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## **Installation Instructions for Copper Head Gaskets**

In some instances, S&S provides copper head gaskets in place of fiber-type gaskets. The following assembly procedures must be followed for leak-free operation.

1. Inspect cylinder and cylinder head gasket surfaces for damage or irregularities which may prevent gasket from sealing. Pulling-out of threaded insert for cylinder head bolts is potential problem with older, worn OEM shovel heads.
2. Clean gasket surfaces of cylinder and head with residue-free solvent such as lacquer thinner.

**WARNING - Many solvents are highly flammable and the fumes toxic if inhaled. Insure adequate ventilation during use, avoid sparks or open flame, and observe solvent manufacturer's precautions and instructions.**

3. These bare copper gaskets require sealant for leakfree operation. Coat both sides of head gasket and coat head gasket surfaces on both the cylinder and the head with Gasgacinch®. Allow time to dry before assembly.

*NOTE - Several years ago S&S supplied copper head gaskets with printed silicone beads around the oil passages. Gasgacinch® should not applied to these gaskets.*

4. Install cylinder heads according to standard procedure and torque head bolts according to application. Lubricate bolt threads and underside of bolt head with a light coat of engine oil prior to installation.