

The New 2012 E-Z Bore Head Milling Fixture is now available

with the ability to set-up for both the Briggs and the Honda / Clone 6.5 cylinder heads



The 2012 milling plate features 2 drilled patterns to set up each of the manufacturer's cylinder heads. Buy only the tool you need now, with the ability to upgrade later!

Milling fixture full kit for Animal & Honda/Clone: \$129.95

Milling fixture kit for Honda / Clone: \$109.95

Milling fixture kit for Animal: \$99.95

Each milling fixture is shipped preset for the engine the customer requests. It can easily be switched for use with the other manufacturer's head simply by using the appropriate adaptor kit.

The E-Z Bore logo is affixed to the top side at the front of the milling fixture.



Honda milling fixture includes the following:

- (4) Aluminum spacers 1 1/4" long -- each end of the spacers has a different thread pitch. Top of spacer is tapped 1/4-28 (fine thread) for precise adjustments. The bottom of spacer is tapped 1/4-20 for securing to adaptor plate.
- (2) Aluminum spacers 1" long -- each end of the spacers has a different thread pitch. Top of spacer is tapped 5mm for securing through the valve guide bores. The bottom of spacer is tapped 1/4-20 for securing to adaptor plate.
- (4) 1/4-28 machined adjusting screws - (2) 1/4-28 flange nuts used on the 2 posts closest to the E-Z Bore logo.
- (2) 5mm x 40 special machined cap screws used on the center 2 posts through valve guide in cylinder head.



Animal Milling Fixture includes:

- (4) 5/16-24 x 1 1/2" machined bolt and spacer assemblies with nuts and washers
- (2) M6 x 50mm center screws used to secure head to milling fixture



For initial Honda set-up: Secure plate posts (spacers) to the milling plate with (6) 1/4-20 X 3/4" cap screws. Turn plate over and locate the (6) 3/8" countersunk bolt locations. Simply install 1/4-20 bolts through bottom of plate into posts for top side mounting. Position the 4 longer posts on outer corners, and the 2 shorter posts in center locations.



Now set the 4 adjusting screws at 4" from the top surface of the milling plate and continue to **Milling Plate Setup** below.

Milling Plate Setup

Secure head milling fixture to milling machine with standard "T" bolt style hardware in the outer 1/2" diameter through holes

Now you are ready to place head onto fixture. Near the center posts you will see (2) 3/8" through holes. These holes allow the rocker studs on the Honda/Clone cylinder head to clear the milling plate. Place head lightly onto the 4 adjusting screws. Insert the 2 machined center screws through the valve guides in head. Thread into the 2 center posts (for Hondas), or into threaded seats in plate (Briggs). After starting guide screws, apply downward pressure to firmly seat head to onto adjusting screws.

The four outside corners of cylinder head can easily be adjusted with a 3/16" allen (Honda) or a 1/4" allen (Briggs) to level gasket surface or to angle at any position. **Note:** center guide screws need to be loosened before adjusting outer corner adjusters.

Once head is mounted on milling fixture, we recommend checking milling gasket surface to ensure head is level with cutter and will be machined to increase performance within sanctioning organization's rule specifications.

Once milling fixture is set, similar multiple machining operations should require minimal adjustments between same brand heads.

We recommend the following accessories for your head milling fixture to insure precise perfectly level cuts.



←**Digital protractors** are a quick way to level the head gasket surface within a couple thousandths of your final setting when switching between the Briggs and the Honda set-up.

We recommend fine-tuning set-up with a **dial indicator in mounting bracket** before making any type of machining cut. →



For initial Animal set-up: Locate (4) 5/16-24 threaded locations on milling plate spaced at 3 1/2" apart, 3" from one end and 2 1/8" from the opposite end. Now set the washer surface of the 4 adjusting screws at 2-5/8" from top surface of milling plate and continue to **Milling Plate Setup** below.

NOTE: The Animal or World Formula Engines using the heat dispenser will need this unit removed for proper set-up in E-Z Bore Head Milling Fixture.

