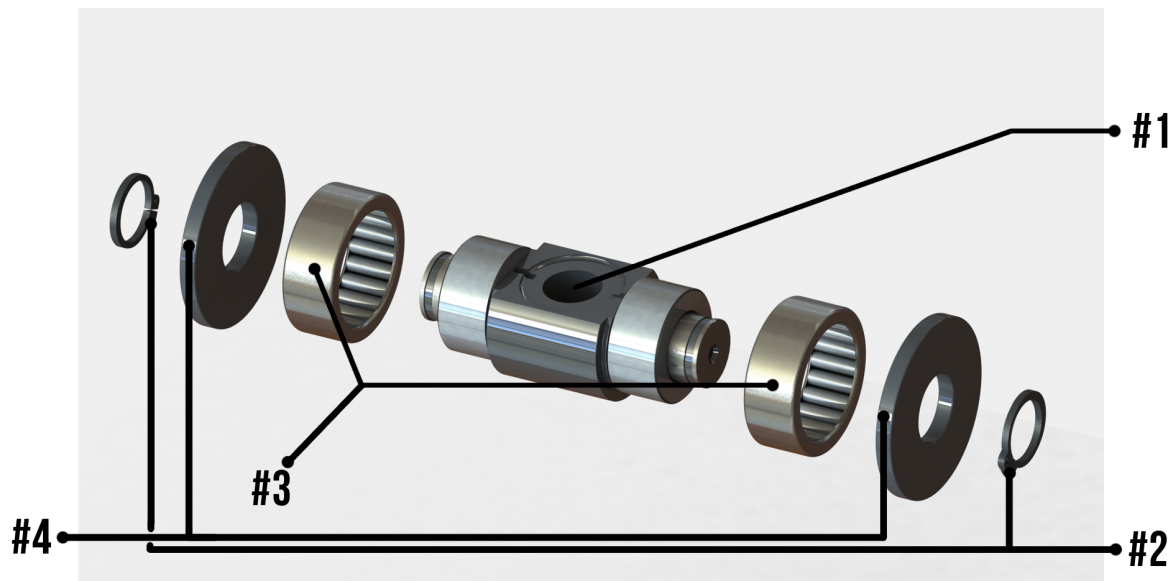




# TRUNNION KIT

## PACKING LIST & INSTRUCTIONS

ID #	NAME	DETAILS	QTY
1	TRUNNION BODY	MAIN TRUNNION BODY W/ PRE-INSTALLED INNER BEARING RACES	16
2	SNAP RING	RETAINING SNAP RINGS FOR TRUNNION BODY	32
3	ROLLER BEARING	PRESS-IN ROLLER BEARINGS FOR ROCKER ARM	32
4	TRUNNION WASHER	RETAINING WASHER FOR TRUNNION BODY	32
5	ASSEMBLY WASHER	ASSEMBLY WASHERS FOR PRESS-IN BEARINGS	2
6	ROCKER BOLT	REPLACEMENT ROCKER ARM BOLTS	16



### QUESTIONS & TECHNICAL ASSISTANCE:

CALL: 888.959.8865 MONDAY-FRIDAY 9-5:30PM (EST)

EMAIL: SALES@BRIANTOOLEYRACING.COM

WWW.BRIANTOOLEYRACING.COM

# TRUNNION ASSEMBLY PROCESS

**NOTE: IF YOU ARE UNCLEAR ON ANY OF THESE STEPS, PLEASE CONSULT A PROFESSIONAL INSTALLER.**

**PROPER SAFETY PRECAUTIONS ARE ADVISED DURING THE ASSEMBLY PROCESS. BE AWARE OF ALL PINCH POINTS WITH YOUR EQUIPMENT, AS WELL AS WEARING ADEQUATE EYE PROTECTION. SAFETY FIRST!**



