

BHJ Products, Inc.

Parts List & Instructions

Product Name: **Crankshaft Dual-Keyway Fixture**
BHJ Part#: **CKF-2**

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Rev. 6/22/2012

Kit Contents:

1x Red Cube (GM)

1x Black Cube (Chrysler/Mopar)

1x Blue Cube (Ford)

1x Storage Case

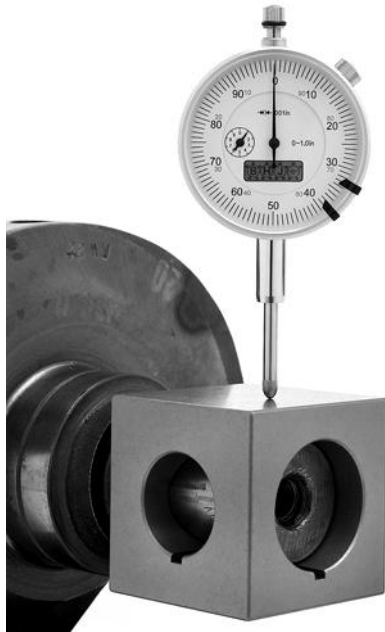
Description

BHJ's Crankshaft Dual-Keyway Fixture provides a quick and accurate solution for adding a 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° from the existing key and register squarely on the crank snout centerline. A keyway may also be added to GM LS series and Chrysler 5.7/6.1 liter crankshafts by indexing the timing gear key.

The Kit accommodates Chevrolet big and small block, GM LS series, Ford big block, small block and Triton/Modular, as well as Mopar big block, small block and 5.7/6.1 Hemi.

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: GM
Large Bore: Chevrolet Big Block
Small Bore: Chevrolet Small Block
Medium Bore: LS Series

Black Cube: Chrysler/Mopar
Large Bore: Big & Small Block
Small Bore: 5.7/6.1 Hemi

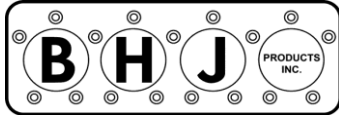
Blue Cube: Ford
Large Bore: Big & Small Block
Small Bore: Triton/Modular

Setup

1. Insert the crankshaft snout into the appropriate Cube bore with key stock inserted in the original keyway.

Note: The GM LS and Chrysler 5.7/6.1 bores are stepped. Measure both ends of the Cube bore and slide the Cube onto the snout with the larger bore toward the counterweight and the smaller bore facing away from the crank, to engage the timing gear key.

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)



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Machining Procedure

End-Mill Cut:

1. Select new keyway position (0°, 90°, 180°, 270°) and rotate crankshaft accordingly.
2. With a dial indicator, square the Cube to the machine surface using the top or side of the Cube (2.500" Cube).
3. Using an edge finder pick up "0" from either side and move the cutter 1.250" in the appropriate direction.
4. Remove the Cube from the crankshaft. The cutter head is now on centerline and at the correct orientation for the cut.

Woodruff Cutter:

1. Select new keyway position (0°, 90°, 180°, 270°) and rotate crankshaft accordingly.
2. With a dial indicator, square the Cube to the machine using the top or side of the Cube (2.500" Cube).
3. Pick up the "0" and move the cutter 1.250" in the down direction.
4. Remove the Cube from the crankshaft. The cutter head is now on centerline and at the correct orientation for the cut.

Call BHJ at (510) 797-6780 with any questions regarding the part, setup, or operation.