

SJ013

Smog Jig Instructions

ENGINEQUEST

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- 1) Make sure cylinder head has smog pads.
- 2) Clean, magnaflux and check cylinder head for cracks.
- 3) Bolt jig to valve cover surface.
- 4) Use 33/64" drill to check alignment.
- 5) Clamp cylinder head to seat and guide machine or drill press.
- 6) Check hole depth. Set machine stop to bottom out correctly.
- 7) Drill large hole.
- 8) Drill hole in center of larger hole with a 3/8" drill bit.
- 9) Unbolt jig.
- 10) Tap center hole using 9/16-18 tap.

Order SD045 step drill to drill all holes in one pass.



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SD045