



Revision
04/25/22

Timing Chain Conversion Kit Part # 1015012 22R/22RE 1985-1995

Using a Hanes, Chilton, or Toyota service manual, follow procedures for installing the Timing Chain Conversion Kit. Install this kit the same way you would an OEM single chain.

Additional Modifications Required

Oil baffle inside valve cover must be modified for clearance of the double cam gear. Do not remove the whole baffle, only the front baffle extension above the cam gear needs to be removed. Using a 3/8 drill bit, locate the spot welds and drill just enough to release the welds. Remove the baffle extension and debur the oil baffle.

Clean valve cover to remove all metal shavings before installation.

Chain Installation

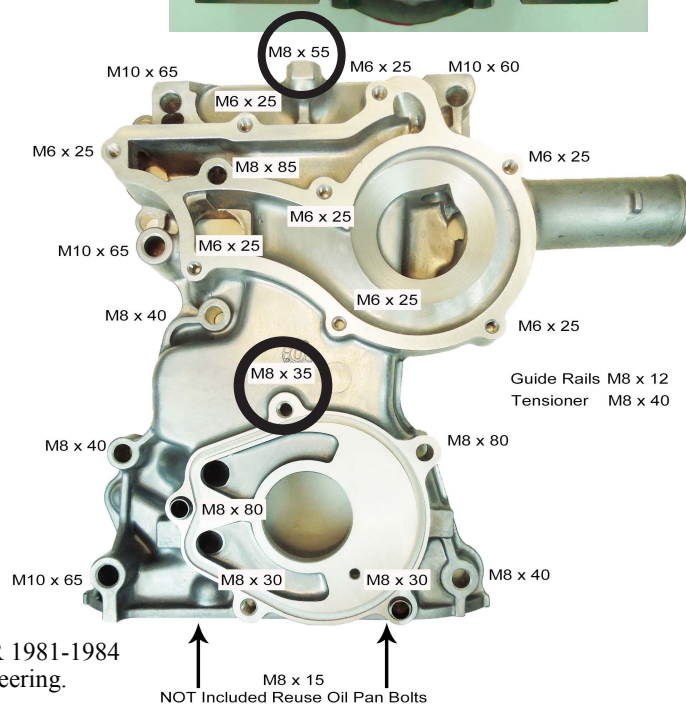
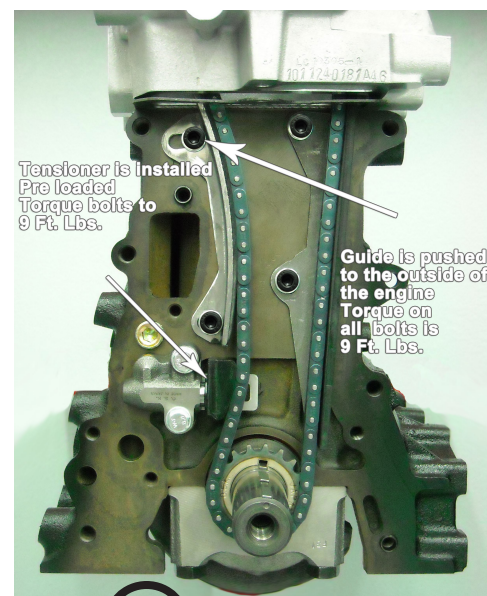
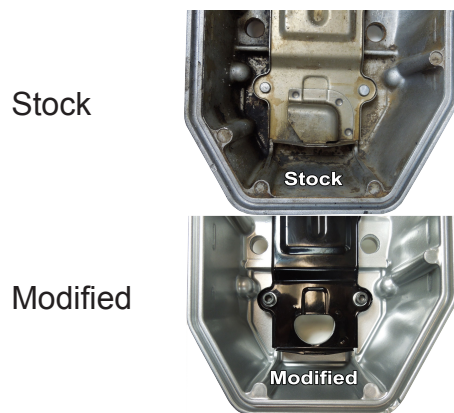
When installing the metal guide rails, the curved rail should be placed in the outward position. This will provide the proper amount of chain tension. The curved guide can be adjusted to accommodate head and block decking. Due to the tightness of the new chain, it may be necessary to gently pry up on the cam gear while sliding it onto the camshaft. Use a screwdriver or similar tool through the center hole on the gear, and inserted into the hole in the cam, gently lift the gear up while sliding the gear back on the cam. Rocking the crankshaft back and forth slightly as needed to line lip the dowel pin. DO NOT FORCE IT ON! The gear should only require slight pressure to slide onto shaft.

***Seal the head of the top bolt, and the threads of the upper oil pump bolt using RTV or Ultra Grey. (Refer to black circles on the bottom illustration)**

Qty	Size	Hardware	Application	Torque Specs
8	M6 x 25	Hex Bolt	Water Pump	6 ft.-lbs.
4	M8 x 12	Allen Bolt	Guide Rails	9 ft.-lbs
2	M8 x 30	Hex Bolt	Lower Oil Pump	9 ft.-lbs
1	M8 x 35	Hex Bolt	Upper Oil Pump	9 ft.-lbs
5	M8 x 40	Hex Bolt	Tensioner/Cover	9 ft.-lbs
1	M8 x 55	Hex Bolt	Head to Cover	9 ft.-lbs
2	M8 x 80	Hex Bolt	Oil Pump	9 ft.-lbs
1	M8 x 85	Hex Bolt	Water Pump	9 ft.-lbs
3	M10 x 65	Hex Bolt	Timing Cover	29 ft.-lbs
1	M10 x 60	Hex Bolt	Cover Alt. Brkt.	29 ft.-lbs
8	6mm	Washer	Water Pump	
4	8mm	Flat Washer	Guide Rails	
15	8mm	Wave Washer	Other 8mm Bolts	
4	10mm	Flat Washer	Timing Cover	

Qty	Item	Description
1	1015027	Modified Timing Cover
1	1015018	HD Double Row Timing Chain Kit
1	1016069	Pro Oil Pump 81-84
1	1016132	Water Pump 81-84
1	1016066	Oil Pump Drive Spline 81-82
1	1015039	TC Conversion Hardware Kit

****Note:** Timing Cover gaskets are under the false bottom of the Timing Chain kit
This kit uses a Water Pump, Oil Pump and Oil Pump Drive Spline from an early 22R 1981-1984
Replacement Double Chains and Double Chain Kits are all available from LC Engineering.



Call the Tech Line if you have any questions on installation. 928-855-6341