

INSTRUCTIONS

INSTALLATION INSTRUCTIONS FOR OIL RESTRICTORS (FORD 302 & 351W ENGINES) 915-50120

NOTE: THIS KIT FOR USE ONLY WITH SOLID TYPE TAPPETS
CUSTOMER RESPONSIBLE FOR CLEANING AND DEBURRING OF RESTRICTORS PRIOR TO ENGINE ASSEMBLY

The five threaded plugs in this kit are to be installed in main bearing webs number 2 through 5 to reduce oil flow to the cam bearings and in the right lifter gallery, thus increasing oil flow to the crankshaft bearings.

The four small plugs (5/16-18 thread) restrict the vertical oil passages between the main bearing bores and the cam bearings in the main webs of number 2 thru 5 (see illustration). Note: Number 1 main web is not to be modified. To install, see a 5/16-18 starting tap to thread the vertical oil passage in the main web to a depth of 3/4" (this is the smaller of the two holes in the main webs).

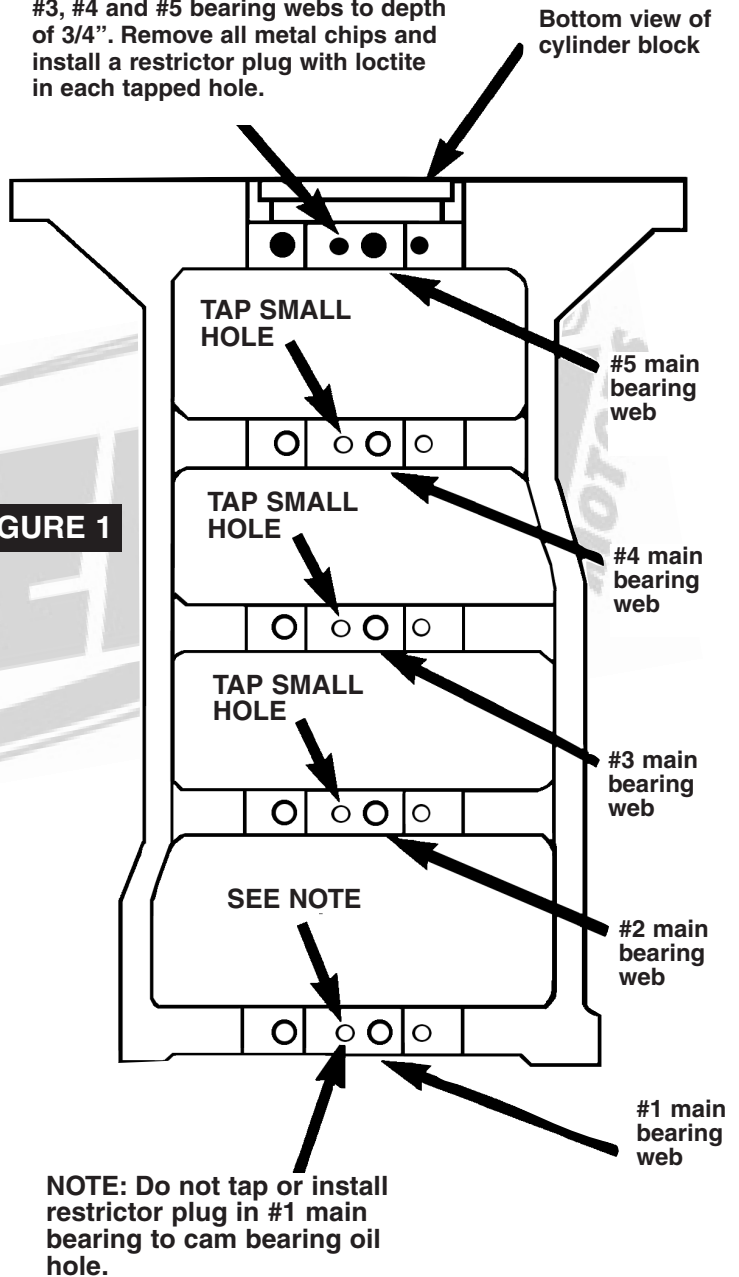
The one large plug (7/16-14 thread) is to be located in the diagonal oil passage that runs from number 5 main bearing bore to the right tappet oil gallery (see illustration).

To install this plug, the upper half of the hole must first be drilled to a 29/64" diameter so the lower half of the hole may be tapped with a 7/16-14" starting tap. Due to the depth of the hole, a tool to drive the tap will have to be fabricated (in some cases a 1/4" drive extension will serve this purpose).

