



Instructions

Congratulations on your purchase of a ProMAXX® engineered performance device! Our tools have the highest quality and precision in the market, delivering the most productive repair. All ProMAXX® tools are manufactured in the United States of America from American materials and craftsmanship. We proudly provide limited lifetime warranties and free unlimited technical support. **Need help with the repair? Contact ProMAXX Technical Support @ 724-941-0941**

1. MOUNT THE PROPLATE™ to the manifold or turbocharger set for repair using the included ProFasteners and included mounting schematic. Torque ProFasteners to 40 FT-LBS. · Use the long ProFasteners included in the kit for the Turbocharger & Turbo-side of the manifold. Use the included washers on the underside of the turbo only when mounting to the slotted bolt holes of the turbo. Use the shorter ProFasteners for the EGR-side of the manifold.

· **TIP:** The manifold is often heavily corroded. Use a wire brush and aggressively clean the back side of the manifold and Turbo mounting area where the ProFasteners will seat.

2. INSERT THE PROBUSHING™ into the ProPlate™. Then insert the corresponding ProDrill™ machine grade tooling bit (included) into an air or electric powered drill. Set the proper depth of the bit: · **For the EGR-side:** use the drill depth gauge, machined into the ProPlate™. **For the Turbo-side of the manifold:** set the drill bit to 1.5" and mark if necessary. Apply one drop of ProLube™ (PPL001).

· **TIP:** You will need to apply pressure to the drill while machining out the broken bolts. ProMAXX Tool recommends using a drill chuck that is key tightened to reduce bit slippage rather than hand tightened.

AVOID USING PENETRATING OIL/SPRAY OR OTHER LUBRICANTS WHICH ELEVATE CUTTING EDGE TEMPERATURES CAUSING THE BIT TO BURN AND CEASE CUTTING.

3. INSERT THE PRODRILL™ into the mounted ProBushing™ by slowly and manually turning the drill chuck until the ProDrill™ slips into the bushing and makes contact with the surface of the damaged stud. *(This will ensure the cutting edge is not damaged.)* *Repeat this procedure for each sequential step in your application.

4. SET THE CUTTING EDGE (CRITICAL STEP TO AVOID BIT FAILURE AND MAINTAIN PRECISE ALIGNMENT) - Apply light pressure at first by **activating your drill both on and off five times in one second intervals. This step creates a seat centered in the damaged bolt and reduces walking of the tooling bit even when drilling an angular surface.** Moreover, this step ensures a perfect match between the surface of the broken bolt and the cutting edge of the bit which distributes the load evenly across the bit's cutting edge.

5. MACHINE THE DAMAGED BOLT - Drill continuously at the proper RPM (see cutting speeds below). Once complete, extract the drill bit from the bushing and remove the bushing from the ProPlate. Using shop air and eye protection, blow air into the drilled hole, clearing it of debris and chips. Screw in your next sequential ProBushing and repeat steps 3 thru 5 machining the stud completely out (keeping cutting speeds in mind with each drill size). **After drilling out the stud** you may be able to use a pick to pull remaining remnants from the threads inside the manifold. Doing so will assist in a smoother operation in step 6.

6. CHASE THE THREADS and return the bolt hole to factory-new condition. Screw in the largest ProBushing™ and attach the included ProTap™ into a 3/8" drive tap socket. Guide the tap into the bushing and slow turn the ProTap clockwise one full rotation at first or until you will feel resistance on the tap as you turn it – never force the tap). Reverse your ratchet and turn the tap counterclockwise ¼ rotation. Using shop air and eye protection, blow down each of the four tap flutes clearing debris. Repeat this process until the tap stops at the bottom of the hole.

Approximate tooling cutting speeds (Under load):

SSSC125/PLT125@500 RPM - SSSC188/PLT188 @ 300 RPM - SSSC266/270/ PLT270 @ 250 RPM - SSC345 @ 200 RPM

PROMAXX™ machine grade tooling is specially engineered to close tolerances of (+) .000" and (-) .001" and ground straight to ensure accurate and repeatable results in using your new device. **Specify PROMAXX® genuine replacement parts and tooling for optimum performance and extended warranty coverage.** Always use appropriate OSHA approved safety glasses/goggle and protective gloves while using this device and performing this operation.

