



## Installation Instructions

You need to first drill and tap the cylinder to accept the new studs.

### Hole machining

12mmx1.25 thread. Drill holes with a 10.75mm or 13/32" bit. It is always best to have a machine shop do this procedure in a vertical mill to ensure proper alignment.

Be sure to hone cylinder after studs are installed.

Install the new studs using Permatex sleeve retainer on the threads.

Be sure to install to the correct height.

The studs must be the correct distance out of the top of the cylinder.

Front – 2.436"

Rear – 3.188"

Sides – 1.929"