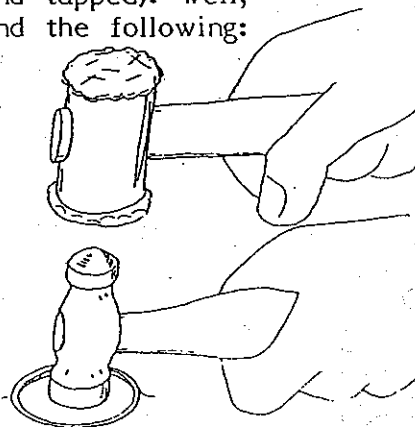


PI-109  
(disc 11-8)

## SOFT PLUG INSTALLATION

Soft plugs -- old and new -- have been known to come loose and even fall out. During a race in '77 a soft plug fell out and caused a crash destroying our 142E racecar. Since then we take precautionary steps; we cover them with silicone adhesive and place an aluminum cap over them which is then secured to the block by two screws (the block is drilled and tapped). Well, this is kind of an over kill for street, but we do recommend the following:

- 1) Be sure block and plugs are clean and dry.
- 2) Use a ball peen and brass hammer.



3) Place the flat side of ball peen against the new plug. Then hit it with the brass hammer (see drawing) until a flat spot -- approx. 1" or the size of a quarter -- appears on the plug. Yes....you can hit it too much! Installing soft plugs is a serious task.

4) Once the plugs are securly swedged in the block, we recommend coating them with silicone sealer (GE, Dow-Corning, 3M, Permetex, etc) working it into the crack between the block and plug. This will help prevent a seeping water leak and could prevent the plug from suddenly popping out. It's good advise from experience we've encountered the hard way.

See reverse for Tech Tip on pan and seal housing bolt installation.