**TOOLS NEEDED:**

**1/2" DRIVE 22MM & 13MM SOCKET  
BENCH VICE OR PRESS  
SNAP RING PLIERS**



**STEP 1:**

**LOCATE THE FLAT SIDE OF YOUR ROCKER ARM**



**STEP 2:**

**PLACE THE ROCKER FLAT SIDE DOWN CENTERING THE OEM BEARING INSIDE THE OPENING OF THE 22MM SOCKET. PLACE THE 13MM SOCKET ON THE CENTER OF THE BEARING FROM ABOVE SANDWICHING THEM BETWEEN YOUR PRESS**



**STEP 3:**

**GENTLY PRESS THE 13MM SOCKET INTO THE OEM ROCKER, EFFECTIVELY PUSHING OUT THE OEM BEARING. IMAGE ABOVE SHOWS THE 13MM PRESSED INTO THE ROCKER AS DESCRIBED.**

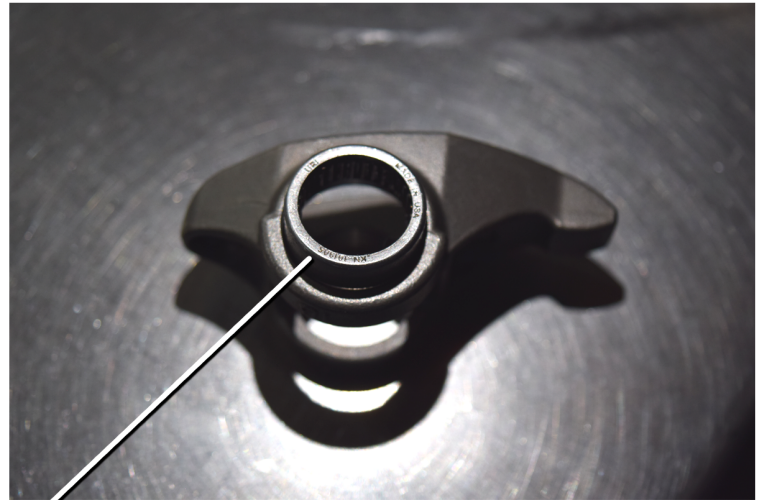
**\*\*KEEP THESE PIECES STRAIGHT. DAMAGE TO ROCKER ARM BODY CAN OCCUR IF THIS IS MISALIGNED\*\***



## STEP 4:

RELEASE THE PRESS AND REMOVE THE 13MM SOCKET. YOU'LL SEE THE OEM BEARING HAS BEEN SUCCESSFULLY PRESSED FREE FROM THE ROCKER.

**\*IF THE OEM BEARING ISN'T FREE FROM THE ROCKER ARM, DOUBLE CHECK THAT THE ALIGNMENT OF THE ROCKER ARM WASNT COMPROMISED DURING STEP 3.**



## STEP 5:

PLACE ONE ROLLER BEARING (PART ID #3) ON TOP OF THE ROCKER WITH THE WRITING SIDE FACING OUTWARD. CENTER THE BEARING WITHIN THE ROCKER ARM OPENING.



## STEP 6:

PLACE THE ROCKER ARM IN THE PRESS. MAKE SURE THE ROLLER BEARING IS SQUARE & CENTERED WITH THE ROCKER ARM OPENING.

ENSURE THAT YOUR PRESS SURFACE IS SMOOTH AND WONT DAMAGE THE INNER BEARING. USE PART ID#5 AS A SMOOTH PRESS SURFACE IF NEEDED.



## STEP 7:

PRESS THE INNER BEARING UNTIL IT IS FLUSH WITH THE OUTSIDE EDGE OF THE ROCKER ARM. REMEMBER, THE WRITING MUST FACE OUTWARD



## **STEP 8:**

**LOCATE PART ID #1. THIS IS A PRE-ASSEMBLED TRUNNION BODY. WE HAVE PRESSED THE INNER BEARING RACE ON THE ENDS PRIOR TO SHIPMENT.**



## **STEP 9:**

**SLIDE THE TRUNNION BODY (PART ID #1) THROUGH THE ROCKER ARM OPENING THAT YOU HAVEN'T PRESSED A ROLLER BEARING INTO YET.**



