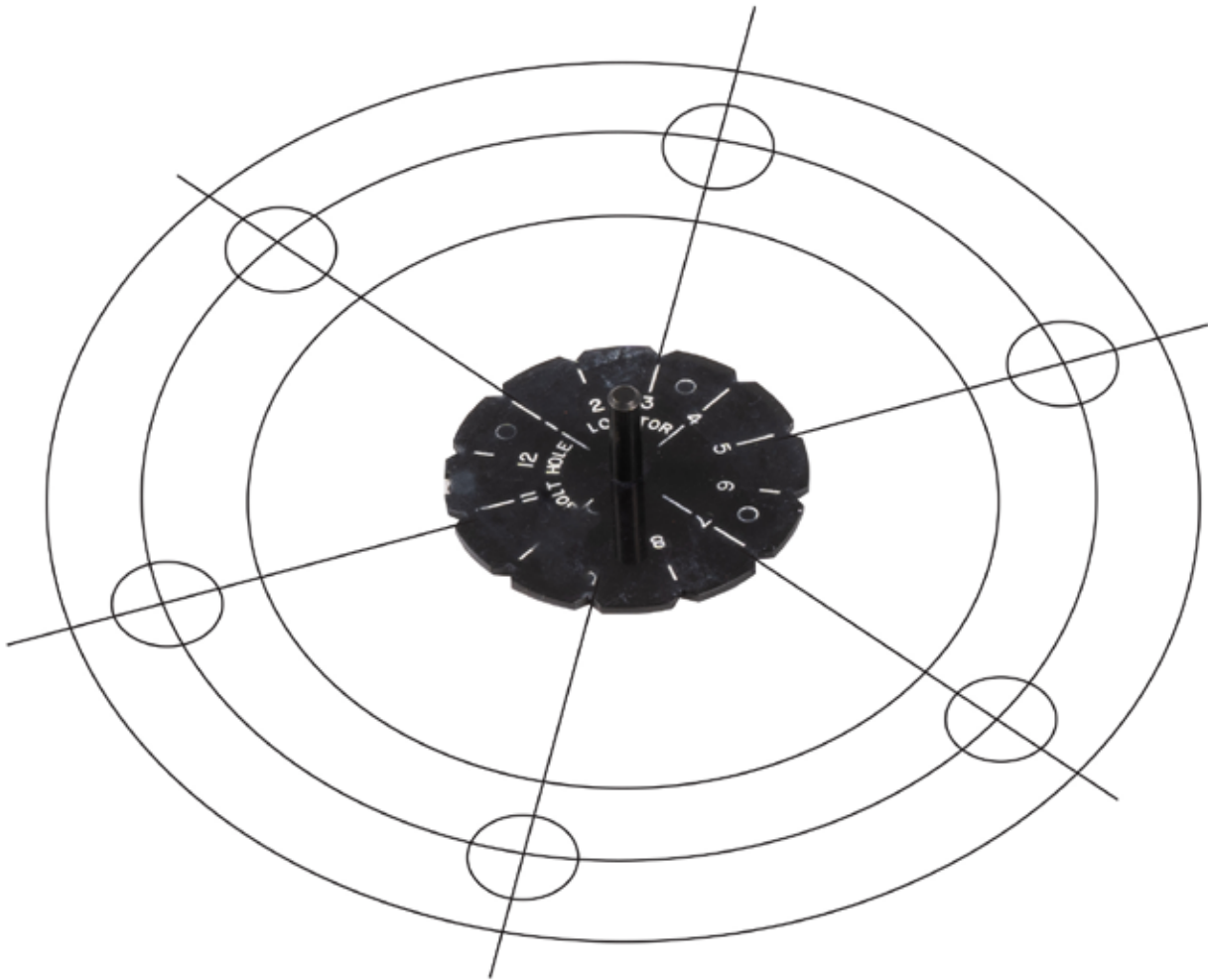


# Guide to Perfect Gaskets

## BOLT HOLE LOCATOR



# LAY OUT GASKETS WITH BOLT HOLES



**1.** Lay blank sheet of paper or gasket material on cutting board. Locate approximate center point and mark.



**2.** Measure and mark outer diameter (OD), inner diameter (ID), and pitch circle diameter (PCD) with straight edge.



**3.** Pierce center point of paper or gasket material with center pin. Insert protruding center pin into recessed ferrule on cutting board. Using center point, use gasket cutter as compass by either holding a pencil against the outer edge, or with cutting blade to make very shallow cut. Scribe OD, ID and PCD.



**4.** Position Bolt Hole Locator over center point. Insert center pin into recessed ferrule on cutting board. Press down firmly to hold Bolt Hole Locator in place.

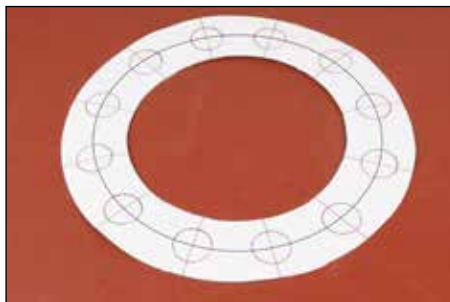


**5.** Note required number of bolt holes on desired gasket. Common configurations are 4, 6, 8, 12, and 24 bolt holes. Using a pencil, mark the following points on paper or gasket material utilizing notches around perimeter of Bolt Hole Locator:

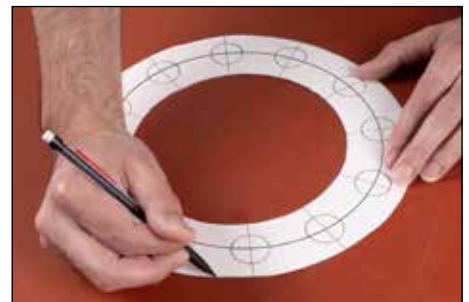
• <b>4 BOLT HOLES:</b>	Mark 1, 4, 7 & 10
• <b>6 BOLT HOLES:</b>	Mark 1, 3, 5, 7, 9 & 11
• <b>8 BOLT HOLES:</b>	Mark 1, 4, 7, 10 & midway between 2-3, 5-6, 8-9 & 11-12
• <b>12 BOLT HOLES:</b>	Mark 1 through 12
• <b>24 BOLT HOLES:</b>	Mark 1 through 12 & midway between each number



**6.** Place straight edge over pairs of opposite marks (for example 1 and 7). Using a pencil, extend straight line to PCD. Where straight line intersects with PCD is center point for bolt hole. Repeat for each pair of opposite marks.



**7.** If gasket design is laid out on paper, using scissors cut out the paper template.



**8.** Measure OD and ID of gasket material and cut.

## LAY OUT GASKETS WITH BOLT HOLES (continued)



**9.** Lay template on top of partially finished gasket. Use piercing tool to transfer bolt hole center points onto gasket. Punch out bolt holes with hole punch.