



Instructions

Exhaust Manifold Repair

Thank you for your purchase of a ProMAXX® engineered performance device! Our tools have the highest quality and precision in the market delivering the most predictable and productive repair.

1. Mount the ProPlate™ to the cylinder head using the included Stainless ProFasteners following the enclosed cylinder head schematic. Torque to a minimum of 20 FT-LBS.
2. Insert the smallest ProBushing™ into the ProPlate™ and utilize the corresponding ProDrill™ machine grade tooling bit. Using drill depth gauge machined into the ProPlate™, set the proper depth of the bit and as necessary. Apply one drop of ProLube™ (PMXPL001) to the end of the bit. **AVOID USING PENETRATING OIL/SPRAY OR OTHER LUBRICANTS WHICH ELEVATE CUTTING EDGE TEMPERATURES CAUSING THE BIT TO BURN AND CEASE CUTTING.**
3. **Manually turn your 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:** While applying light pressure, **activate your drill both on and off five times in one second intervals (ten times if utilizing an air ratchet).** This is the **MOST CRITICAL** step of this repair, **creating precise alignment (a seat) for the tooling bit to stay on center and not follow the angular broken surface of the stud; apply load evenly across the entire cutting edge.** Once seated, drill continuously at the proper RPM not stopping until you have reached the desired depth. (see cutting speed chart included with your kit).
5. **EXTRACTOR OPTION: Prepare to Extract Remnant.** Remove the ProPlate™ and if your kit included the optional ProCutter™ deburring tool, (PMXPPC007A), then replace the ProDrill™ with the ProCutter™. Insert the protruding portion of the arbor into drilled hole. Toggle the drill on and off for five one-second intervals to remove the burr, clean the tapped hole, and flatten the broken stud. With ProTractor™ (PMXPPT125/188), place a mark approximately ¼" from the end and lightly hammer the ProTractor™ into the remnant to the ¼" depth line. **DO NOT INSERT THE PROTRACTOR ANY FURTHER THAN 1/4" depth line.** Place the included slip-nut over the ProTractor™ and slide it up against the cylinder head. While holding the opposite end of the ProTractor™ and using a high-quality calibrated torque wrench, slowly and carefully apply torque, first in the clockwise direction, and then in the counterclockwise direction to loosen the damaged stud. Repeat this motion several times **NOT EXCEEDING 65 IN-LBS OF TORQUE FOR THE PMXPPT125 OR 140 IN-LBS FOR THE PMXPPT188.** If using the PMXPPT125 and the damaged stud fails to release, **STOP and remove the ProTractor™ and proceed to the larger more robust PMXPPT188 ProTractor™.** Repeat steps 3-5 above.
6. **EXTRACTORLESS™ TOOLING OPTION:** If you purchased the EXTRACTORLESS™ option with or added to your EMR kit, you have the option to remove the broken stud with an extractor OR go EXTRACTORLESS™. For EXTRACTORLESS™, follow the drilling sequence of the PMXSSSC125/188/266 for an aluminum head, or PMXSSSC125/188/270 for a cast iron head. When finished drilling, insert the tap ProBushing™ into the mounted ProPlate™ and use the ProTap (PMXPPT008/PMXPPT010) to chase the threads clean. Apply one drop of ProLube (PMXPL001) to each flute of the ProTap. Turn one full turn of the ProTap when you begin, then turn counterclockwise 1/4-1/2 turn. Using compressed air, clean the cutting debris free by sending compressed air down each flute to remove any remaining material. This step will remove obstacles in the threads to reduce probability of tap failure.

NOTE: In the unlikely event an extractor fails or a tap breaks, **contact technical support at 724-941-0941 for recommendations and procedures.**
(ProMAXX® Broken Extractor kits available at www.promaxxtool.com)

NOTE: ProMAXX® **does not** recommend tapered left-handed screw extractors as they may deform the remnant increasing complexity of extraction. In addition, these extractors cannot be turned clockwise to unlock the damaged remnant. Approximate tooling cutting speeds (Under load): MIN: PMXSSSC125/PLT125@500 RPM, PMXSSSC188/PLT188@300 RPM, PMXSSSC266/270/ PLT270@250 RPM.

