

# SJ001

## Smog Jig Instructions

**ENGINEQUEST**

**(800) 426-8771** toll free

**(702) 649-7776** local

**(702) 649-6777** fax

**[www.enginequest.com](http://www.enginequest.com)**

- 1) Make sure cylinder head has smog pads.
- 2) Clean, magnaflux and check cylinder head for cracks.
- 3) Do not reinstall valves and springs till head is drilled.
- 4) Bolt jig to valve cover surface, check for alignment.
- 5) Check alignment with 29/64" drill: make sure bushings and holes are properly aligned.
- 6) Clamp head to seat and guide machine or drill press.
- 7) Check depth of holes to be drilled. Set machine stop to bottom out correctly.
- 8) Use SD038 Step drill to drill holes. Proceed to step 10. If step drill is not used go to step 8.
- 9) Drill large hole with 29/64" step drill.
- 10) Drill hole in center of large hole with 3/8" drill bit for smog tubes.
- 11) Unbolt jig and tap holes to bottom with 1/2-20 NF tap.