

# INSTRUCTIONS

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**SPEEDWAY**  
motors

## 910-15031 - T4 Turbo Mockup Jig

KIT CONTENTS			
Qty	Description	P/N	Item #
1	Turbine Housing	910-15031.1	1
1	Compressor Housing	910-15031.2	2
1	Turbine Inlet	910-15031.3	3
1	2.5" Compressor Inlet	910-15031.4.25	4
1	3" Compressor Outlet	910-15031.4.3	5
2	Extension Slider	910-15031.5	6
1	Compressor Inlet	910-15031.6	7
1	Turbine Outlet	910-15031.7	8
1	1/2-13 Thru Rod	910-15031.8	9

HARDWARE			
Qty	Description	Tool Size	Item #
8	Serrated Flange Nut, 1/2-13	3/4" Hex	10
8	Hex Cap Screw, 1/4-28 x 1/2, GR-5, Zinc	7/16" Hex	11
8	Hex Nut, 1/4-28, GR-5, Zinc	7/16" Hex	12

1. If your turbo is one of the listed below in the Figure 2, skip to step 11. If your turbo is not listed continue to step 2.
2. Using a tape measure, flat table, and a straight edge, place your turbo on end with the compressor inlet down and your straight edge on the turbine outlet. Measure the distance from the flat surface to your straight edge and record this measurement as measurement (I).
3. Next, measure the distance from the flat surface to the center of your compressor outlet and record as measurement (A).
4. Flip your turbo over with the turbine outlet now down and measure from the flat surface to the center of your turbine inlet and record as measurement (C).
5. Using your measurements for I, A, and C, calculate measurement B and record.
6. Next, place your straight edge on the end of the compressor outlet and measure perpendicular to the centerline of the turbo housing and record as measurement (D).
7. Using your straight edge again, place it on the end of the turbine inlet and measure the distance perpendicular to the centerline of the turbo housing. