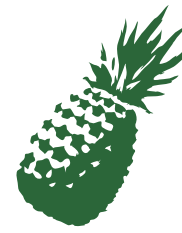


PINEAPPLE

Racing



PINEAPPLE RACING 6-PORT INSERT INSTRUCTIONS†



First, you need clean 6-port sleeves. Aerosol carb cleaner and a tooth brush do a very good job. Wash them down with brake cleaner (alcohol) as a final rinse. You need some Loctite, a small hammer, a punch and a couple flat-blade screwdrivers. A vice is very helpful, too.



Place the sleeve on top of (not in) a vice with the jaws mostly closed, with the port facing up. You are just supporting the sleeve on the vice, so it won't roll over and the pin has somewhere to go. Drift the pin out carefully. Remember the orientation of the pin.



Scuff up the mating area of the sleeve with the edge of a small screwdriver. This enhances the grip of the Loctite.



Do the same for the bottom of the insert.



Slide the insert down the throat of the insert until it is close to the bottom, then add a couple drops of Loctite. Here we show red Loctite, but you can also use the green formulation.



Press the insert home firmly.



Use a larger flat bladed screwdriver to peen the edge of the sleeve to mechanically secure the insert. A light 'ding' is enough. Do this to both sides.



Re-insert the pin in the original orientation, but drive it in from the non-port side so it goes back in the same way it came out.



The finished product. Note the peening on either edge of the port opening. Repeat procedure for the second 6-port sleeve. Be sure to clean engine 6-port runners prior to re-installing sleeves and check for free operation.

†This product is intended for off-road use only and not intended for use on emissions controlled vehicles. By purchasing this product you are assuming all liabilities associated with its installation and use.