Thoroughly clean the block, especially in the areas that have been reworked, to remove all metal chips before securely installing the restrictor plugs in their location with locktite.

Tap (15/16-18) the small hole in #2, #3, #4 and #5 bearing webs to depth of 3/4". Remove all metal chips and install a restrictor plug with loctite in each tapped hole.

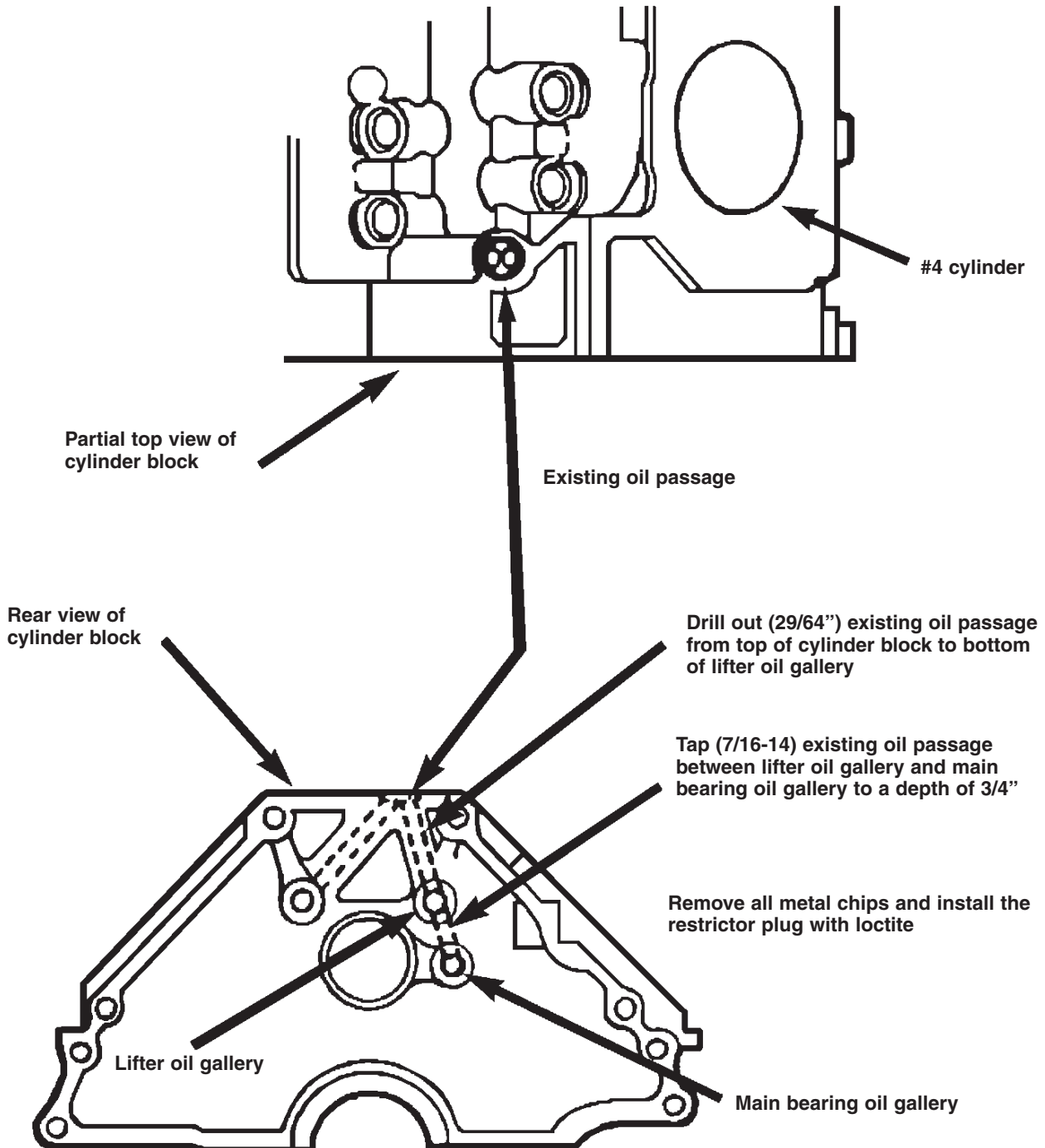
FIGURE 1



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IMPORTANT

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