

## SUM-141560-IK

### LS Engine Trunnion Upgrade Kit Removal and Installation Instructions

#### Included in the LS Engine Trunnion kit:

- (16) Rocker Arm Trunnions
- (32) Trunnion Bushings
- (32) Trunnion Snap Rings



#### \*Tools in the optional installation kit:

Part Number SUM-141560-IK

- (2) Installation Washers
- (1) Removal Washer
- (1) 7/16" Diameter Press/Drive Pin



#### Tools Required:

- Safety Glasses
- Small Press
- Hammer (optional)
- External Snap Ring Pliers

#### LS7 Rocker arms

Be advised the housing bores on these rocker arms may run small and may require honing to the proper diameter of .8125". If this is required, we strongly suggest taking the rocker arms to an automotive machine shop to have this done.

\*The following instructions are based on using the optional installation kit

## Step 1: OEM Trunnion Removal

Put on safety glasses. Place the removal washer (thickest of the 3 in kit) on a solid surface or in the press. Place the rocker arm on top of the washer with the flat side down and trunnion/bearing centered in the hole of the washer. Place 7/16" pin in the center of the trunnion and while holding vertically, press or drive downward until the trunnion pushes the bottom bearing assembly out of the rocker arm body. Turn the rocker arm over and place it back on the washer and using the same 7/16" pin carefully press/drive the remaining bearing shell out of the other side. Discard the old parts.



## Step 2: Upgraded Trunnion Installation

Place the rocker arm, flat side down, in the press. Place one of the bronze bushings on the top of the rocker arm centered in the housing bore of the trunnion.



Press the bushing into the rocker arm body just until it is flush with the outside. Lift up the rocker arm and place a light coat of oil or assembly lube on one end of the new trunnion and insert it into the rocker body and installed bushing.



Place one of the 2 installation washers (thinner with smaller hole than the removal washer) under the press, then set the rocker arm on top with the side the bushing is in down and trunnion sticking through the center of the washer.



Put a light coat of oil or assembly lube inside the other bushing and place on top of the rocker, sliding it over the trunnion and centering it on the rocker arm housing bore.

Partially press the bushing into rocker body just until it gets started straight then back off and place second installation washer on top of bushing making sure it is centered



Press the washer/bushing down and as the washer gets close to going over the trunnion shaft, check to make sure it's still centered, then press the bushing down until it's flush with the rocker body. Install both snap rings and repeat the process to the other rocker arms.



## PLEASE NOTE:

The optional SUM-141560-IK tool is to be used with a shop press. If a bench vise style tool is required, a secondary install tool is offered under part number SME-906011.

