

# SDJ-1 Chevy Starter Drill Jig Instructions

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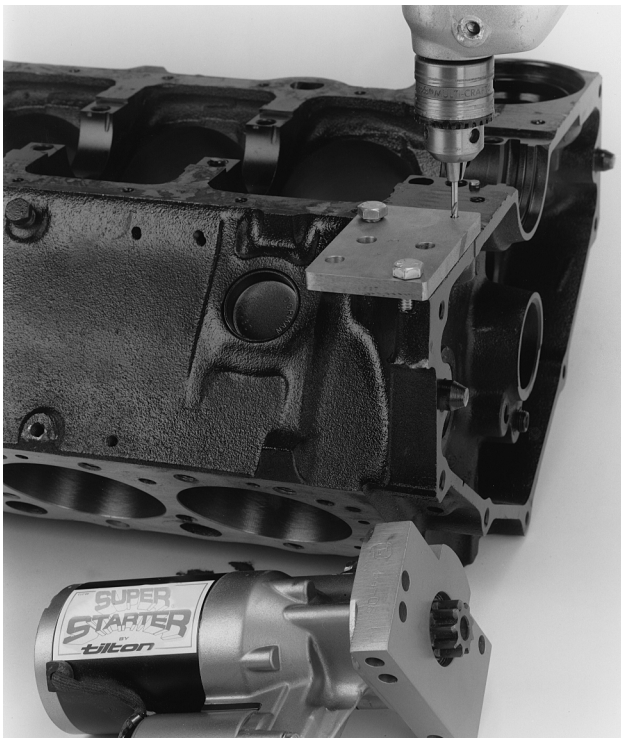
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# SDJ-1

For use with big block or small block Chevrolet.

**Please read instructions  
before using.**



## Introduction

Using one of the three plates, any of the three Chevy starter mounting bolts which are broken can be drilled on center with no likelihood of going off center.

The plates will enable you to drill the missing bolt with precision, in two steps, with the proper size hole for tapping.

The plates are hardened for long wear and come with mounting bolts.

## Broken bolts

By using a sequence combination of these three jig plates, any one of the three starter mounting bolts can be accurately drilled for removal.

If the bolt is broken squarely and close to surface, start with the pilot drill (5/32 or #21). If the bolt is broken deep and not squarely, use the large (5/16) drill first to clean up and center drill the bolt. You then return to the pilot drill (5/32 or #21) and drill through the bolt. Drill through and use the appropriate Easy Out. If this fails, go to the larger drill jig (5/16), then tap carefully.

## Third bolt hole not drilled

Start with the pilot drill jig (5/32 or #21) and drill approximately 3/4" deep. Next go to the large (5/16) drill, and drill to the bottom of the pilot hole and tap.

## Tips

- Go Slow! A block is expensive. There is no excuse for hurrying.
- The pilot drill should not be used to center a deep or un-square broken bolt. Use the large drill (5/16) to center drill the bolt, but only deeply enough so the pilot drill will start centered.
- When drilling the rear bolt hole, which is not drilled, the drill will go through at about 3/4" deep, which is okay. The front hole is blind. Stop at approximately 3/4" deep.
- The edge of the plates should line up squarely to the back edge of the block. If it's not square, something is wrong. Find out what is wrong before proceeding.