



Installation Instruction for Shovelhead-Style Copper Head Gaskets

In some instances, S&S provides copper head gaskets in place of fiber-type gaskets used previously. 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 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. Bare copper gaskets currently supplied with some kits require sealant for leakfree operation. Coat both sides of gasket with quality gasket sealant such as Copper Coat or Gaskacinch according to sealant manufacturer's instructions.

NOTE - Coated copper gaskets such as those supplied with certain S&S V²-style kits in past should have no additional sealant applied.

4. Install cylinder heads according to standard procedure and torque head bolts to normal specifications. S&S recommends 65 ft-lbs. for S&S Shovel-style cylinder heads. Lubricate bolt threads and underside of bolt head with light coat of antisieze compound prior to installation.
5. Retorque head bolts and base nuts after engine has been run and reached operating temperature. Unless loose, do not retorque base nuts treated with thread-locking compound at time of installation.

Installation Instruction for Shovelhead-Style Copper Head Gaskets

In some instances, S&S provides copper head gaskets in place of fiber-type gaskets used previously. 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 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. Bare copper gaskets currently supplied with some kits require sealant for leakfree operation. Coat both sides of gasket with quality gasket sealant such as Copper Coat or Gaskacinch according to sealant manufacturer's instructions.

NOTE - Coated copper gaskets such as those supplied with certain S&S V²-style kits in past should have no additional sealant applied.

4. Install cylinder heads according to standard procedure and torque head bolts to normal specifications. S&S recommends 65 ft-lbs. for S&S Shovel-style cylinder heads. Lubricate bolt threads and underside of bolt head with light coat of antisieze compound prior to installation.
5. Retorque head bolts and base nuts after engine has been run and reached operating temperature. Unless loose, do not retorque base nuts treated with thread-locking compound at time of installation.