

1. clean block surface and water jacket.
2. cover block surface with masking tape then remove with razerblade the water jacket opening
3. plug water pump port with alumnium foil.



4. fill the water jacket with salt till about 3/4" remains be sure block is level! .use a screw driver to level salt out.



5. MIX EPOXY IN SMALL BATCHES 8 to 1 RATIO TILL LIGHT BLUE COLOR IS ACHIVED

(carbon kits mix the the carbon flakes in AFTER! GO SLOW ON THE FLAKES if you cant pour it youve likely went alittle too far but dont fret if you move fast you can push them in and it will work just fine.)

6. pour epoxy in to the jacket i prefer to use a small funnel. THE EPOXY WILL REST YOU WANT TO BUILD IT UP FLAT IN STAGES. if you spill it on anything clean up lmidiatly!

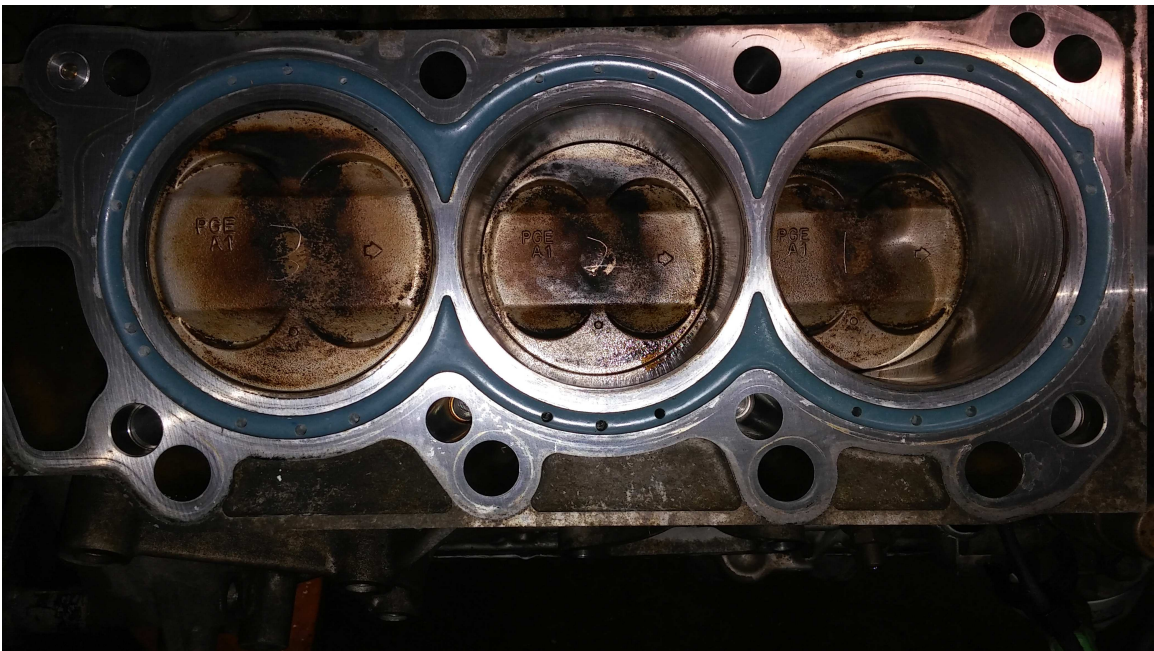
7. after 30 min or so remove tape and use a paper towel to clean block surface.

8. allow epoxy to cure atleast 8 hrs at no lower than 45* the warmer the better. cold temps will increse cure time.



9. when epoxy is fully cured place head gasket over the block surface then mark water ports in the gasket to the block with a marker.

10. use a small drill bit to drill through the marked areas till you reach the salt. WARNING THE HOLES MUST NOT BE TOUCHING THE SLEEVE IF IT DOES THIS PROSESS IS USELESS. be sure the drill is dead center use a nice drill bit! IIRC used a 5/16 bit



11. wash the salt out of the block throughly i use the car wash. then youre done!



