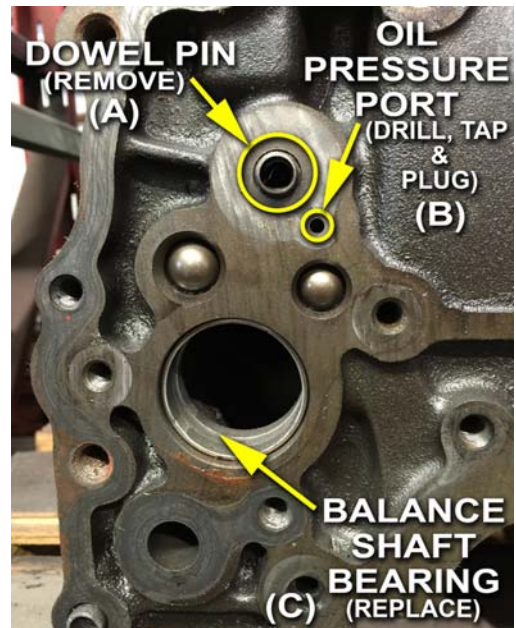
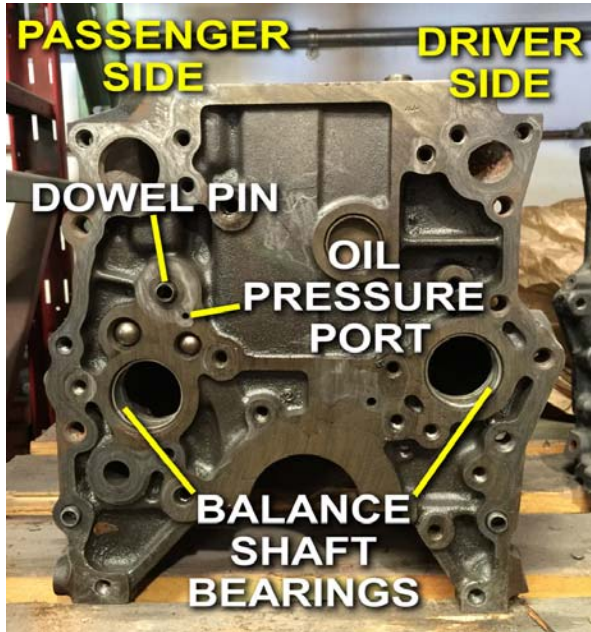


## 3RZ Balance Shaft Removal Kit - Part #1015050

1. Remove all chains, sprockets, and counterbalance shafts etc... from engine.
2. Remove the Dowel pin (A) above balance shaft opening (Passenger's side of block). **THIS WILL NOT BE RE-USED.**
3. Using the supplied drill bit, drill out the Oil Pressure Port (B). Then using the supplied 1/16" tap, Tap block so that plug will fit flush into block. **ALWAYS USE TAP LUBE AND TAP WITH CAUTION.**
4. Be sure to clean all metal shavings from engine. Use a shop vac if installation is done in the truck.
5. Install supplied pipe plug into Oil Pressure Port (B) using Teflon sealant or Loctite.



6. Use supplied driver to remove front (only) shaft bearings (C). Check rear shaft bearing if damaged, remove.
7. Deburr block and then proceed to install the new Aluminum bearing insert into balance shaft block holes. **THIS IS TO BLOCK OIL FLOW. \*\*FOR EASE OF INSTALL: Place new Aluminum Bearing Inserts in the freezer for approx. 30 min. prior to installation.\*\***
8. Install the new billet oil jet where tensioner was removed (driver's side of block). Longer bolt (M8-1.25x40mm) goes on the guide rail mount location (D). (Stock studs must get removed and will not get re-used)
9. Torque oil jet bolts to 14 Ft-Lbs.
10. Install cam timing chain and guides according to factory service manual.
11. **DO NOT RE-INSTALL ANY COUNTER BALANCE COMPONENTS.**

If you have questions call our tech support line 928-855-6341

