



PLEASE FOLLOW ALL OF THESE INSTRUCTIONS CAREFULLY.
Copper Head Gasket Installation
INSTALLATION PROCEDURE

It is recommended that when using a copper head gasket that you heat the gasket to a cherry red or purplish color using an oxygen/acetylene torch. Holding gasket with a steel coat hanger, begin to heat an area of the gasket and once the gasket starts to show the appropriate color, start moving flame so the color pattern follows the flame around the gasket surface. When you have finished heating the gasket surface quickly drop the copper gasket into a bucket of cold water. and remove scaling with scotch brite or light sand paper (400-600 grit). The gasket is now ready to have a light coat of sealant applied. We recommend 3-Bond 1211, 3-Bond 1104, Permatex Moto-Seal 1 (gray color), or Permatex Moto-Seal 2 (white color). This sealant can be difficult to find but is available from Trinity Racing. After applying the sealant, torque the head down an additional 10% of factory specs (eg. factory spec = 30ftlbs. then torque to 33ftlbs). It is also recommended that you let sealant completely set up. 100% set up time is usually 72 hours. While the sealant is setting continue checking the head torque using the final torque spec (on a 2-stroke engine, a re-torque of the head must be done at least twice after initial warm-up). Always use caution when using a torch and make sure you are working in a well ventilated area.