



Optional Extractor-less Repairs

PPB3125 with ProDrill™ SSSC125 PPB3188 with ProDrill™ SSSC188 PPB3340 with ProDrill™ SSSC340 PPB3395 with ProTap™ PPT010



Congratulations on your purchase of the new ProMAXX® Exhaust Manifold Repair Kit! We engineered this kit for fast and easy removal and replacement of broken exhaust manifold mounting studs in the Ford V8 gas 6.2 L engines. Mount the ProPlate™ to the cylinder head in any one of the positions shown above using the included ProFast™ PPF008625 precision stainless steel fasteners. Insert the proper ProBushing™ and corresponding ProDrill™ (see above) precision-machined tooling bit into an air-powered drill and use the drill depth gauge machined into the ProPlate™ to set the proper depth of the bit. Open the cap on the ProLube™ PPL001 machinist cutting oil and insert the small tooling bit in through the cap and retract. The bottle is design to deliver the precise amount of oil necessary for the operation. For larger tooling and subsequent machining, use just one drop placed on the end of the ProDrill™ and ProCutter™ when necessary. **AVOID PENETRATING OIL/SPRAY OR OTHER LUBRICANTS.** Insert the mounted ProDrill™ into the included ProBushing™ PPB3125 first by slowly and manually turning the chuck until the ProDrill™ slips into the bushing and contacts the surface of the damaged stud. This will ensure the cutting edge is maintained. While applying light pressure, activate your drill both on and off in approximately one second intervals for five to ten seconds. This initial process is critical in that it creates a "seat" for the bit to rest on and ensures that the bit will stay on stud center and not follow the angular surface of the damaged stud. This reduces the probability of tooling bit breakage and drilling off center of the damaged stud. Retract the bit and clean the debris from the bit with a shop towel which will remove steel fragments that have been case hardened and extend the life and cutting action of the tooling bit. Once again, place one drop of ProLube™ PPL001 to the end of the bit and reinsert the bit into the ProPlate™ manually as described previously above. While continuously running your drill at the proper RPM (see below), slowly apply more pressure for eight to ten second intervals and while the bit is turning, extract the bit while maintaining it in the bushing to allow the bit to "clean" cutting debris from this operation. Repeat this step for approximately every ten seconds progressively exerting more pressure until the drill chuck is approximately 1/4" from contacting the bushing mounted in the ProPlate™. Remove ProBushing™ PPB3125 and replace with PPB3188 (see above) and repeat the process above. Utilize the optional splined ProTractor™ PPT188 by placing a mark approximately 1/4" from the end of the extractor. Tap the ProTractor™ in to the depth of the line. Place the included slip-nut over the ProTractor™ and slide it up against the cylinder head. While holding the opposite end of the ProTractor™ and using a high-quality calibrated torque wrench, slowly and carefully apply torque, first in the clockwise direction, and then in the counter-clockwise direction to loosen the damaged stud. **DO NOT EXCEED 180 IN-LBS OF TORQUE.** Repeat this motion several times slowly increasing applied torque and being careful **NOT TO EXCEED** safe torque limitations stated above. If the damaged stud fails to release, **STOP** and remove the ProTractor™. In extreme cases, utilize the optional ProMAXX® ProDrill™ SSSC340 and PPB3340 ProBushing™ tooling to follow the SSSC188. This step will leave only the threads of the broken stud remaining. Simply blow the debris clean and follow with the optional PPB3395 ProBushing™ and PPT010 ProTap™ precision machine tooling to clean the remaining threads free of all debris. Use a drill depth stop collar for larger bits. In the unlikely event an extractor fails, contact technical support at 724-941-0941 for recommendations and procedures. ProMAXX® recommends an extractor-less repair using the steps above omitting any attempts to extract the damaged stud. Simply use sequential ProDrill™ and ProBushing™ sizes finishing with ProMAXX® ProTap™ PPT010.

NOTE: ProMAXX® *does not* recommend tapered left-handed screw extractors as they have the potential to deform the remnant in the cylinder head increasing complexity to extract. In addition, these extractors cannot be turned clockwise to unlock the damaged remnant. **USE ONLY GENUINE PROMAXX® PARTS.** Tooling cutting speeds (Under load): MIN: SSSC125/SSSC030 @300 RPM, SSSC188@200, SSSC340@150. MAX: SSSC125 @900 RPM, SSSC188@300, SSSC270@250. OPTIMUM: SSSC125/SSSC030 @500 RPM, SSSC188@250, SSSC340@200. **NOTE:** Some air ratchets may not generate sufficient RPM under load to be effective. SEE ProMAXX® ProRatchet #PPR5250, and PPG5250 ProGard™ at www.ProMAXXtool.com. Use optional ProPin™ where only one tapped hole is available, mount the ProPlate™ with one ProFast™ fastener in any open hole.

PROMAXX TOOLING IS SPECIALLY ENGINEERED TO CLOSE TOLERANCES (+) .000" AND (-) .002" TO ENSURE ACCURATE AND REPEATABLE RESULTS USING YOUR NEW DEVICE. SPECIFY PROMAXX® GENUINE REPLACEMENT PARTS AND TOOLING FOR OPTIMUM PERFORMANCE AND EXTENDED WARRANTY COVERAGE.

SAFETY PROCEDURE: ALWAYS USE APPROPRIATE SAFETY EQUIPMENT INCLUDING OSHA APPROVED SAFETY GLASSES/GOGGLE AND PROTECTIVE GLOVES WHILE USING THIS DEVICE AND PERFORMING THIS OPERATION.

User Guide



**ProMAXX engineered performance tools are
proudly made in the United States of America by
American craftsman using American materials.**

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LIMITED LIFETIME WARRANTY

The ProMAXX® ProPlate™ included in this repair kit is a high-quality precision tool designed and manufactured in the USA and is backed by a LIMITED LIFETIME warranty. ProMAXX® warrants this product to the original purchaser for its useful life against deficiencies in material and workmanship. This LIMITED LIFETIME WARRANTY does not cover normal wear and tear, and if it is used incorrectly, abused, altered or repaired. Deficient products will be replaced or repaired. For more information about ProMAXX® and our line of engineered performance tools and machine tooling, visit www.ProMAXXtool.com.

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