



FORD PERFORMANCE

M-6261-A460 460 Roller Cam Bearings INSTALLATION INSTRUCTIONS

NO PART OF THIS DOCUMENT MAY BE REPRODUCED WITHOUT PRIOR AGREEMENT AND WRITTEN PERMISSION OF FORD PERFORMANCE PARTS.

Please visit www.fordracingparts.com for the most current instruction information

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

STEP 1: Align bore cylinder block cam bearing bores:

Cast Iron block: 2.4995"/2.5005"

Aluminum block: 2.4988"/2.4997"

NOTE: Cylindricity must be within .0002"

STEP 2: An oil supply must be provided to the cam thrust plate, timing chain and distributor bushing. Using a die grinder, machine a shallow groove in the #1 cam bore from the cam bearing oil supply hole to the distributor bushing oil located at 4 o'clock. Also, cut a shallow groove from the oil supply hole to the front face of the cam bore for thrust and timing chain oiling. Groove radii should be .025"/.030"

STEP 3: Tap the oil supply holes to the cam bearings to the crank bores. Plug with 5/16-18 threaded plugs. Loctite can be used to secure the plugs.

NOTE: #1 cam bearing oil supply hole intersects the main oil supply passage. Even when plugged at the crank bore, it will supply oil to the cam bearing bore for distributor bushing, thrust plate and timing chain.

STEP 4: Press against the stamped end of the bearing shell (and with bearing designation). Use a suitable tool such as Comp Cams roller cam bearing installation tool #5412. Bearings should be centered in the housing. Longitudinal adjustment to center bearing on camshaft journals is acceptable as long as bearing shell is completely supported in the housing.

STEP 5: The standard 2.5" camshaft housing rear cup will still seal the enlarged cam bore. Use RTV to ensure a leak tight seal.

NOTE: Drawn cup needle roller bearings cannot be measured before installation as the thin walled outer ring can be out of round from the manufacturing process. After installing in a ring gage (or cam bearing bore) with 2.04995" ID the bearing ID can be measured with a tapered plug gauge. SPEC is 2.1256"/2.1271.

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