

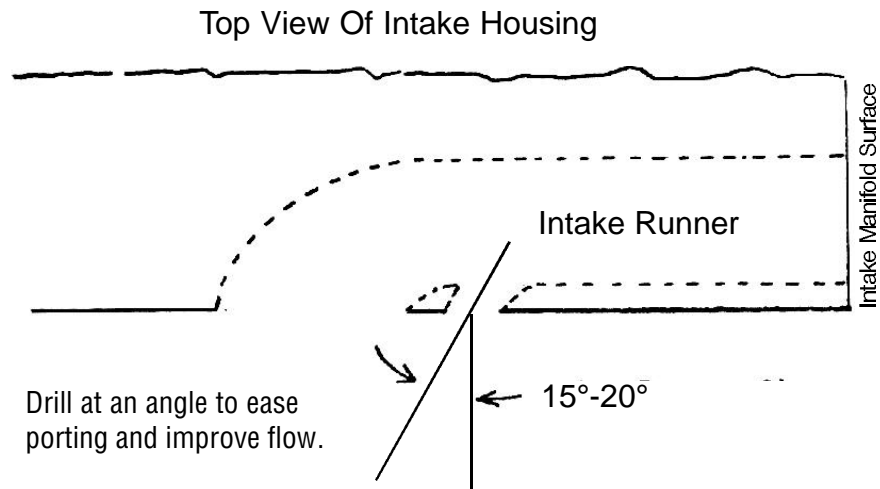
INSTRUCTIONS FOR USE OF INTAKE PORTING TEMPLATES

Part No. 22200, 22201, 22202

1. Cut out the template shape exactly to the scribed lines using drills, porting tools and files as necessary. (Racing Beat stocks a full line of porting tools.)
2. The template is aligned by means of the tubular dowels and the dowel holes in the part being ported. Temporarily align the template noting where the porting will take place. Remove the template and mark the housing with DYEKEM layout dye (if unavailable, a dark color magic marker will do).
3. Re-install the template with the dowels, ensuring that it lays flat on the housing. Now use a very sharp scribe and mark the template outline on the housing. Be sure to hold the template down tight on the housing.
4. Port out the housing to the scribed line. Do not increase the intake runner size, since the port is already large enough. At most, only lightly polish the rough cast iron surface. After opening up the ports to the scribed lines, spend a considerable amount of time shaping the transition from the runner to the port face, especially the inside of the curve. This curve should be very smooth and as nearly constant in radius as possible.

SPECIAL INSTRUCTIONS

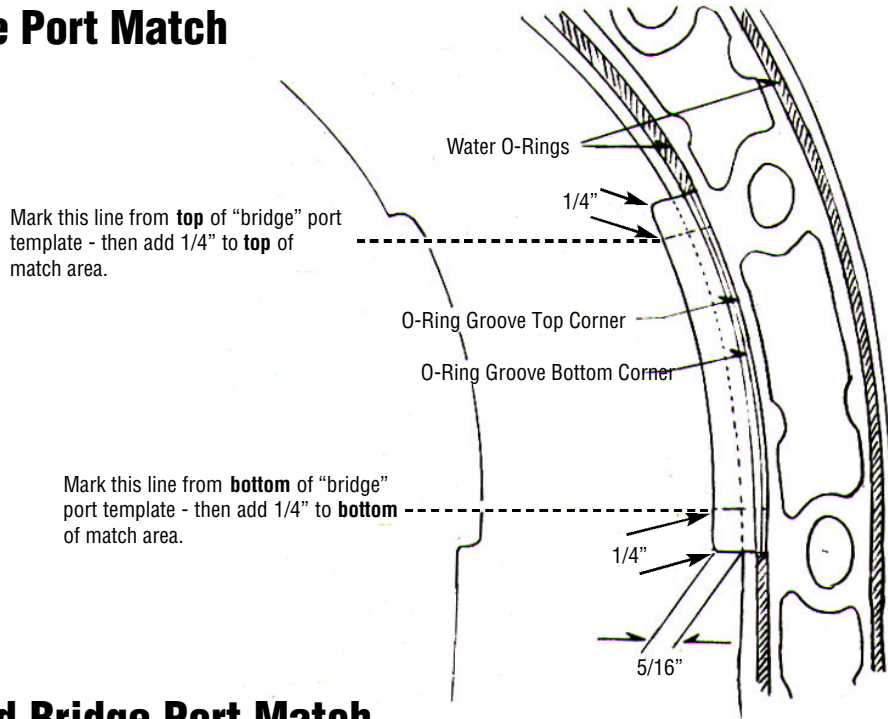
1. BRIDGE PORTING of side housing: When bridge porting a side housing, it is necessary to “chain drill” the “bridge” as a starting point. Be sure to center punch the housing before drilling. For best power, drill the holes at a 15° to 20° angle toward the incoming runner to smooth the port transition.



2. ROTOR HOUSING MATCH (for bridge porting) After marking the rotor housing for matching as described in the general instructions, mark the inner surface of the rotor housing as shown below and cut straight across between the lines.

NOTE: When cutting the J-Bridge, do not cut the corner of the outer wall of the O-ring groove.

J-Bridge Port Match



Standard Bridge Port Match

