

DJ035

Chevrolet 2 to 3 Bolt Starter Hole Conversion Jig Instructions

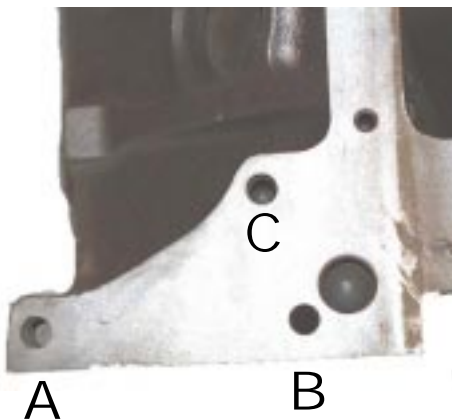
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Convert Chevrolet 6 cylinder and Small Block V8 with 2 bolt hole started pad to a universal 3 bolt hole.

Also can be used for broken starter bolt hole repair.

Tools Needed

- 3/8" drill bit • 5/16" drill bit • 3/8 x 16 NC Tap

Drilling 3rd Starter Bolt Hole On Small Block V8 Chevrolet.

- 1) Bolt drill jig to block using bushing holes "A" and "C" with top up. (top is the side that bushings stick up.)
- 2) Insert a 3/8" drill bit in bushing hole "B" and drill a depth of 5/16"
- 3) Insert 5/16" drill bit through bushing hole "B" and drill all the way through the pad. Make sure the 5/16" drill bit stays in the center on the 3/8" hole that has been started.
- 4) Unbolt jig
- 5) Tap hole with 3/8" x 16 NC Tap

Drilling 3rd Starter Bolt Hole On L6 250-290 Chevrolet.

- 1) Bolt drill jig to block using bushing holes "A" and "B" with top up. (top is the side that bushings stick up.)
- 2) Insert a 3/8" drill bit in bushing hole "C" and drill a depth of 1/16"
- 3) Insert 5/16" drill bit through bushing hole "B" and drill all the way through the pad. Make sure the 5/16" drill bit stays in the center on the 3/8" hole that has been started.
- 4) Unbolt jig
- 5) Tap hole with 3/8" x 16 NC Tap

Re-drilling outermost starter bolt hole after block repair

- 1) Bolt drill jig to block using bushing holes "B" and "C" with top up. (top is the side that bushings stick up.)
- 2) Insert a 3/8" drill bit in bushing hole "A" and drill a depth of 1/16"
- 3) Insert 5/16" drill bit through bushing hole "A" and drill all the way through the pad. Make sure the 5/16" drill bit stays in the center on the 3/8" hole that has been started.
- 4) Unbolt jig
- 5) Tap hole with 3/8" x 16 NC Tap