**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 groves 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.