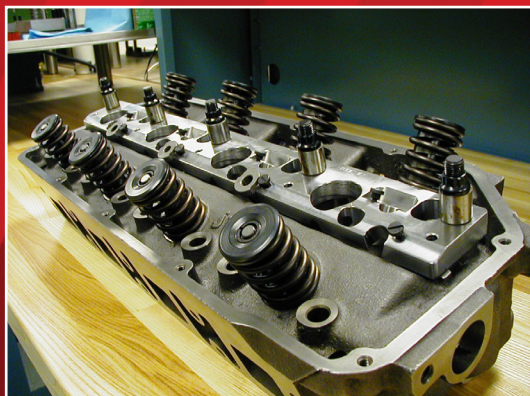


Instruction Sheet

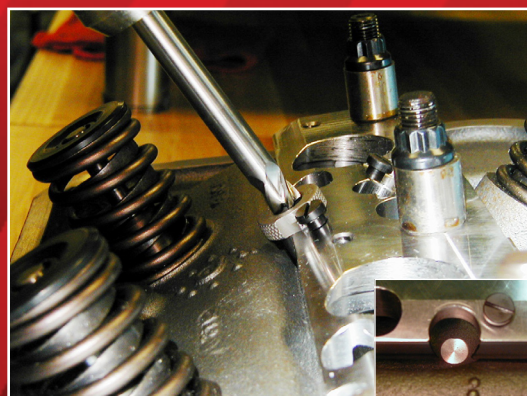
Chrysler Hemi Drill Jig

Cast Iron Cylinder Heads

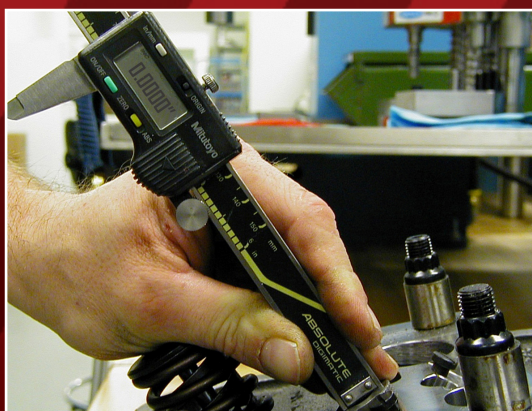
INS-29140



STEP 1: SECURE THE DRILL JIG TO THE CYLINDER HEAD.



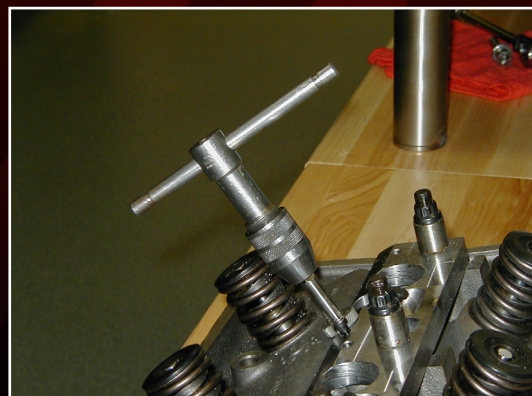
STEP 2: INSTALL THE $\frac{13}{32}$ " DRILL BUSHING INTO THE DRILL JIG. MILL THE HEAD USING THE SPOTFACE CUTTER UNTIL THE SURFACE IS CLEAN.



STEP 3: INSTALL THE "O" DRILL BUSHING. ZERO OUT VERNIER CALIPER FROM SPOTFACE SURFACE TO THE TOP OF THE DRILL BUSHING.



STEP 4: DRILL NEW HOLES FOR MOUNTING STUDS TO A DEPTH OF .870" \pm .025".



STEP 5: INSTALL THE "W" DRILL BUSHING AND TAP USING THE 3/8-16 H2 HAND TAP FOLLOWED BY THE 3/8-16 H2 BOTTOMING TAP.



STEP 6: INSTALL THE APPROPRIATE STUD AND CHECK TO SEE THAT THERE IS FULL THREAD ENGAGEMENT INTO THE HEAD.

TOL-29140

CHRYSLER HEMI DRILL JIG

QUAN	PART NUMBER	DESCRIPTION	COST
5	BLT-25291	7/16 x 5.500" Drill Jig Bolt	\$7.00 ea
5	NUT-24560	7/16-14 Drill Jig Nut	\$3.00 ea
5	WSH-20695	7/16 Flat Washer	\$1.00 ea
8	TOL-25290	Jergens Lock Screw	\$1.50 ea
1	TOL-25292	Drill Jig Plate	\$175.00
1	TOL-25293	3/8-16 H2 Hand Tap	\$18.00
1	TOL-25294	3/8-16 H2 Bottoming Tap	\$18.00
1	TOL-25295	"O" Jobber Drill Bit	\$19.00
1	TOL-25297	13/32 Drill Bushing	\$30.00
1	TOL-25298	"W" Drill Bushing	\$30.00
1	TOL-25299	"O" Drill Bushing	\$30.00
1	TOL-29100	Spotface Cutter	\$70.00

TOOL RENTAL TERMS:

A SECURITY FEE OF \$400.00 IS REQUIRED FOR THIS TOOL RENTAL. THIS FEE MAY BE CHARGED TO A CREDIT CARD OR BILLED TO AN OPEN ACCOUNT. THIS TOOL MUST BE RETURNED IN UNDAMAGED FORM WITHIN 20 DAYS OF THE ORIGINAL INVOICE DATE. AN ADDITIONAL FEE MAY BE CHARGED IF THE TOOL IS NOT RETURNED WITHIN THE SPECIFIED TERMS. UPON RETURN OF THE TOOL TO JESEL, A CREDIT OF \$300.00 WILL BE RETURNED TO YOUR ACCOUNT PROVIDING ALL THE COMPONENTS LISTED ABOVE ARE RETURNED IN SATISFACTORY CONDITION. IF ANY COMPONENTS ARE MISSING OR DAMAGED, THE REPLACEMENT COST FOR THE PARTS WILL BE DEDUCTED FROM YOUR CREDIT.

www.jesel.com

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