

Pre-Chamber Ignition Body Installation

Keep all parts clean from contamination.
Thoroughly clean the gasket and O-ring sealing surfaces.
Always use new gaskets and O-rings to install pre-chambers.
Make sure pre-chamber bore in the head and all sealing surfaces in head are clean and dry.

Parts and tools needed:

1. Pre-chamber.
2. Pre-chamber seal kit.
3. Sil-Glyde for O-rings NAPA part # 765-1351.
4. Optional - Sealant to hold sealing rings in place during installation NAPA part # 765-1210.
5. Torque wrench.

Dressing Pre-Chamber:

1. Place pre-chamber body upside down on work bench.
2. Use Sil-Glide part # 765-1351 to lubricate O-rings
*Caution - do not use engine oil or grease on these O-rings as this may cause sealing issues.
3. Place O-rings in appropriate grooves in pre-chamber.
4. Use small amount of sealant part # 765-1210 above and below tip gasket. (Optional.)

Installing Pre-Chamber:

1. Place pre-chamber into the bore in the cylinder head.
2. Insure tip alignment with spark plug. Red mark on body indicates the spark plug side.
3. Tighten the bolts evenly to a torque of 32 lb. ft., then to 60 lb. ft., than 90 lb. ft., and then 100 lb. ft.
4. Pre-chamber has to be torqued after first heat cycle or by 500 hours to 100 lb. ft. and should be checked as regular maintenance.
5. Gas Check Valve torque – 85 lbs. ft.
6. Cap for pre-chamber body torque – 4 lbs. ft.

Pre-Chamber Part Number - PC-1782

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