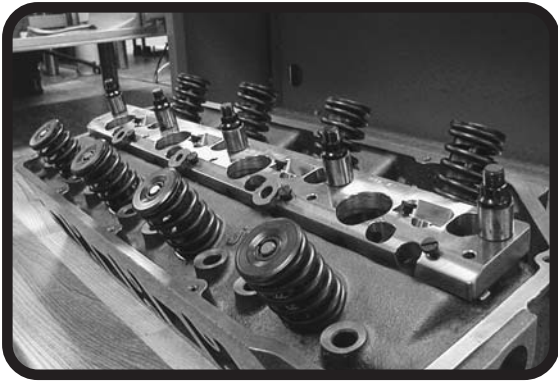


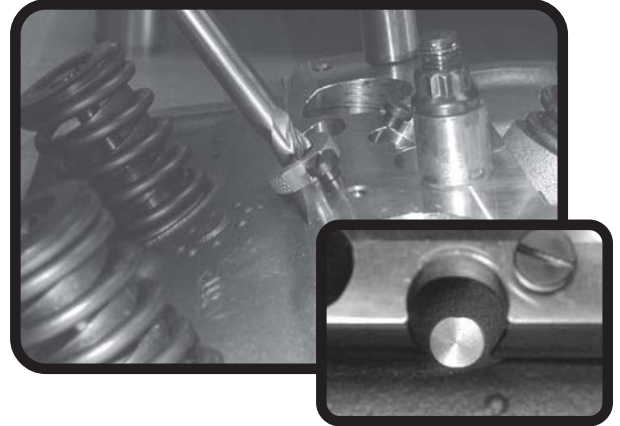
# CHRYSLER HEMI DRILL JIG

(FOR CAST IRON HEAD CASTINGS ONLY)

JESEL INSTRUCTIONS FOR DRILLING AND TAPPING CHRYSLER CYLINDER HEADS FOR INSTALLATION OF 3/8" ROCKER SHAFT STUDS INTO SECONDARY SPARK PLUG LOCATION.



**STEP 1:** SECURE DRILL JIG TO CYLINDER HEAD BY EITHER BOLTING JIG THROUGH HEAD AND INTO BLOCK OR BY USING WASHERS AND NUTS TO SECURE IT TO THE DECK SURFACE.



**STEP 2:** INSTALL THE 13/32" DRILL BUSHING INTO DRILL JIG. MILL HEAD USING SPOTFACE CUTTER UNTIL THE SURFACE IS CLEAN.



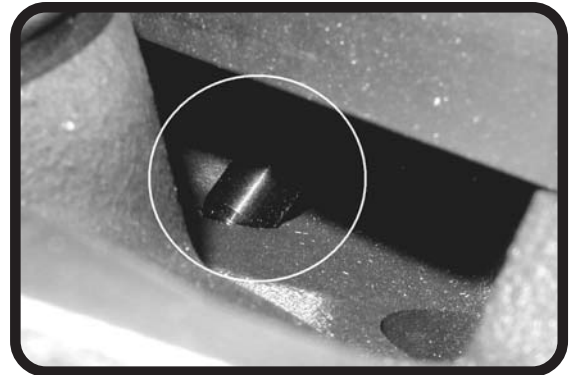
**STEP 3:** INSTALL "O" DRILL BUSHING. ZERO OUT VERNIER CALIPER FROM SPOTFACE SURFACE TO THE TOP OF THE DRILL BUSHING.



**STEP 4:** DRILL HOLES TO A MAXIMUM DEPTH OF .870" (OR + .025)". WARNING: DO NOT RE-DRILL HOLES ONCE THEY HAVE BEEN TAPPED FOR THREADS.



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



**STEP 6:** SCREW IN THE PROPER STUD THAT IS SUPPLIED IN THE ROCKER ARM KIT AND CHECK TO SEE THAT YOU HAVE FULL THREAD ENGAGEMENT.

(ALL MACHINE WORK DONE IN-HOUSE BY JESEL VALVETRAIN INNOVATION)

# TOL-29140

## CHRYSLER HEMI DRILL JIG

QUANTITY	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
1	TOL-25292	Drill Jig Plate	\$175.00 ea
8	TOL-25296	Jergens Lock Screw	\$1.50 ea
1	TOL-25293	3/8-16 H2 Hand Tap	\$18.00 ea
1	TOL-25294	3/8-16 H2 Bottoming Tap	\$18.00 ea
1	TOL-25295	"O" Jobber Drill	\$19.00 ea
1	TOL-29100	Spotface Cutter	\$70.00 ea
1	TOL-25297	13/32 Drill Bushing	\$30.00 ea
1	TOL-25298	"W" Drill Bushing	\$30.00 ea
1	TOL-25299	"O" Drill Bushing	\$30.00 ea

### 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.



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