

Hypermax Engineering Solid Wire Ring Head Gasket Assembly

Contents:

- 2 Head Gasket Bodies
- 8 Solid Wire Rings
- 16 Water Jacket Support Tubes – 1/2" long
- 1 Machining Drawing of Grooves

1. Using a 0.375" diameter reamer, ream the water jacket holes per **figure 1**. There are 4 per side and 8 total.
2. Install the eight 1/2" long water jacket support tubes in the crankcase per **figure 1** with the stepped end inserted first and flush with the deck surface. Resurface the crankcase at this time if necessary.

Figure 1

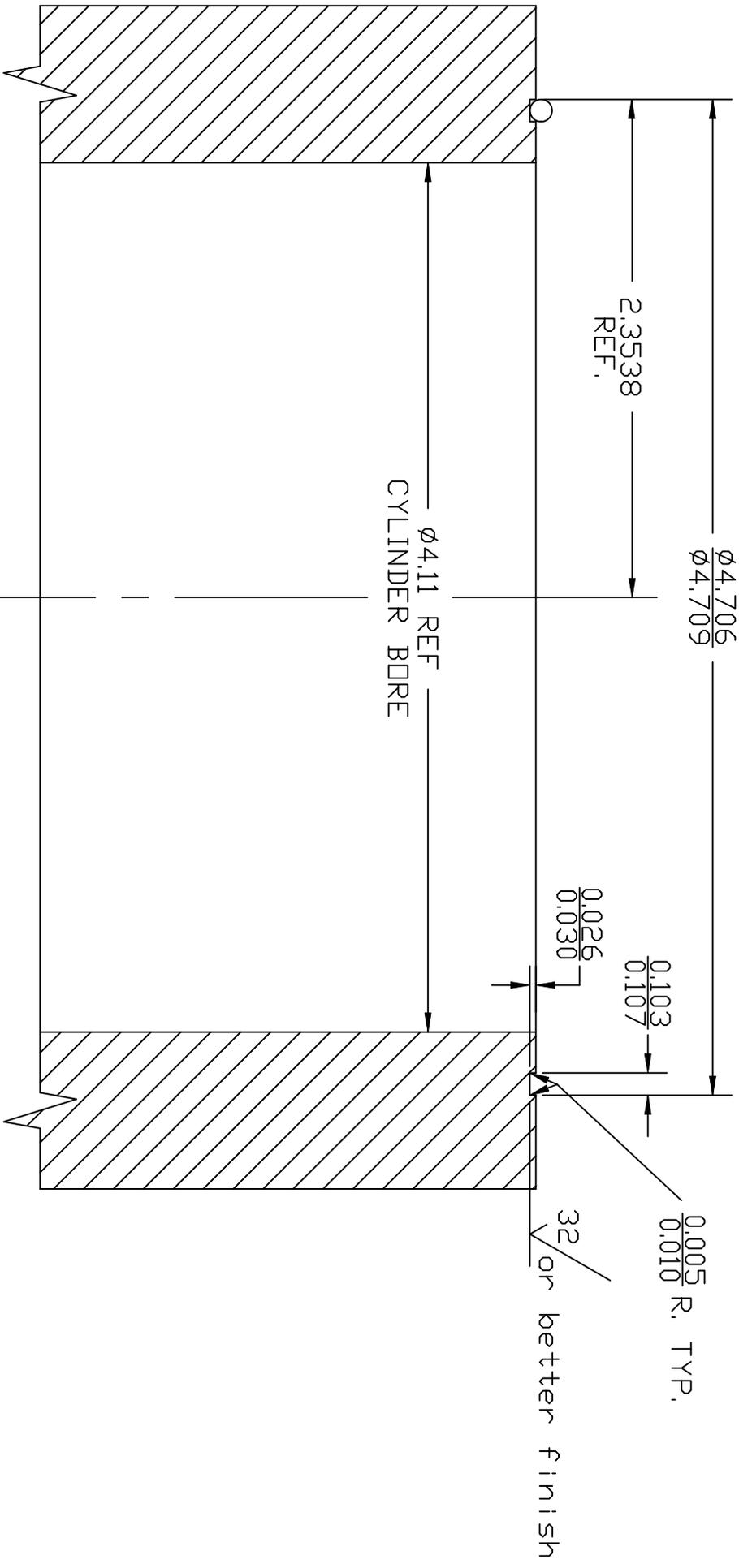


3. Using a 0.375" diameter reamer, ream the water jacket holes per **figure 2**. There are 4 per side and 8 total.
4. Install the eight 1/2" long water jacket support tubes in the cylinder head per **figure 2** with the stepped end inserted first and flush with the head surface. Resurface the head at this time if necessary.
5. If it is necessary to resurface either the crankcase or the cylinder heads, piston to head and valve to piston clearances must be checked.

