



BHJ Products, Inc.

Parts List & Instructions

Product Name: **Lifter-Tru Piloted Cutters**
BHJ Part#: **LT-CUT-XXX**

Page 1 of 1

Description

BHJ's Lifter-Tru piloted cutters are designed for use in all BHJ Lifter-Tru blueprinting fixtures. The Lifter-Tru allows a machinist to re-machine lifter bores and correct their position in an engine block and may be done with, or without the use of lifter bore sleeves. Lifter-Tru piloted cutters are available for machining .843", .875", .906", .937", 1.00", 1.062" and 1.125" nominal lifter bores, but are also available in custom sizes, by request.

BHJ Lifter-Tru cutters are available in two pilot lengths, "Standard" pilot and "Long" pilot:

- **Standard pilot-length** cutters incorporate a 2.0625" pilot and will accommodate OEM-configuration lifter boss heights in the majority of blocks.
- **Long pilot-length** cutters have a 2.250" piloted end. Blocks utilizing a tall lifter boss, as is the case with some aftermarket blocks, GM LS series blocks and others, it is necessary to begin cutting the lifter bore using an equivalent-size long-pilot cutter. Doing so ensures engagement of the cam tunnel mandrel before machining begins. In some cases, it is necessary to begin cutting a tall lifter boss using a long-pilot cutter and finish the cut with a standard-pilot cutter, as the longer pilot may bottom-out in the cam tunnel of the block before completing the cut.

Instructions

1. All Lifter-Tru piloted cutters are designed for use in a completely-assembled Lifter-Tru fixture. Both the cam tunnel mandrel and upper guide plate should be installed onto the fixture for best results.
2. Cutters are first quality, high speed steel tools. The following recommended settings are supplied by the manufacturers for optimum tool life and surface finish:

Speed: 40-60 RPM

Power Feed: .006-.012" Per Revolution

Coolant: Flood or High Pressure Mist with soluble oil. The coolant is of the utmost importance. By either flooding the cutter or using a high pressure mist, not only is the cutter kept cool but more importantly, the chips are constantly flushed away preventing scoring of the finish. Experience shows that cutter gives a mirror finish when used according to the above recommendations.

Lubricant: A light coat of lubricant may also be applied inside the upper guide plate and cam tunnel mandrel bushings before insertion of the piloted cutter as well.

Contact BHJ with any questions regarding the operation of this, or any other BHJ tooling.