Wipe Out Enterprises Inc.

Work Instructions

Document # WOEI-H018 DT466 Block IH Preparation for Cleaning, Drilling Out Oil Galleys

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Drill Main Oil Galleys and Oil Feed to Front

PURPOSE: Prepare IH DT466 Block for Cleaning “Out Sourced”

Proper Procedure for

TOOLS/COMPONENTS:

Hammer
12 inch channel lock pliers
Long pin punch
Allen sockets or wrenches
½ in drive ratchet or breaker bar
Dead blow rubber mallet
Torch
Cam bearing removal tool
“R” Drill Bit
Drill
Slide Hammer Kit
Degrinder

Instructions:

1. Remove all freeze plugs both sides of block and at front and rear of block. May need to use slide hammer and screw to remove.





2. With a long punch and hammer, drive on one side of the freeze plug as to try to turn it. Careful not to drive to hard and knock it in the block.
3. Once the freeze plug has turned sideways use channel lock pliers and pull it out of block.
4. Repeat on all frost plugs.
5. Remove all pipe plugs.
6. On the left side of block there are two pipe plugs. Remove the ½" pipe plug with an 11/16" socket and ratchet or breaker bar.



7. Remove 1/8" pipe plugs on the left side of block also. Be careful not to strip out head of plug. If plug does not seem to want to loosen up use torch and heat up around plug to aid in the removal.



8. Repeat on all 1/8" pipe plugs on the right side.

9. There are two or three pipe plugs on the left side that also need removed. Use ½" ratchet or breaker bar to remove.



10. Turn block up side down and with a rubber mallet drive out dip stick tube.



11. With proper die on the cam bearing tool remove the cam bearings by pounding them out with cam bearing tool.



12. Remove anything else that may not have been removed in the disassembly process.

13. Oil pressure relief BOSS needs ground down to clear sleeve





Drill Out Oil Feeds

14. Drill Out the Main Oil Feed Galleys with an Letter Size "R" drill bit. This will need done through the 1/8" fittings on side of block and through the oil feed in the main saddle.

Drill Oil Cooler Outlet to Add Oil Feed to Front of Block

15. Drill the Oil Cooler Outlet Port at Front of Block for Oil Feed. *(See WOEI-H064)*



16. Idler gear bold hole up size would be a good time to do now. *(See WOEI-H017)*



17. Wipe off tools and put them away.
18. Enter labor and parts on the labor and expense spreadsheet, for customer the work was done for.
19. Send block off for cleaning to Hart's Machine. The block will need to be skidded and loaded into the van. See shipping instructions in WOEI-H016 Sending Parts Out For Work.docx