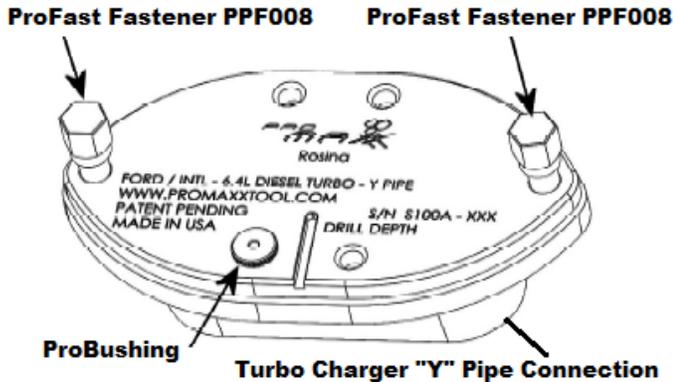




Thank you for purchasing the "Y" pipe turbo repair kit for the Ford/International 6.4 diesel engine. The Rosina ProKit™ was designed to assist the professional automotive technician in the repair of damaged or broken bolts in the turbo charger in the vehicle without removing it. When used correctly, the device will facilitate the repair of the turbo charger versus replacing it.

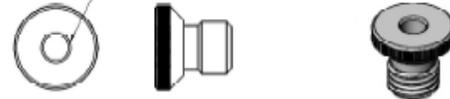
## FORD/INTL 6.4L DIESEL TURBO - Y PIPE



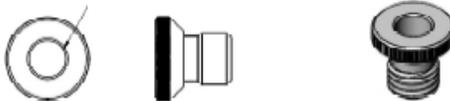
### ProBushing Accessories



**Precision Bushing Hardened - Small PPB030 - STD.**  
Use with ProMAXX Machine Tooling SSSC030



**Precision Bushing Hardened - Medium PPB188II - Optional**  
Use with ProMAXX ProDrill Machine Tooling SSSC188



**Precision Bushing Hardened - Large PPB266II - STD.**  
Use with ProMAXX ProDrill Machine Tooling SSSC266

Before use, it is recommended that the mounting surface be free from debris or carbon prior to mounting the Rosina ProPlate™. Once cleaned, attach the ProMaxx® ProPlate™ to the turbo charger using the included PPF008 ProFast™ stainless steel mounting fasteners in any two open positions shown above. Insert the ProBushing™ PPB030II into any open tapped hole directly over the broken bolt set for removal. Insert a ProDrill™ SSSC030 precision-machined tooling bit into an electric or air-powered drill and use the drill depth gauge machined into the ProPlate™ to set the proper depth of the bit. Place one drop of ProLube™ PPL001 on the end of the bit prior to drilling. The use of penetrating spray or other lubricants other than for machining applications are not recommended. Insert the mounted ProDrill™ into the hardened steel drill bushing first by slowly and manually turning the drill chuck until the ProDrill™ slips into the bushing and contacts the surface of the damaged bolt. While applying light pressure, activate your drill both on and off in one second intervals for approximately five to six times. This initial process is critical in that it creates a "seat" for the bit to rest and ensures that the bit will stay on the center of the damaged bolt and not follow the angular surface usually caused when the bolt breaks. This reduces the probability of tooling bit breakage and drilling off center of the damaged bolt. Retract the bit and clean the debris from the bit with a shop towel. This removes steel fragments that have been case hardened and extends the life and cutting action of the tooling bit. Once again, place one drop of ProLube™ PPL001 to the end of the bit and reinsert the bit into the ProPlate™ manually as described previously above. While continuously running your drill at the proper RPM, slowly apply more pressure for eight to ten second intervals and while the bit is turning, slowly extract the bit while maintaining it in the bushing to allow the bit to "clean" cutting debris from this operation. Repeat this step for approximately every eight to ten seconds progressively exerting more pressure until complete. Once the machining operation is complete, remove the and replace the SSSC030 ProDrill™ and PPB030II ProBushing™ with the SSSC188 and PPB188II respectively. Lastly, insert the PPB266II ProBushing™ and now use the SSSC266 for machining the stud leaving only the threads behind. Follow the same instructions as above for safe, accurate, and efficient drilling of the damaged bolt. Once complete, insert the precision tap into a tap or ratchet handle and clean any remaining debris from the drilling operation. Replacement parts and tooling are available from your dealer or online at [www.promaxxtool.com](http://www.promaxxtool.com).

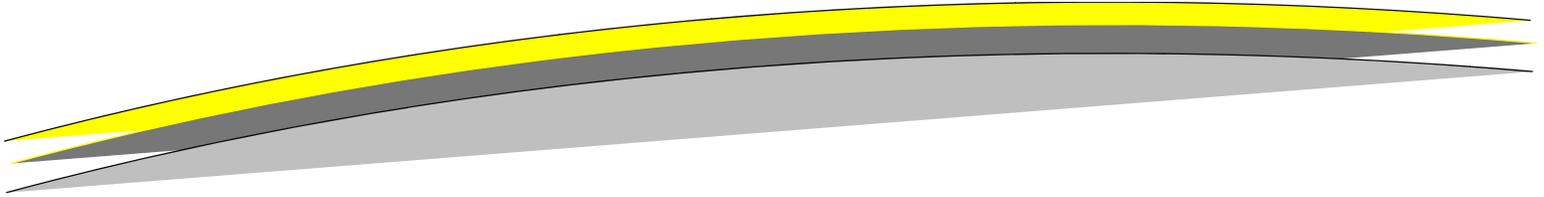
For support, please contact technical support at [www.promaxxtool.com](http://www.promaxxtool.com), or dial 412-347-4041.

Tooling cutting speeds (Under load): MIN: SSSC030 @350 RPM, SSSC188@200, SSSC266@150. MAX: SSSC030 @900 RPM, SSSC188@300, SSSC266@250. OPTIMUM: SSS030@500 RPM, SSSC188@250, SSSC266@200.

Recommended tools: Pneumatic or electric drill, 3/8" box wrench, tap handle, blow gun, safety glasses.

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

# *User Guide*



**Made in the USA**

## **LIMITED LIFETIME WARRANTY**

The ProMaxx® ProPlate™ included in this repair kit is a high-quality precision tool designed and manufactured 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 more information about ProMaxx® and our line of precision machine tools and tooling, visit [www.promaxxtool.com](http://www.promaxxtool.com).

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