

# BHJ Products, Inc.

## Parts List & Instructions

Product Name: **Crankshaft Dual-Keyway Fixture**  
BHJ Part#: **CKF-1**

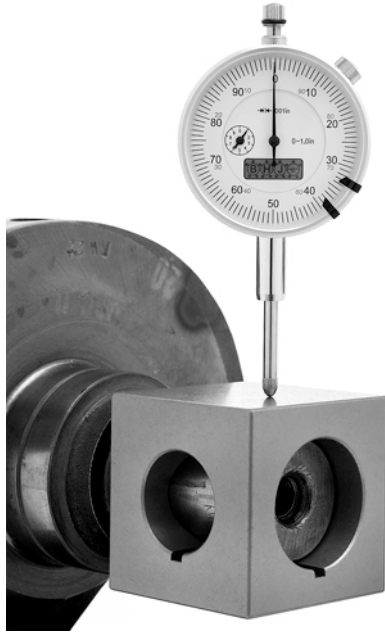
Page 1 of 2

### Kit Contents:

**1x** Red Cube (Chevrolet)

**1x** Storage Tray

**1x** Black Cube (Ford & Mopar)



### Description

BHJ's Crankshaft Dual-Key Fixture provides a quick and accurate solution for adding a second crankshaft keyway, using a vertical mill or other conventional shop equipment.

Using a dial indicator or micrometer (not included) the "Crank Cubes" enable indexing of the crankshaft at 180 degrees from the existing key and register squarely on the crank snout centerline.

The Kit accommodates small and big block Chevrolet, Ford small block, big block and Triton/Modular, as well as Mopar applications and includes two anodized, billet aluminum Cubes and a storage tray.

BHJ's Harmonic Damper Keyway Fixture (P/N DKF-1) and Crankshaft V-Blocks (P/N CVB-1) are recommended companions to this Kit.

Red Cube: Chevrolet

Large ID Bore – Big Block  
Small ID Bore – Small Block

Black Cube: Ford, Mopar

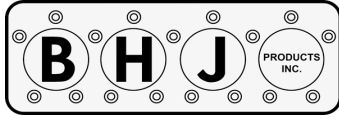
Large ID Bore – Ford 3/16" and 1/4" inch key  
Medium ID Bore – Mopar  
Small ID Bore – Ford Triton/Modular

### Setup

1. Insert the crankshaft into the appropriate Cube opening with the key stock inserted in the factory keyway
2. Tighten the setscrews to hold the Cube in position
3. Align and support the crankshaft using BHJ Crankshaft V-Blocks (P/N CVB-1)

### Machining Procedure

Continued Next Page...



# **BHJ Products, Inc.**

## **Parts List & Instructions**

Product Name: **Crankshaft Dual-Keyway Fixture**  
BHJ Part#: **CKF-1**

Page 2 of 2

### **Machining Procedure**

End-Mill Cut:

1. With a dial indicator, square the Cube to the machine surface using the Top or Side of the Cube (2.50" Cube)
2. Using an edge finder pick up "0" from either side and move the cutter 1.250" in the appropriate direction
3. **REMOVE THE CUBE** from the crankshaft. The cutter head is now on centerline, 180-degrees from the existing keyway

Woodruff Cutter:

1. With a dial indicator, square the Cube to the machine using the Top or Side of the Cube (2.50" Cube)
2. Pick up the "0" and move the cutter 1.250" in the down direction
3. **REMOVE THE CUBE** from the crankshaft. The cutter head is now on centerline, 180-degrees from the existing keyway

**Call BHJ at (510) 797-7680 with any questions regarding the part, setup, or operation.**