NOTE: **Some air ratchets may not generate sufficient RPM under load to be effective.** Visit www.promaxxtool.com to see ProMAXX® drilling solutions for optimum efficiency and maximum productivity: ProRatchet PMXPPR5260 OR PowerDrill™ PMXPPD2800PRO

All PROMAXX® machine shop grade tooling are made in the USA and are specially engineered to close tolerances of (+) .000" and (-) .001". They are ground straight to ensure accurate and repeatable results reducing walk and increasing efficiency when completing these repairs.

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.

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. If you need help with a repair, call us! You can reach ProMAXX® Technical Support at 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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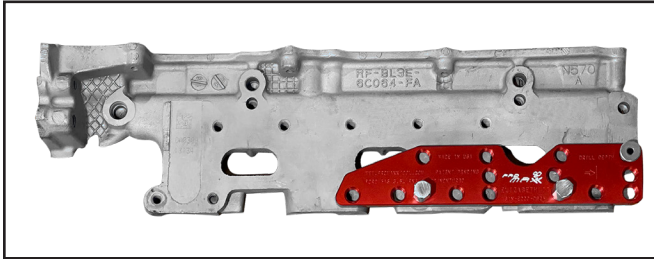


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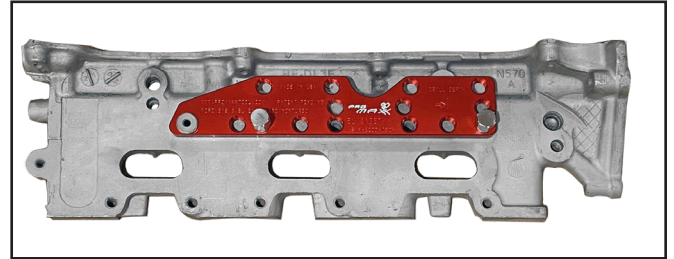




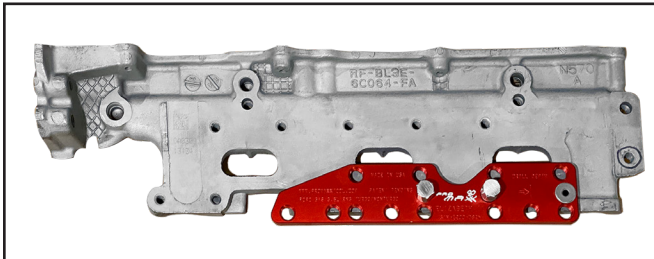
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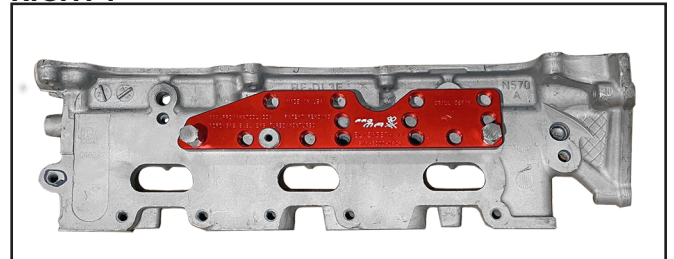
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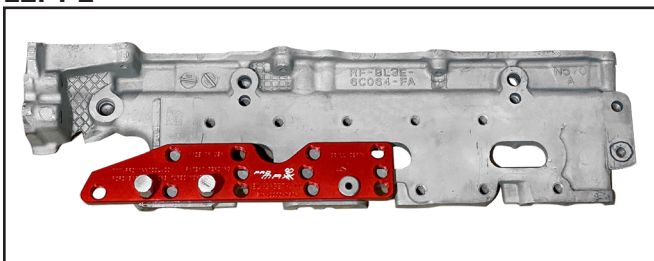
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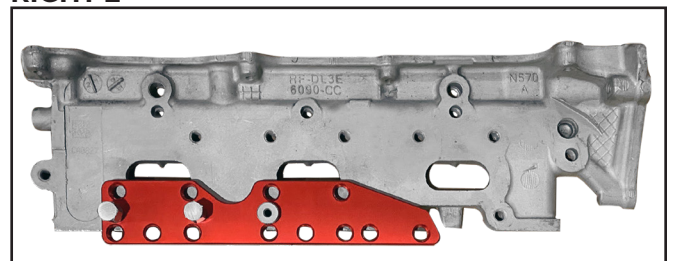
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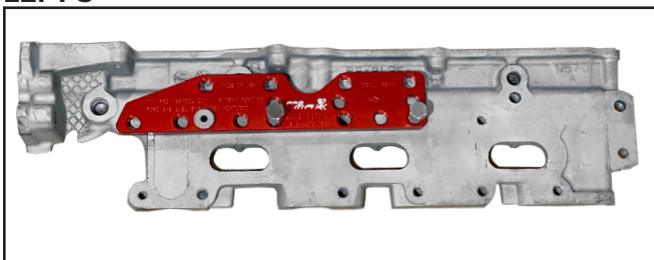
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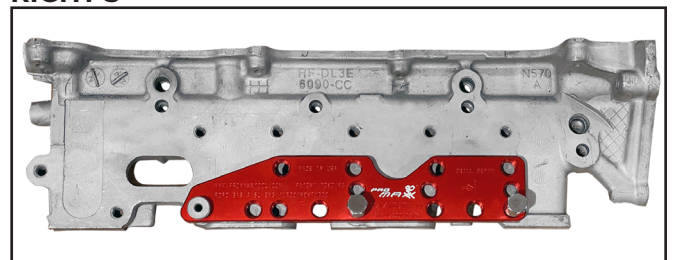
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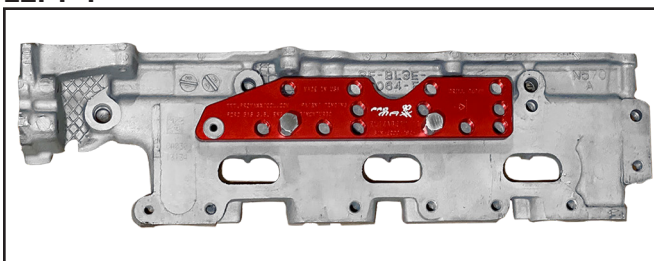
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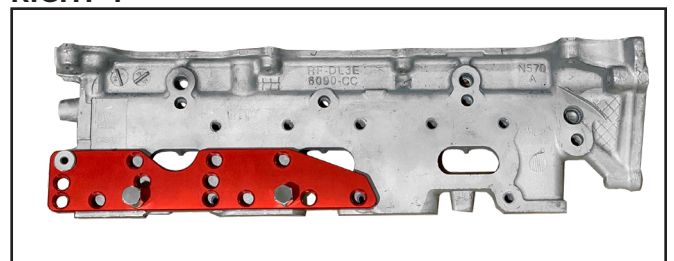
LEFT 4



