

# MAGNUSON

## SUPERCHARGERS

### HELLCAT ADDENDUM

## CRANK PIN INSTALLATION INSTRUCTIONS

Your vehicle particulars may find this modification easier from the bottom. In any case you may need to remove components (such as the fan shroud assembly in this Dodge Challenger) to gain access to the crank harmonic pulley for this installation.

1. Use a 21mm wrench to remove the crank harmonic balancer pulley bolt.



2. Install the crank pin drill guide with the provided M16x100mm bolt. It's convenient to align the two holes for the crank pins in the drill guide horizontally for ease of access. Torque the temporary bolt holding the drill guide to 40 ft-lbs.



3. Use the provided drill bit to drill the two holes using the pin guide jig holes. Be sure to drill the holes out completely to the second step of the drill bit. This will not be an apparent stop of the bit while drilling. You must either put a piece of marking tape or verify visually that you have drilled to the second step of the bit.



4. Blow out the holes using compressed air. Use protective glasses, be careful of your eyes! Now, install the provided reaming bit into the drill motor and clean the holes out. When you're finished with the ream bit blow the holes out again with compressed air watching out for your eyes.



5. Remove the drill guide kit.



6. Put a generous bead of green Loctite 680 on the crank pins and press the tapered end of each one into each of the two holes you just prepared. Use a hammer and drift-pin or nail-set to tap the crank pins in completely. Ensure that they are in completely, and will not touch the surface of the crank bolt directly when installed.



7. Re-install the supplied OEM crank bolt and torque to 239 ft-lbs. Verify your torque wrench setting. We fabricated a tool to hold the crank while torquing the bolt.

