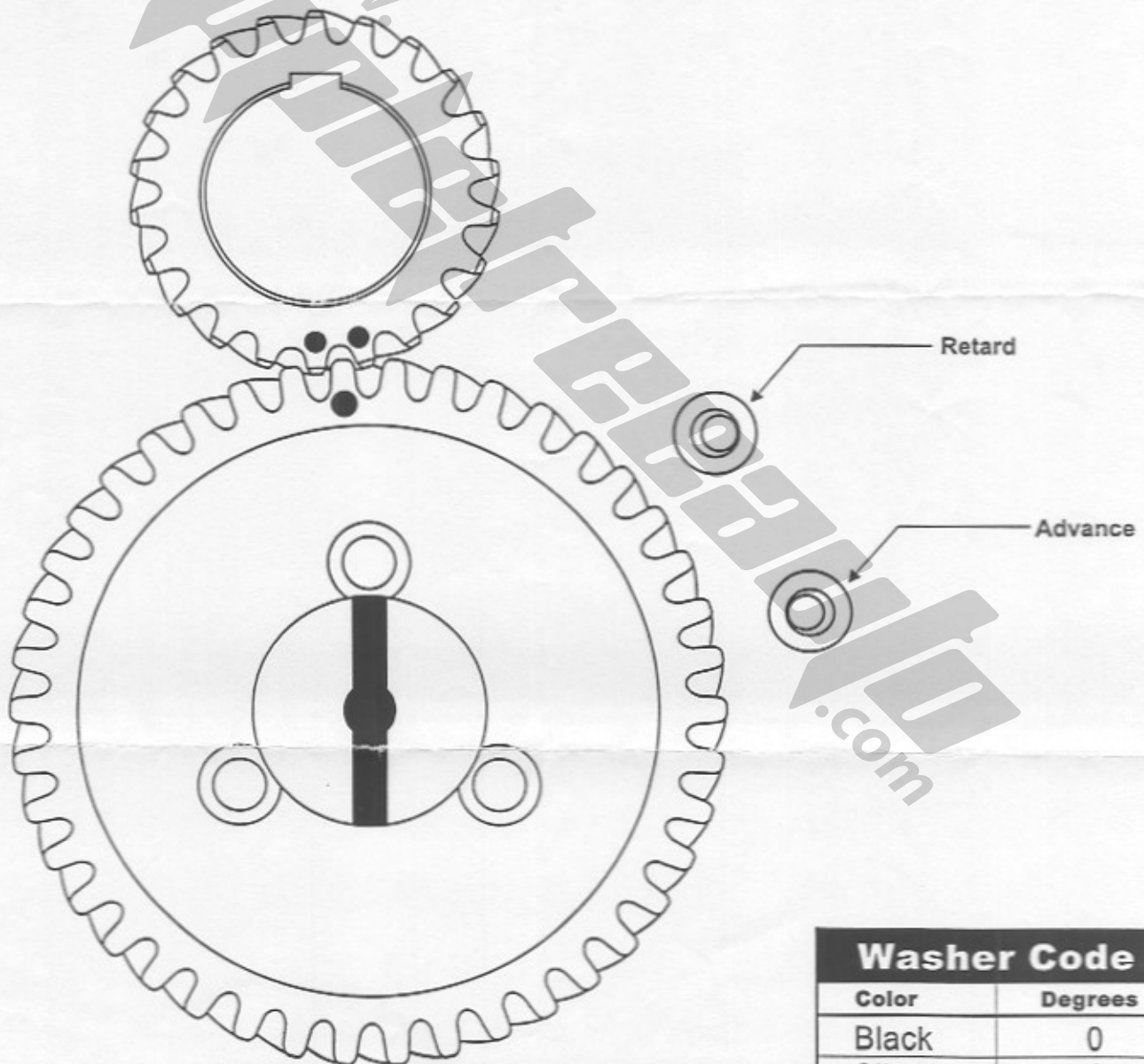




99-4014-0

Instructions for 21-2510 & 21-2515 Cam Gears

1. Fit gear to camshaft hub as pictured below. If gear is too tight on hub lightly sand hub until gear fits. **DO NOT** sand excessively as this could cause gear to fit loosely on hub.
2. Install matching color washers to set cam timing as pictured below.
3. During mock-up of cam; check clearance of cam bolts to oil pump body. Upon final assembly be sure to use Locktie® or a comparable product on the cam bolts.



| Washer Code | |
|-------------|---------|
| Color | Degrees |
| Black | 0 |
| Silver | 2 |
| Gold | 4 |