RIGHT 4



LEFT 5






RIGHT 5

NEED HELP?
WE LOVE HELPING OUR CUSTOMERS!
DIAL 724-941-0941
We are only successful when you are.



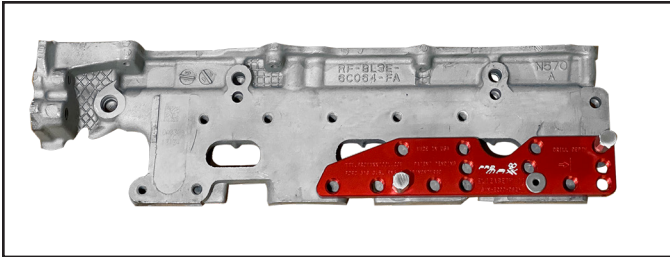
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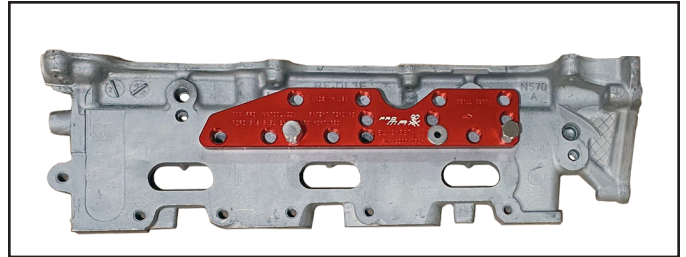




