

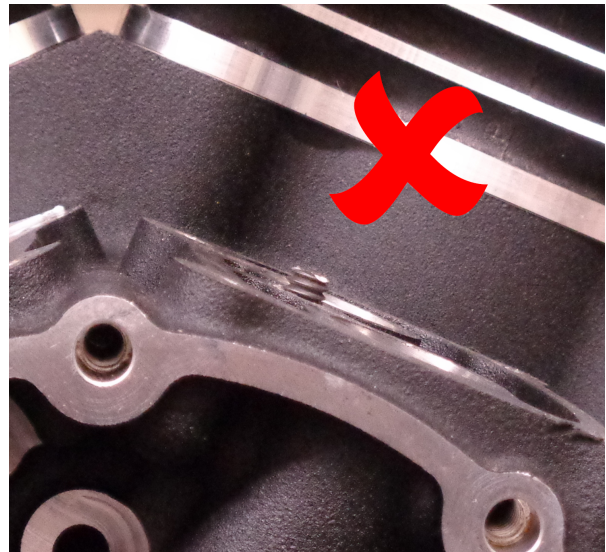


Installation instructions for R&R M8 Tappet Cuff Drill Jig

The R&R M8 tappet cuff drill jig is a tool that will help drill out the broken bolt on Milwaukee Eight tappet cuffs while engine is in the frame. To use this jig will require the following tools

- 1. 90 degree drill (if using an air drill a regulator is required to run drill around 500 RPM, do not use an air drill at full speed for risk of breaking drill bit)*
- 2. Masking or other tape to mask off opposing lifter block areas*
- 3. Air gun*
- 4. Shop vac or other vacuum*
- 5. Shop rags or paper towels*

Before you start if bolt has broken off above gasket surface do not use this tool. Jig requires a flat gasket surface to work properly.



Step 1
Completely disassemble and clean cam chest.



Step 2
To prevent chip contamination, stuff clean rags in cam chest cavity and lifter bores, mask off opposing lifter block and install cam cover.



Step 3

Install appropriate Jig plate for the lifter block (F for front, R for rear) using four supplied allen bolts, torque to 8 Ft Lbs.



Step 4

Measure and mark drill bit at 1.5 inches from the tip. This will act as a guide when drilling out the broken stud.



Step 5

Using a 90 degree drill slowly drill out the broken stud. Be sure to *TURN IT SLOW!!!!* 500 RPM or less stopping often to blow out and vacuum the chips from the hole. It is a slow process. Rushing, too much speed or pressure risks breaking the hardened drill bit off in the bolt requiring engine removal and disassembly to remove. Continue process until you reach the 1.5 inch mark you made on the drill bit.



Step 6

Blow out and vacuum any chips. Remove Jig and mask surface. Remove tape from around bolt hole. Using tapping oil, run 1/4"x 20 tap slowly into the hole to remove remaining bolt material, stopping and removing tap to clean both tap and blow and vacuum chips several times during process.



Step 7

Remove cam cover, tape and rags. Clean lifter bores and cam chest cavity of all chips and tapping fluid. Check bolt engagement.

