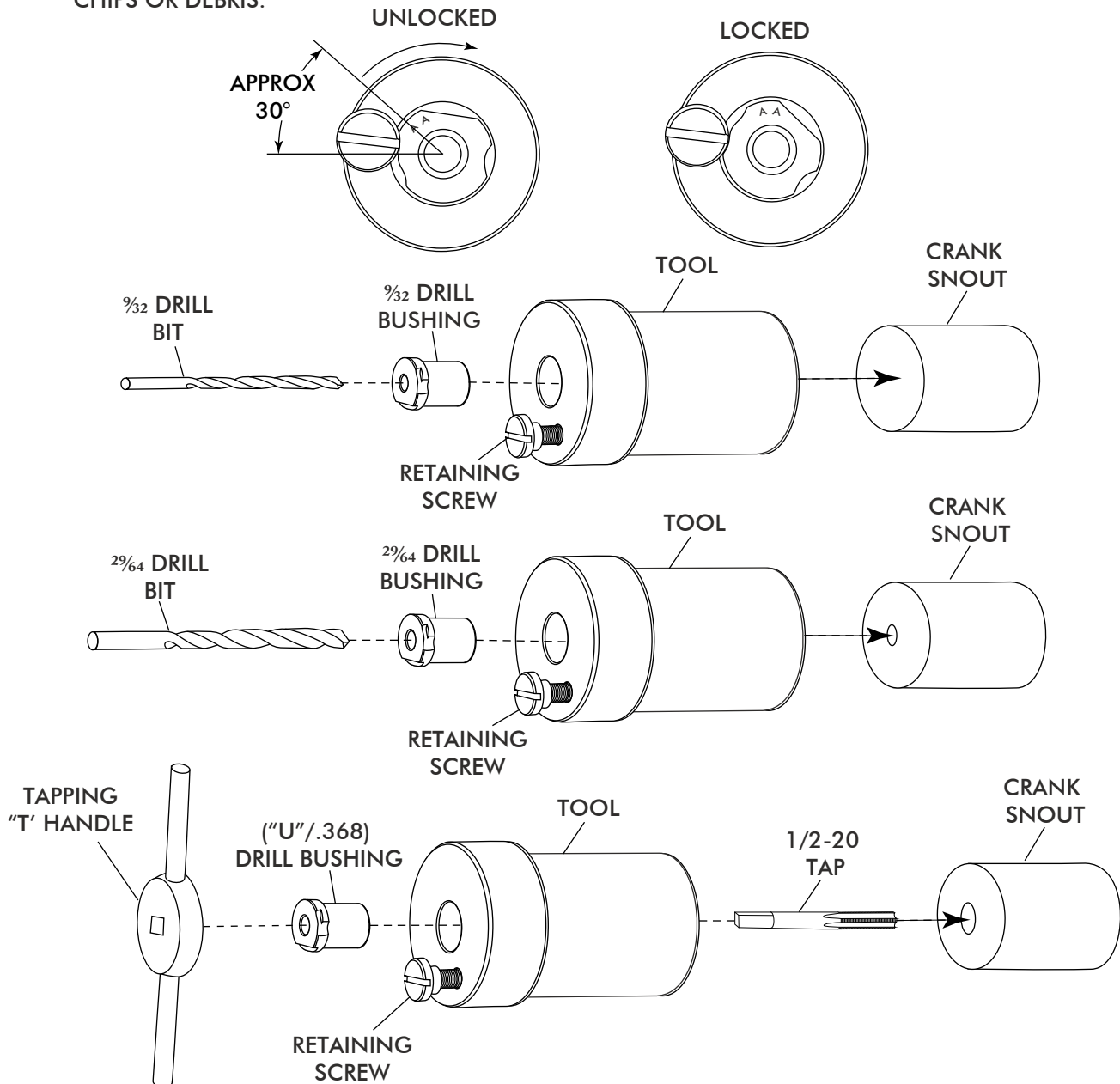




## 235, 261 CRANKSHAFT DRILL/ TAP TOOL INSTRUCTIONS

- WARNING: USE EXTREME CARE WHEN DRILLING/ TAPPING YOUR CRANKSHAFT TO AVOID BREAKING EITHER THE DRILL OR TAP.
- TO DRILL/ TAP SNOUT, INSTALL  $\frac{3}{32}$  REMOVABLE DRILL BUSHING INTO TOOL AND TIGHTEN RETAINING SCREW. SLIP TOOL OVER CRANK SNOUT, USING PLENTY OF CUTTING FLUID, DRILL  $\frac{3}{32}$  PILOT HOLE APPROX  $1\frac{5}{8}$  DEEP.
- REMOVE  $\frac{3}{32}$  DRILL BUSHING, INSTALL  $\frac{29}{64}$  BUSHING, TIGHTEN RETAINING SCREW. SLIP TOOL OVER CRANK SNOUT, DRILL PILOT HOLE OVERSIZE TO  $\frac{29}{64}$ , AGAIN USING CUTTING FLUID,  $1\frac{5}{8}$  DEEP.
- REMOVE  $\frac{29}{64}$  DRILL BUSHING AND INSTALL FINAL "U" (.368 BUSHING), AND RETAINING SCREW. INSERT  $1/2$ -20 TAP FROM BACK OF TOOL AND SLIP TOOL OVER CRANK SNOUT. CAREFULLY ATTACH WRENCH OR TAPPING "T" HANDLE ONTO TAP WHILE KEEPING TOOL POSITIONED OVER CRANK SNOUT. TAP SLOWLY USING THREAD CUTTING FLUID TO DEPTH OF  $1\frac{1}{2}$ " OR BOTTOM OF HOLE. CLEAN HOLE OF CHIPS OR DEBRIS.





# CHEVY 235 261 CS DRILL TOOL KIT PACKING LIST

CS DRILL TOOL KIT  
421000

No.	QTY.	DESCRIPTION	MFG PART NO.		
1.	1	DRILL BUSH 3/4 X 3/4 X "U" ID	07491756	MSC	_____
2.	1	DRILL BUSH 3/4 X 3/4 X 29/64 ID	07429756	MSC	_____
3.	1	DRILL BUSH 3/4 X 3/4 X 9/32 ID	07418759	MSC	_____
4.	1	5/16-18 RETAINING SCREW FOR BUSHING	8496A13	MCMaster	_____
5.	1	1/2-20 TAP, GREENFIELD, SPIRAL POINT HSS	2XUF6	GRAINGER	_____
6.	1	9/32 DRILL BIT, CL, COBALT 135 DEG SPLIT POINT HSS	81191181	MSC	_____
7.	1	29/64 DRILL BIT, CL, COBALT 135 DEG SPLIT POINT HSS	81191298	MSC	_____
8.	1	CHEVY 235 261 CS DRILL TOOL	421001	VA	_____

CHECKED BY: \_\_\_\_\_  
 PACKED BY: \_\_\_\_\_  
 DATE: \_\_\_\_\_

