



M-6269-A460 Roller Bearing Camshaft Thrust Plate INSTALLATION INSTRUCTIONS

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**!!! PLEASE READ ALL OF THE FOLLOWING INSTRUCTIONS CAREFULLY PRIOR TO INSTALLATION.
AT ANY TIME YOU DO NOT UNDERSTAND THE INSTRUCTIONS, PLEASE CALL THE FORD RACING
TECHLINE AT 1-800-367-3788 !!!**

Application:

Ford 351C, 351M, 400M, 429, 460 production blocks.
Ford Racing M-6010-A460 and M-6010-A460BB blocks

Installation:

STEP 1: Machine cam sprocket as shown on attached page.

NOTE: A qualified machinist should perform this operation. Prior to machining sprocket use a micrometer to measure the cam plate and bearing thickness. Dimension A should be .003 to .006 greater than the total thickness of the bearing and cam thrust step.

STEP 2: Remove old timing gear and cam plate from engine and clean surface area. Refer to Ford shop manual for timing chain removal if necessary.

STEP 3: The new cam plate has two notches on bearing side (block side). They are for oil to be pressure fed to the bearing. Look at the front of your block around the front cam bearing. On a production block and Ford Racing iron blocks the oil hole is at 4 o'clock position. Verify that the hole is visible and not restricted.

STEP 4: Slide bearing assembly and cam plate onto cam. Make sure that the oil hole and the notch in the cam plate match up. The bearing ID has slightly raised edges which should point toward the front of engine.

STEP 5: Install retaining screws (supplied) and torque them to 10 to 12 ft-lbs.

NOTE: On production blocks the two 1/4-20NC bolt holes that retain the plate may need to be bottom tapped. If so, use a bottoming tap with grease on it to collect the metal chips. Also, the flat head screws we supply can be difficult to remove if an excess amount of Loctite is used. We suggest that if you use Loctite to use a low strength type and apply a small amount on the threads only.

STEP 6: Install modified cam sprocket (see page 2) and torque retaining bolt to camshaft manufacturer recommended spec. With a dial indicator check camshaft end play. It should be .003" to .006"

NOTE: camshaft bolt torque:

3/8" 40-45 ft-lbs

7/16" 65 ft-lbs

Factory Ford shop manuals are available from Helm Publications, 1-800-782-4356

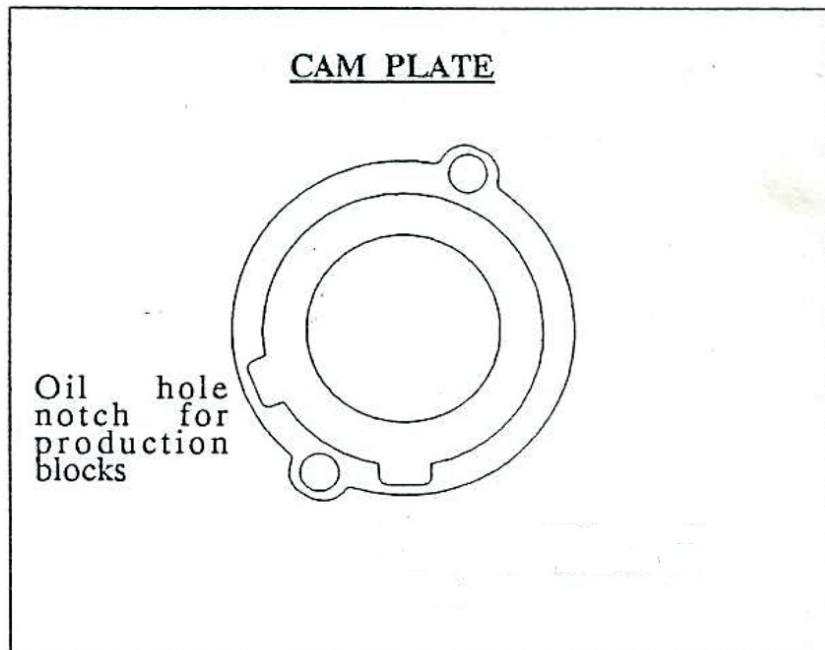
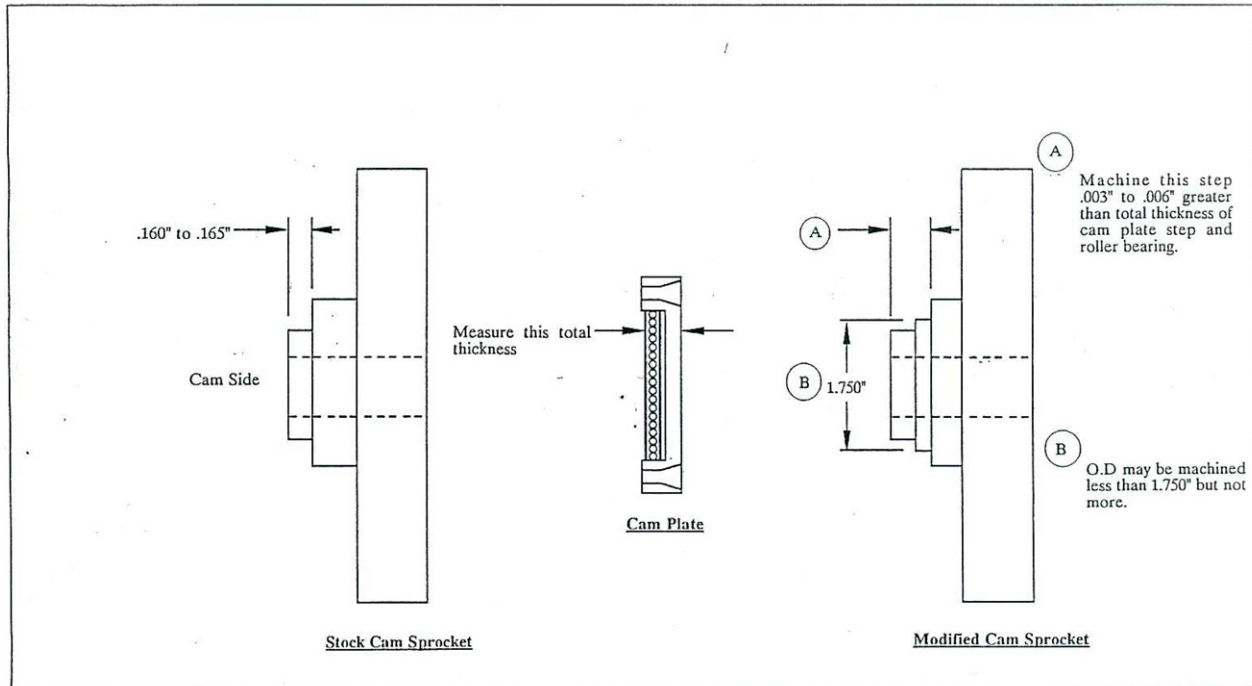
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Cam Sprocket Modification Instructions:

IS-6269-A460

The bearing in the new cam plate is inset below plate surface. Total thickness of step in cam plate and roller bearing should be .003" to .006" less than dimension A.



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