For Technical Assistance, or to re-order tooling
- call 724-941-0941



For video instruction, check out the QR code to the left! Simply hover your phone camera over the image and it will connect you to our fast, easy Youtube tutorial.



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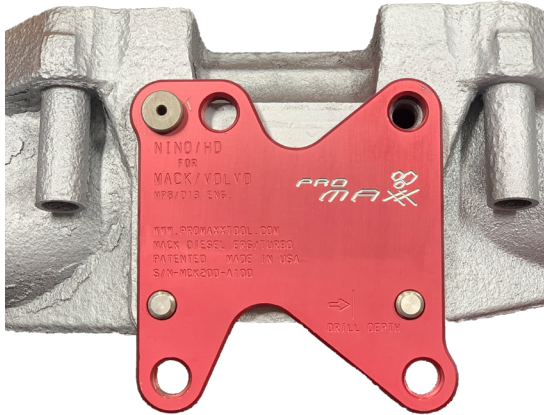


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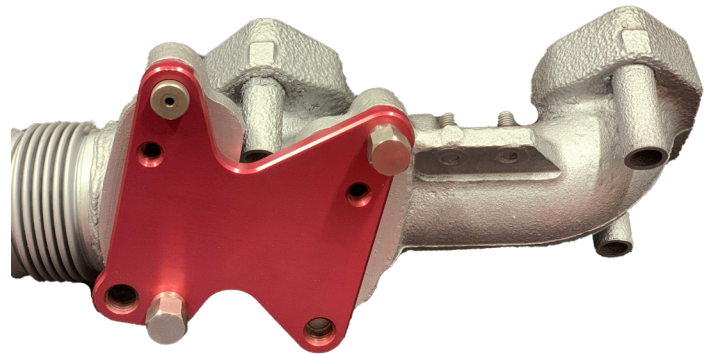




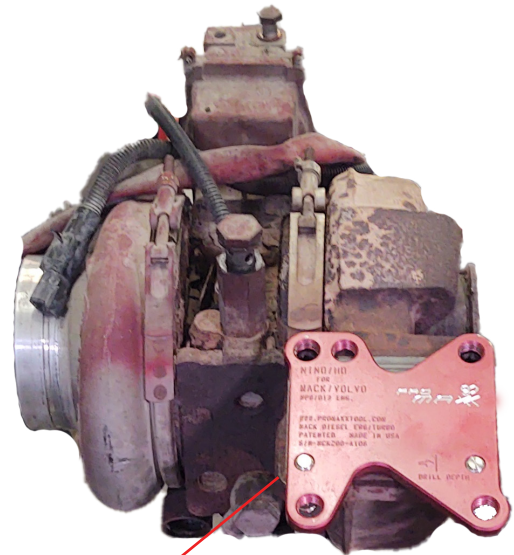
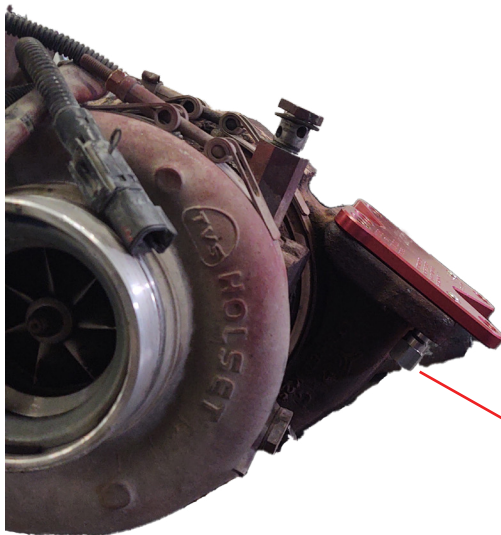
NINO HD MACK MP8 / VOLVO D13 PROPLATE MOUNTING & APPLICATION



TURBO-SIDE
LONG FASTENERS



EGR-SIDE
SHORT FASTENERS



TURBO
LONG FASTENERS

NEED HELP?
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We are only successful when you are.

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