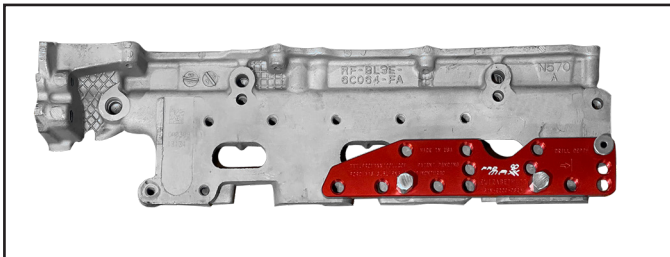
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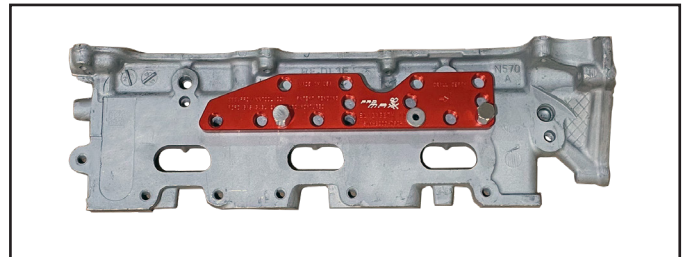
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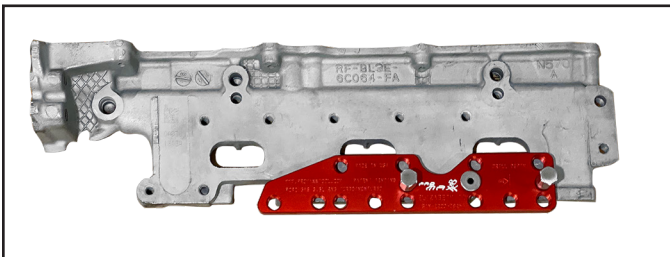
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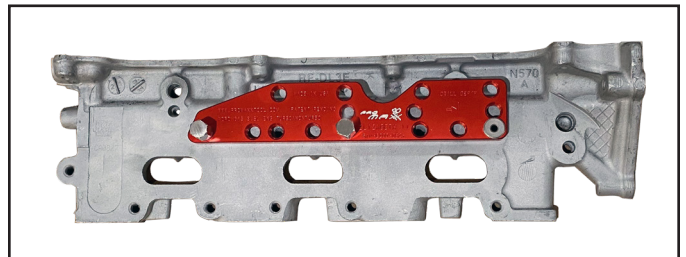
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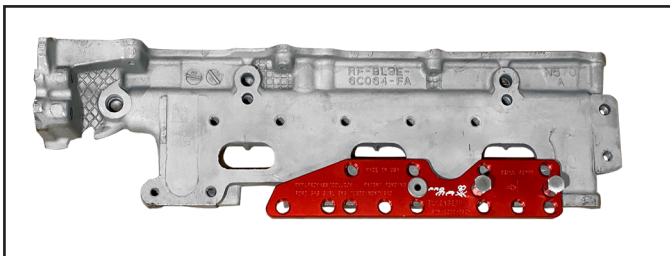
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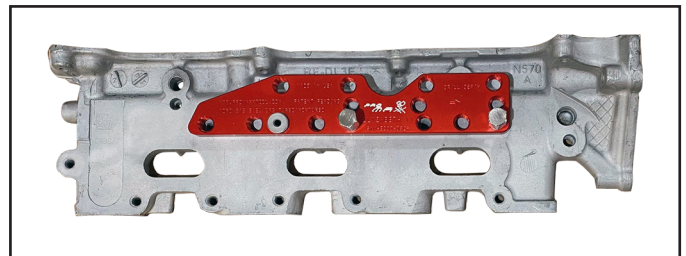
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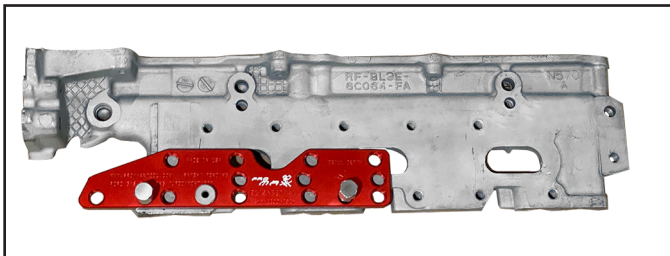
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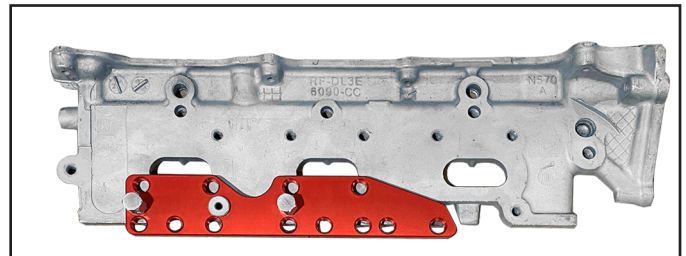
LEFT 9



