



Alternate Firing Ordering Camshaft LML Pin Swap

Stock Firing Ordering:

1 – 2 – 7 – 8 – 4 – 5 – 6 – 3

Empire Firing Order:

1 – 5 – 6 – 3 – 4 – 2 – 7 – 8

2 & 5

Swap

7 & 6

Swap

8 & 3

Swap

1 & 4

Do Not Swap

2011 – 2015 LML

#2 – Dark Blue – X3-51

#5 – Light Blue – X3-52

#6 – Purple – X2-32

#7 – Tan – X2-31

#8 – Grey – X3-72

#3 – Dark Green – X3-71

Note: The numbers next to the colors are in reference to the ECM.

Note 2: Do not remove timing key or washer. They are there to ensure the cam works properly.

Note 3: When setting the valve lash it is recommended to check the compression stroke of each individual cylinder. This is to help make sure you are setting things correctly

MINIMUM OF .050 THOU CRUSH HEAD GASKET RECOMMENDED TO INSTALL ALTERNATE FIRE CAM (EX. GM C GRADE HEAD GASKETS & COMETIC .060 HIGH PERFORMANCE STEEL MULTI USE HEAD GASKET)