

Flathead Block Pressure Testing Instructions

- 1) Clean deck surfaces and bolt holes
- 2) Install pressure plate on either side and bolt down.
 - a. Each bolt will have a steel washer first, then a sealing washer.
 - b. Torque to 20 lbs. - overtightening will eventually harm the neoprene gasket.
- 3) Install water pump plate with regulator and tighten.
- 4) Hook air supply. You will need to supply your own air inlet fitting to the air regulator. This is due to the variety of air couplings on the market. Your fitting must have a 1/4" male pipe thread to screw into the regulator.
- 5) Begin testing by either the following methods:
 - a. Spray soapy water (soap makes water cling to metal)
Check all critical areas - ports, seat, cyl., any crack repair, valley area, and entire water jacket.
 - b. Block can be submerged - for a thorough test. This will test everything including the exhaust runners from the valve seat to the outside of the block.
- 6) When finished with Side 1, disconnect air supply and allow air to bleed out. It is not necessary to change setting on the regulator.
- 7) Switch to other side of the block.
 - a. Remove pressure plate and install on Side 2.
 - b. Water pump regulator plate - must be turned over.
 - i. Remove 1/4" pipe plug from Side 2 and install pressure regulator in its place.
 - ii. Install the 1/4" pipe plug in the void created by removing the pressure regulator. Install & tighten the water pump plate.
- 8) Test Side 2 using the same procedure.