RIGHT 9



LEFT 10



RIGHT 10



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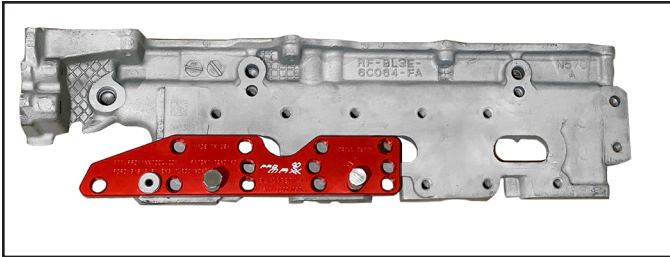


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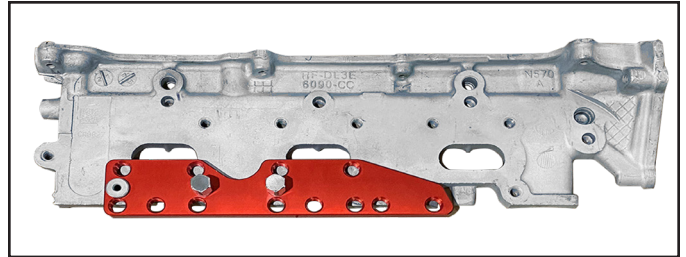




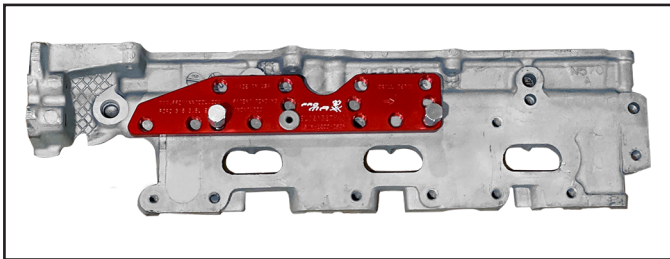
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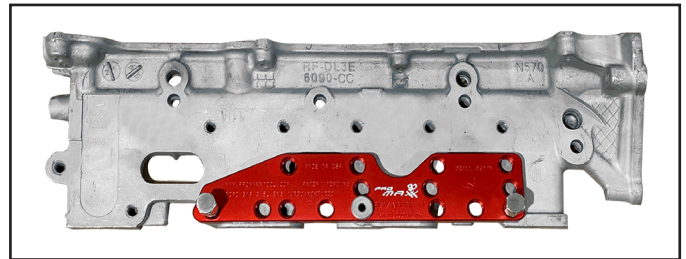
LEFT 11



RIGHT 11



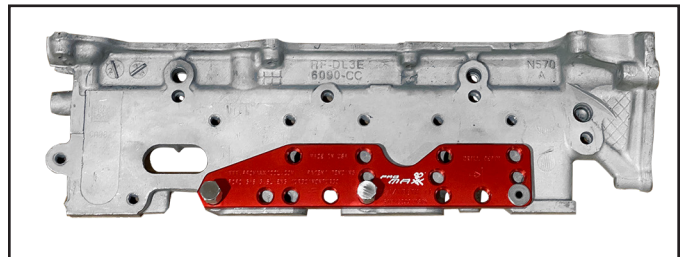
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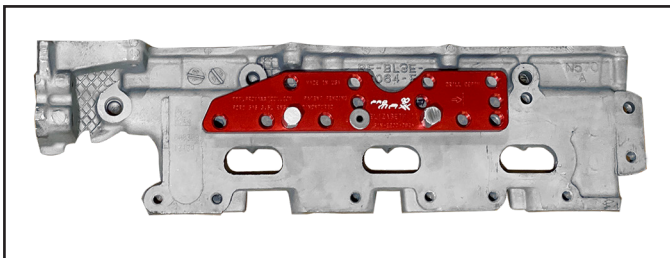
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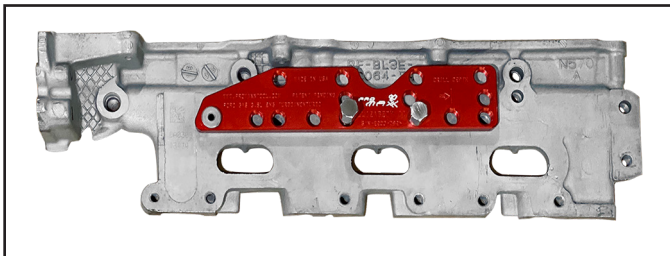
LEFT 13



RIGHT 13



LEFT 14



LEFT 15



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