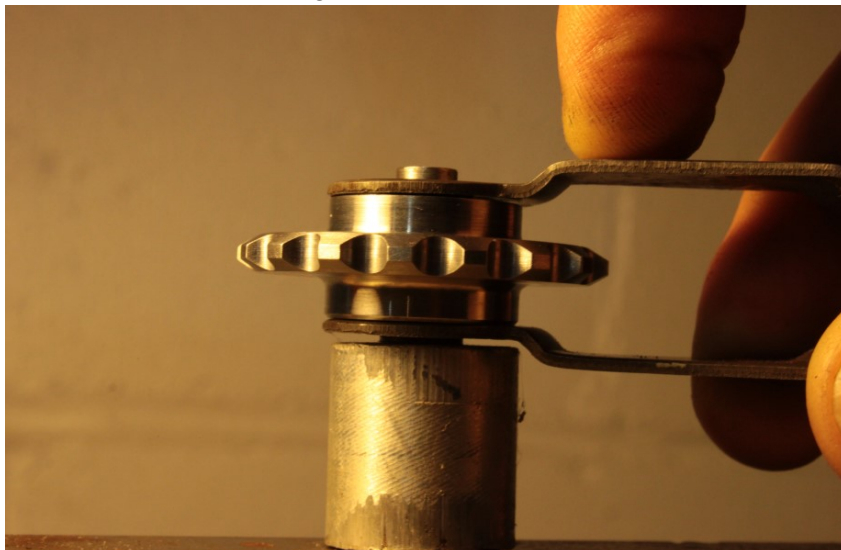
- 3) Mark the steel housing at 45° relative to the centerline between the upper and lower roller holes. Align the oil hole in the upper roller sprocket bushing to be aligned with this mark (Spreading the steel housing slightly while manually rotating the sprocket should allow the bushing to easily spin into position).



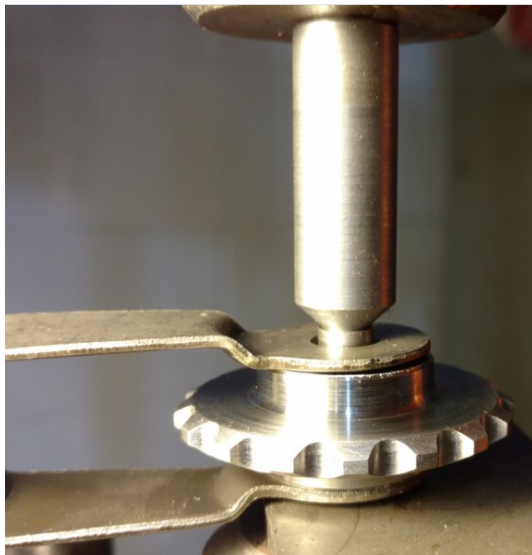
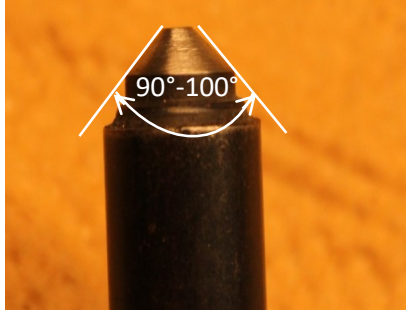
- 4) Carefully install the rivet with the alignment marks oriented together. Be sure not to allow the steel housing to spread while doing this so that the inner bushing hole remains aligned with the steel housing mark. If you are unsure of possible movement, remove the rivet and double check before moving on.



- 5) Carefully move assembly to a press. Squeezing the steel housing together slightly helps to prevent inner bushing from rotating. Be sure to only support the rivet head, and not the steel housing.



- 6) Grind a 90°-100° included angle tip on the end of a piece of steel to be used as a riveting tool. The diameter of the tool should be at least .38in to ensure proper rivet deformation. Alternatively, you can use the custom designed rivet driving tool available for sale.



- 7) After successful installation of the riveted roller sprocket, install the lower roller wheel and the OEM lower roller wheel axle and snap rings.



Before final installation into the engine, apply lubricating engine oil to both upper and lower bearings. Assembly is now complete.