## **STEP 9 CONTINUED:**

**THIS IS WHAT THE OPPOSITE SIDE OF THE ROCKER WILL LOOK LIKE ONCE THE TRUNNION BODY IS SLID INTO PLACE.**



## **STEP 10:**

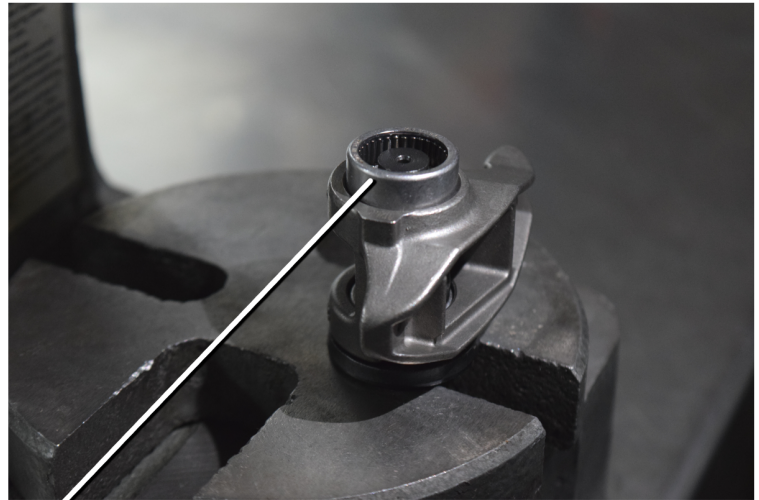
**PLACE AN ASSEMBLY WASHER (PART ID #5) ON YOUR PRESS SURFACE. USE A CUTAWAY BASE SO THE AREA BELOW THE WASHER OPENING IS FREE AND CLEAR.**

**\*ALTERNATIVELY, YOU CAN PLACE THE ASSEMBLY WASHER ON TOP OF YOUR 22MM SOCKET TO FREE THE AREA BELOW THE WASHER OPENING.**



## STEP 11:

**CENTER THE ROCKER ARM OVER THE WASHER OPENING. YOU WILL BE PLACING THE SIDE THAT ALREADY HAS THE ROLLER BEARING INSTALLED FACE DOWN ( FROM STEPS 6 & 7).**



## STEP 12:

**PLACE ROLLER BEARING (PART ID #3) IN THE CENTER OF THE ROCKER ARM OPENING, WITH THE WRITING SIDE FACING OUTWARD.**



## STEP 13:

**PLACE REMAINING ASSEMBLY WASHER (PART ID# 5) ON TOP OF THE ROLLER BEARING. MAKE SURE THAT THE ASSEMBLY WASHER IS CENTERED OVER THE TRUNNION BODY.**

**\*IF THE WASHER ISN'T CENTERED, YOU WILL NOT BE ABLE TO FULLY PRESS THE ROLLER BEARING INTO THE ROCKER.**



## STEP 14:

**PRESS THE ROLLER BEARING INTO THE ROCKER ARM BODY. ONCE COMPLETE, THE ROLLER BEARING SHOULD BE FLUSH WITH THE ROCKER ARM BODY.**

**\*IF IT IS NOT FLUSH, YOU MAY HAVE A MISALIGNED ASSEMBLY WASHER.**

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**STEP 15:**  
**LOCATE YOUR RETAINING WASHERS AND YOUR  
SNAP RINGS (PART ID #'S 2 & 4).**



**STEP 16:**  
**SLIDE THE RETAINING WASHER OVER THE  
TRUNNION BODY.**



**STEP 17:**  
**USING SNAP RING PLIERS, INSTALL THE SNAP RINGS INTO THE GROOVES PROVIDED IN THE TRUNNION BODY.  
REPEAT STEPS 16 AND 17 ON THE OPPOSITE SIDE OF THE ROCKER ARM.  
REPEAT THESE STEPS ON YOUR REMAINING ROCKER ARMS!**