

# SJ006

## Smog Jig Instructions

**ENGINEQUEST**

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