

COPPER GASKET INSTALLATION

Copper requires special attention to work properly

1. Check the fit of the gasket. Gaskets are sized as close as possible, but you may need to use a very fine file or deburring tool for final fit. No part of the gasket should enter bore area. Check dowel fit too.
2. Anneal the gasket by heating to a dull red (a propane torch works well), then quenching in cold water.
3. Make sure all the sealing surfaces are very clean, dry and flat with no ridges. Once it's ready to install, handle your copper gasket carefully, touching only the edges. An oily fingerprint on the sealing surface can cause leaks.
4. When the surfaces are properly cleaned, spray gasket surface with Permatex High Tack 'Spray a Gasket' (Part# 98H or 98D).
5. After curing time has elapsed, assemble the motor following manufactures specs, making sure no oil or grease touch the gasket surfaces.
6. Torque the head bolts to the recommended setting and in the proper sequence (new head bolts are recommended). Dirt, rust or other contamination cause torque specs to be reached before you get proper bolt stretch.
7. Follow our Engine Assembly Tips for break-in procedures.

COPPER GASKETS ARE REUSEABLE. A USED COPPER GASKET IN GOOD CONDITION CAN BE CLEANED, RE-ANNEALED AND RE-INSTALLED

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