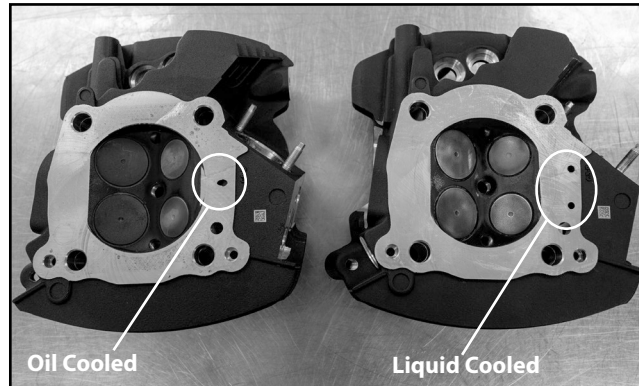


INSTALLATION OF EXPANSION PLUGS IN OIL COOLED HEADS

NOTES

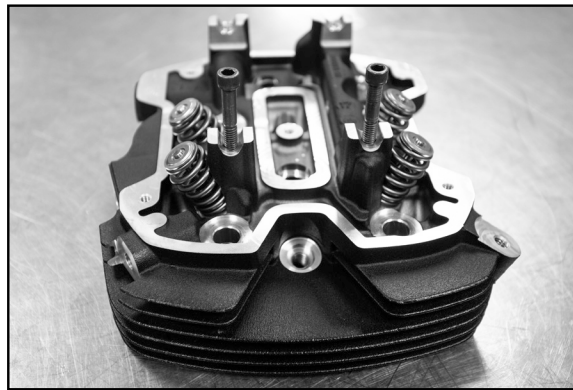
- **Important!** Installation of the expansion plugs only applies to oil cooled heads. If you have liquid cooled heads skip to page 4 and disregard the expansion plugs and installation tool that will not be needed.
- **Important!** Installation of the expansion plugs is required for oil cooled heads. Failure to install the plugs will cause an oil leak. Both the front and rear head must be plugged.
- If you are unsure which heads you have please **see Picture 1** for identification. Oil cooled heads will have 1 hole in the head gasket area. Liquid cooled heads will have 2 holes in the head gasket area.



Picture 1

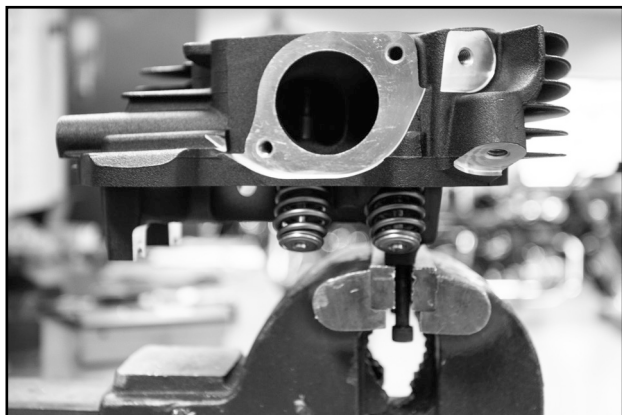
1. Securing Cylinder Head For Plug Installation

- a. Install two 5/16-18 x 2-1/2" bolts into the drive side rocker arm bosses. **See Picture 2.**



Picture 2

- b. Mount the cylinder head in a bench vise by clamping on the bolts. Be careful not to clamp on the cylinder head or damage will occur. **See Picture 3.**



Picture 3

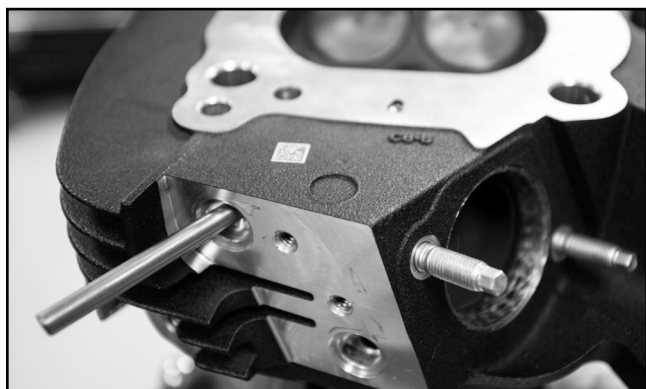
- c. Confirm the plug is completely inside the hole and resting against the installation tool. Use a hammer and a 5/32" flat end punch to tap the expansion plug ball until the ball is even with the top of the plug casing. **See Picture 6.**



Picture 6

2. Installing Expansion Plugs

- a. Install provided expansion plug installation tool into the oil passage closest to the head gasket surface until it stops. **See Picture 4.**



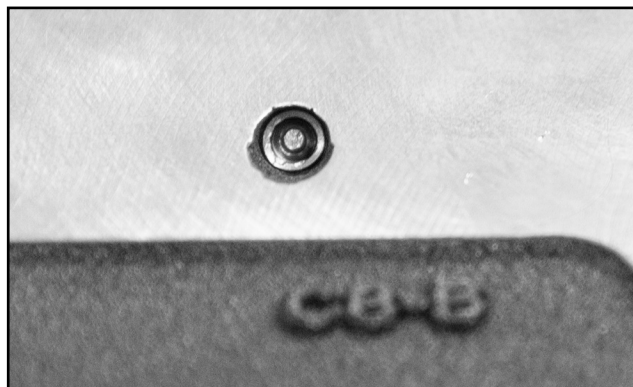
Picture 4

- b. Install expansion plug with the ball side facing up. Use a flat end 5/32" punch to slide the plug in until it stops against the installation tool. **See Picture 5.**



Picture 5

- d. Confirm the top of the expansion ball is flat with the top of the plug casing. It is normal for the top of the ball and casing to deform slightly. **See Picture 7.**



Picture 7

- e. Use a pair of channel locks to spin and pull on the installation tool for removal. **See Picture 8.**



Picture 8

- f. Repeat securing of the cylinder head and installation of the expansion plug for the other head.