



INSTRUCTIONS

EXHAUST MANIFOLD REPAIR

Congratulations on your purchase of a ProMAXX® engineered performance device! Our tools are the highest quality and precision in the market delivering the most productive repair. All ProMAXX® tools are manufactured right here in the United States of America from American materials by American craftsman. We are extremely proud of our products and as such we provide a limited lifetime warranty and free unlimited technical support to assist you in obtaining the most benefit from them. Let's get started!

1. Mount the ProPlate™ to the cylinder head using the included ProFast PPF010625-125 or PPF010625-150 precision fasteners according to the included cylinder head schematic. Torque to a minimum of 20 FT-LBS.

2. Insert the ProBushing™ and corresponding ProDrill™ machine grade tooling bit into an air-powered angled style drill and use the drill depth gauge machined into the ProPlate™ to set the proper depth of the bit and mark the bit if necessary. Apply one drop of the ProLube™ PPL001 drilling & tapping cutting fluid. **AVOID PENETRATING OIL/SPRAY OR OTHER LUBRICANTS.**

3. Insert the mounted ProDrill™ into the included ProBushing™ mounted in the ProPlate™ first by slowly and manually turning the chuck until the ProDrill™ slips into the bushing and contacts the surface of the damaged stud. This will ensure the cutting edge is not damaged. **Important step to avoid drill bit breakage.** While applying light pressure, **activate your drill both on and off five times (ten times if utilizing an air ratchet) in one second intervals. This is the MOST CRITICAL step of this repair as it facilitates precise alignment by creating a "seat" for the tooling bit to stay on center and not follow the angular broken surface of the stud.** Moreover, this step allows the surface of the stud to conform to the cutting edge of the bit distributing the load evenly across the entire cutting edge of the bit providing for cutting extremely hard surfaces and extending cutting tool life.

4. After this initial start, drill continuously running your drill at the proper RPM (see below) and while the bit is turning, **extract the bit in and out of the damaged stud** while maintaining it in the bushing to "clean" or "excavate" cutting debris from the stud. Repeat this step progressively exerting more pressure until your drill reaches the maximum depth.

Begin the Extractorless™ Repair: Using the larger ProDrill™ and the corresponding ProBushing, drill continuously, regularly excavating chips and debris from the drill flutes. Repeat this step with your remaining drill steps. Clear all debris, insert the largest ProBushing™ and attach your tap holder to the ProTap™ PPT010125. Apply two drops of ProMAXX® ProLube™ to the tap. Insert the ProTap™ PPT010125 into the bushing, slowly and carefully turning the tap by hand first clockwise ¼ turn, then counterclockwise ¼ turn, blow down the flutes of the tap to clean debris frequently and repeat this process until the tap stops cutting.

You may also contact technical support at 724-941-0941 for recommendations and procedures.

NOTE. Approximate tooling cutting speeds (Under load): MIN: SSSC125@500 RPM, SSSC188/PLT188@300 RPM, SSSC270/PLT270@250 RPM and SSSC340@250 RPM.

NOTE: Some air ratchets may not generate at sufficient RPM under load to be effective. SEE ProMAXX® ProRatchet PPR5260 or PowerDrill™ PPD2800 at www.promaxxtool.com for optimum efficiency and maximum productivity.

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.

NEED HELP? WE LOVE HELPING OUR CUSTOMERS!

DIAL 724-941-0941

We are only successful when you are



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.



1121 Boyce Rd Suite 2000, Pittsburgh, PA 15241



(724) 941-0941



www.promaxxtool.com

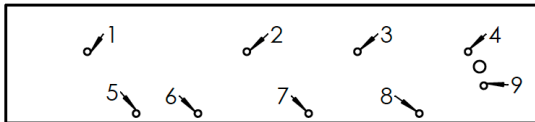




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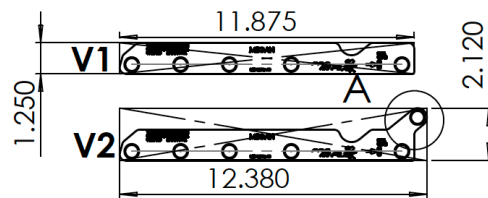
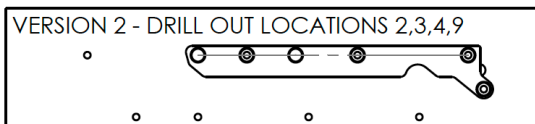
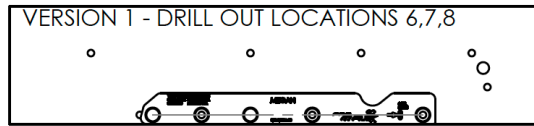
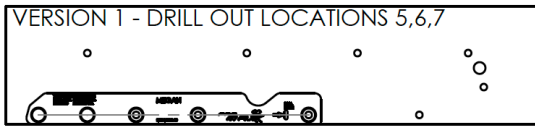
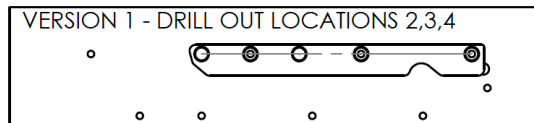
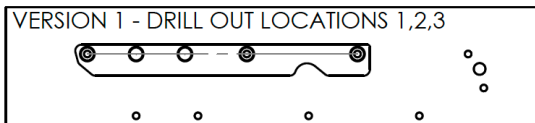
PROPLATE MOUNTING & APPLICATION

FORD V8 6.2 LITER (MEGAN TOOL CONCEPTS)



NOTE: VERSION 1 AND 2
ARE IDENTICAL EXCEPT FOR
LOCATION 9 EXTENSION

DETAIL A
SCALE 2 : 5



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