

# CJ305

## Small Block Conversion Jig Instructions



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CJ305 Convert Chevrolet 305 & 350  
CID blocks w/electric fuel pumps to  
accept mechanical fuel pump.  
(incl. drill bits and reamers)

### Tools Needed

- 5/16" drill bit • 3/8" drill bit
- 1/4"- 20 tap • 3/8"- 16 tap

Follow these steps...

1. Check the block to make sure it has two 3/8" and 2 1/4" threaded holes on the fuel pump pad. If not, bolt the "L" shaped drilling jig to the block using the two 3/8" holes on the lower right front of block. Drill two 5/16" (bit not included) and two #8 in fuel pump pad of block. Unbolt jig and remove from block. Tap the 5/16" holes with a 3/8"-16 tap and the #8 holes with a 1/4-20 tap.

2. Bolt the drilling jig with the 1/2" bushing to the fuel pump pad on the block using the 3/8" holes. Drill the fuel pump pushrod hole using the extra long 1/2" (included). Unbolt jig and remove from block.

3. Bolt the drilling jig with the 1" bushing to the fuel pump pad using the 3/8" holes. Use the 1" drill bit (included) to bore a counterbore 1/2" to 1-5/8". O.E. counterbores vary in depth. Unbolt jig and remove from block.

4. Using the special reamer provided in kit, ream the fuel pump pushrod hole to achieve final sizing. Check fit by inserting a fuel pump pushrod.

5. Bolt the drilling jig with the 3/8" bushing to the fuel pump pad using the 3/8" holes. Using a 3/8" (not included) drill the oil drain back hole through the floor of the block.