Figure 2



4. With the head surface clean and dowels removed, machine head per drawing **HYP-095**.
5. Clean and assemble short block and install dowels.
6. Coat each Solid Wire Ring with anti-seize and install in the machined grooves.
7. Using RTV sealant, outline the water passages on the crankcase and then install the gasket body and outline the water passages again on the gasket body. Use the RTV sparingly to prevent the water jackets from being obstructed.
8. Carefully place the cylinder head on the block and follow the enclosed torque sequence (**figure 3**) and final torque to 115 Ft/Lb. Note: Be sure to oil the threads and under the bolt heads.



HYPERMAX ENGINEERING INC.

Name: WIRE RING GASKET REWORK DRAWING - 7.3L

Material:

Tolerances: .X=+/- .06 .XX=+/- .030 .XXX=+/- .010

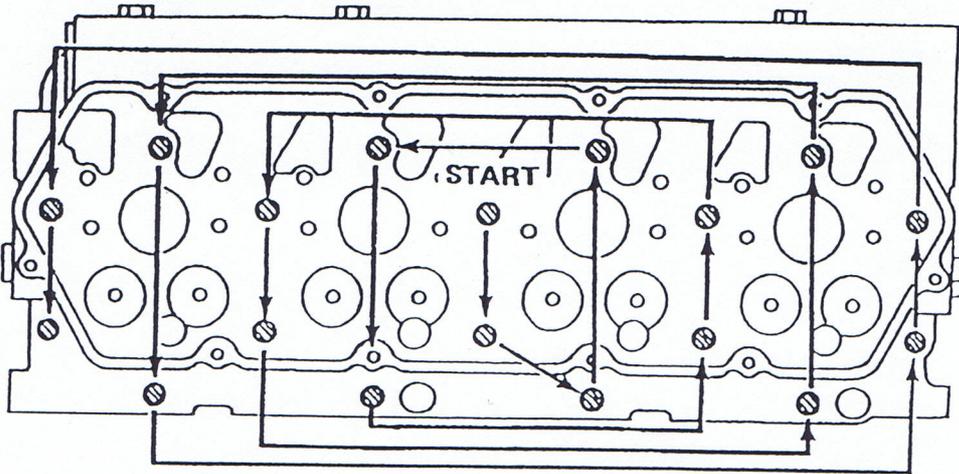
Date: 01-21-03 Scale: Drawing size

Part no. HYP-095

Cylinder torque sequence

Step 1. 65 Ft/Lb

Step 2. 85 Ft/Lb



Step 3. 115 Ft/Lb

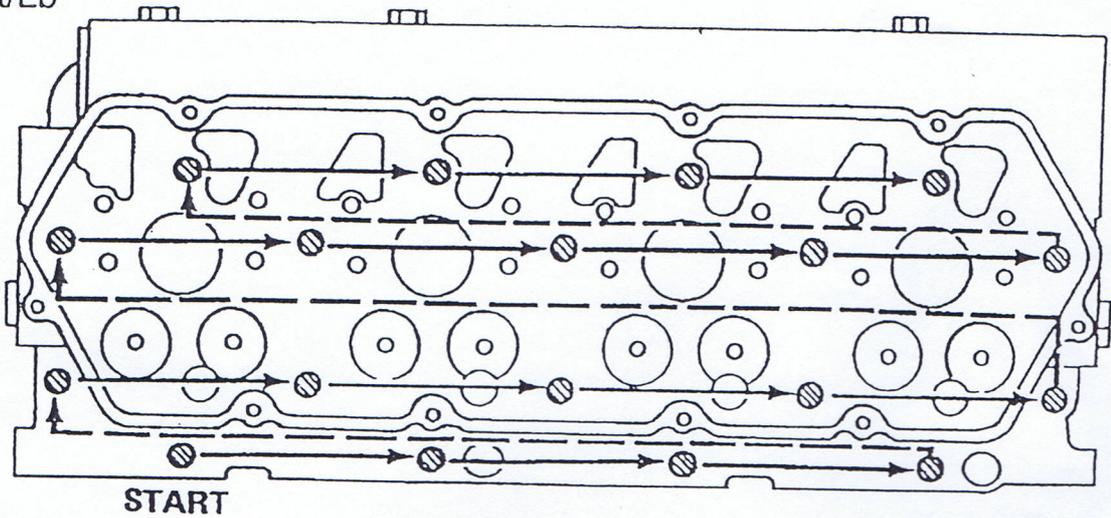


Figure 3