



INSTRUCTIONS

Rosina DMX-TURBO Y PIPE REPAIR

The ProMaxx® ProPlate™ included in this kit was designed as an Extractorless® kit to assist in repairing the main turbo charger “Y” pipe flange in the GM Duramax diesel engine commonly found in the Chevrolet / GMC Silverado / Danali trucks without removing the turbo charger. Used properly, this device can significantly reduce repair times and risks associated with restoring the mounting holes to factory-new.

Mount the ProPlate™ to the turbo charger using the included ProFast™ precision stainless steel fasteners. Insert the proper ProBushing™ and corresponding ProDrill™ precision-machined tooling bit into an air-powered drill and use the drill depth gauge machined into the ProPlate™ to set the proper depth of the bit. Open the cap on the ProLube™ PPL001 machinist’s drill and tapping fluid oil and insert the small tooling bit in through the cap, gasket, and retract. For larger tooling and subsequent machining, use just one drop placed on the end of the ProDrill™ when necessary. **AVOID PENETRATING OIL/SPRAY OR OTHER LUBRICANTS.** Insert the mounted ProDrill™ into the included ProBushing™ PPB3125 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 maintained. While applying light pressure, activate your drill both on and off ten times in approximately one second intervals. This initial process is critical in that it creates a “seat” for the bit to rest and ensures that the bit will stay on center and not follow the angular surface of the damaged bolt/stud. Moreover, this action reduces the probability of the tooling bit to break and drill off center. **Proceed to drill continuously at the proper RPM as provided below.** Repeat this step frequently while continuing to apply more pressure until the drill chuck rests on the bushing.

Remove ProBushing™ PPB3125 (SML) and replace with the PPB3188 (MED) and follow with the ProDrill™ SSSC188 using the same procedure as above, manually inserting the ProDrill into the bushing by hand and then start and stop your drill on and off prior to drilling continuously. Remove ProBushing™ PPB3188 (MED) and replace with the PPB3270 (LRG) and follow with the ProDrill™ SSSC270 using the same procedure as above. Using compressed air, clean the debris. Remove ProBushing™ PPB3270 (LRG) and replace with the ProBushing™ PPB3320 (TAP). Place one drop of ProLube™ drill and tap-cutting lubricant on the ProTap™. Slowly begin to restore the threads by turning the tap at 1/2 revolution intervals clockwise and counter-clockwise periodically stopping to clean debris from each flute of the tap. Continue to clean the threads until the tap stops. Removing the tap is not necessary. Continue to clean the threads until the tap stops. **DO NOT OVER TORQUE TAP.**

In the unlikely event a tap fractures, visit www.promaxxtool.com and purchase the ProTap™ extractor kit or call 724-941-0941. The Tooling included in your kit are precision machine-shop grade quality, made in the USA and engineered as a complete system to ensure complete success.

USE ONLY GENUINE PROMAXX® MACHINE GRADE PARTS. Tooling cutting speeds (Under load): MIN: SSSC125@350 RPM, SSSC188@200, SSSC270@150. MAX: SSSC125 @900 RPM, SSSC188@300, SSSC270@250. OPTIMUM: SSSC125/SSSC @500 RPM, SSSC188@250

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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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