

# NORNDA AUTOMOTIVE

## Assembly Instructions:

To suit: Chevrolet Small Block

25-31 Innes Road  
Windsor Gardens  
Australia SA5087  
Ph + 61 8 8261 7222  
Fx + 61 8 8261 9171

### Warning:

Do not use the keyway marks to time the engine. Always use the tooth or tooth space timing marks.

### Note:

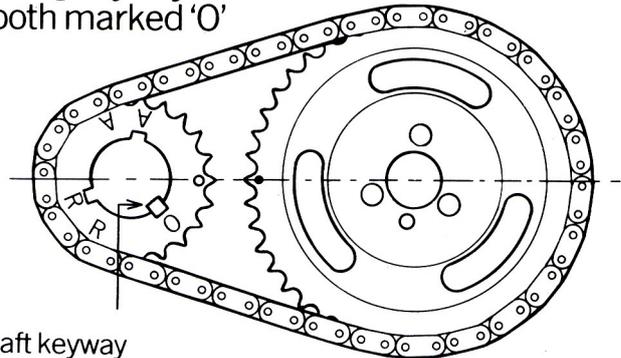
Check for clearance between timing components and block or timing cover. On some blocks it may be necessary to remove material for chain or sprocket clearance. Before advancing or retarding the camshaft timing, the camshaft timing should be checked in the standard position with a degree wheel.

### Lubrication:

For maximum chain life, proper chain lubrication is a necessity. When increasing the timing chain speed (rpm's), lubrication of the chain must also increase. Therefore, oil must penetrate into the spaces between the link plates thereby sufficiently lubricating the bearing surfaces between the pins and the bushes. Excessive wear can cause the chain to lengthen to the point of not only damaging the sprocket teeth but destroying the timing chain drive.

## 1 Standard Timing

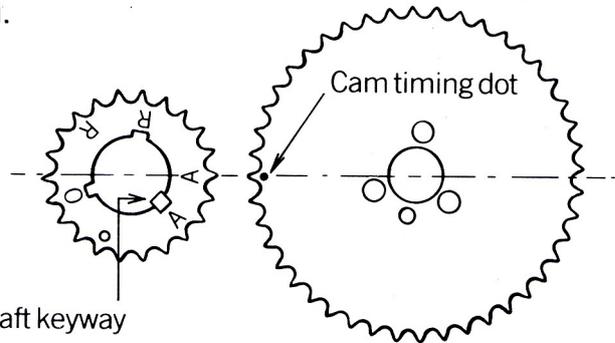
Using keyway and tooth marked 'O'



Crankshaft keyway

## 2 Camshaft Advanced 4°

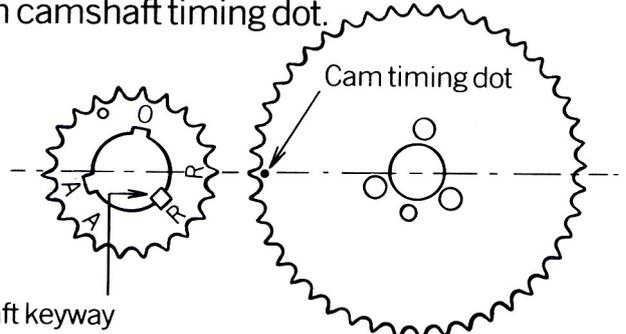
1. Install crankshaft sprocket with keyway marked 'A' to key on crankshaft.
2. Rotate crankshaft anti-clockwise until tooth marked 'A' is in line with camshaft timing dot.
3. Without further rotary movement of either cam or crank sprockets assemble timing chain.



Crankshaft keyway

## 3 Camshaft Retarded 4°

- Use same procedure as 2 above. Using keyway marked 'R' and rotate crankshaft clockwise until tooth marked 'R' is in line with camshaft timing dot.



Crankshaft keyway