

User Guide



ProMAXX engineered performance tools are proudly made in the United States of America by American craftsman using American materials.

LIMITED LIFETIME WARRANTY

The ProMAXX® ProBody™ EGRR100 ProPlate™ included in the assembly is a quality precision tool designed and manufactured by ProMAXX® in the USA and is backed by a LIMITED LIFETIME warranty. ProMAXX® warrants this product to the original purchaser for its useful life against deficiencies in material and workmanship. This LIMITED LIFETIME WARRANTY does not cover normal wear and tear, and if it is used incorrectly, abused, altered or repaired. Deficient products will be replaced or repaired. For replacement parts or for information about ProMAXX® and our line of precision machine tools and tooling, visit www.promaxxtool.com.

Thank you for investing in our ProMAXX® EGR Valve Tube Repair Kit (NINO). This device was engineered to facilitate a repair, versus replacement of the manifold in the Ford 6.7L diesel engine saving you time and your operation unnecessary cost.

It is recommended that the intake manifold should be removed and subsequent aluminum housing if attempting to repair the bolt closest to the intake, otherwise, leave the intake manifold intact. Protect all air intake passages from cutting debris before performing any machining operation. Remove any remaining portion of the fastener that protrudes above the surface of the exhaust manifold prior to mounting the NINO™ ProBody™. Insert the ProBody™ PPF180 flange side to the exhaust manifold via the EGR valve tube exhaust passage carefully centering the two bushing mounting holes over the 6MM tapped hole/damaged bolt(s). If only one bolt is broken, use the optional ProPin™ PPP750 for aligning the tool precisely over the damaged bolt. Using a 9/16" deep socket and ratchet tighten the chrome hex nut PHX375 until the ProBody™ stops moving. Once stable, turn an additional one-quarter to one-half turn of your ratchet securing the ProBody™ to the manifold – DO NOT OVERTIGHTEN. Insert ProBushing™ PPB280, or for a faster stepped repair, the optional PPB125 into the ProBody™ over the damaged bolt. Once set, select the proper ProDrill™ SSSC125/SSSC280 or optional ProMAXX® Platinum machine tooling bit and insert it into a ½" capacity air or electric drill. NOTE: Be sure to regulate drilling speed to approximately 200 RPM, not exceeding 300 RPM for the SSSC280/420, or Platinum, and 500 RPM for the SSSC125 tooling bit or damage to the tooling bit may result. Select the ProStop™ PPS280 collar in the kit and slip it over the SSSC280 machine tooling bit and set the amount of the bit protruding (distance) between the bottom of the collar to the tip of the bit to 1 11/16". Tighten the ProStop™ socket head screws to secure it. Check the ProStop™ to ensure it is tight and will not move. Apply two drops of ProMAXX® ProLube™ specially formulated cutting oil to the bushing and to the bit and manually turn your drill chuck until the tooling bit rests on the damaged bolt. This will ensure precise fit and preserve the tooling cutting edge. Toggle your drill on and off five to ten one-second intervals applying light pressure on the drill. This process will allow the cutting edge to engage in the cutting surface prolonging bit life. Once complete, begin drilling continuously until the ProStop™ rests on the ProBushing™ adding cutting oil as necessary and stopping frequently to clear debris from below the bushing and surrounding parts. Remove and replace the SSSC280 tooling bit with the SSSC420 bit, the PPB280 bushing with the PPB420 bushing, and repeat the process above. Once drilling is complete, clear all debris and insert the PPB485 ProBushing™. Attach a 3/8" drive tap holder to the ProTap™ PPT012 and apply two drops of ProMAXX® ProLube™ to the tap. Insert the ProTap™ PPT012 into the bushing, slowly and carefully turning the tap by hand clockwise ¼ turn, then counter-clockwise, repeating this process until the tap stops cutting. To prolong tap life, remove and clean debris from the tap and bushing periodically. Remove the ProBody™ assembly by loosening the chrome hex nut until it spins freely. It may be necessary to lightly tap the top of the ProArbor™ to unlock it from the manifold using a plastic-faced hammer that will not damage the arbor. Use the included insert tool to thread the PPS006 ProSert™ into the manifold until it stops. Lift the insert tool slightly, turn it 90 degrees and tap the top of the insert tool with a ball-peen hammer to drive the locking pins flush with the surface of the manifold. Once locked, the manifold is now permanently repaired. ProMAXX® recommends adding Loctite® anti-sieze compound to the fasteners when re-installing the EGR tube.

Tools required: Pneumatic or electric drill ½" diameter capacity. Plastic faced hammer, steel ball-peen hammer, 9/16" deep socket and ratchet, tap holder accessory, blow gun, and OSHA approved safety glasses. Consider the optional ProBushing™ PPB125 and SSSC125 ProDrill™ machine tooling bit for a piloted start. For more rapid progress in machining, consider the ProMAXX® Platinum PLT280 and PLT420 machine tooling bits for replacement. NOTE: The fasteners used in mounting the EGR tube are extremely hard titanium alloy compound making machining difficult. Our tooling is designed to machine the fastener. However, frequent sharpening of the tooling to keep a sharp edge may be required. Maintain a cutting angle of 140 degrees. ProMAXX® does offer a sharpening service to return your machine tooling to optimal performance. Visit our website at www.promaxxtool.com for details.



SAFETY PROCEDURE: ALWAYS USE APPROPRIATE SAFETY EQUIPMENT INCLUDING OSHA APPROVED SAFETY GLASSES/GOGGLE AND PROTECTIVE GLOVES WHILE USING THIS DEVICE AND PERFORMING THIS OPERATION.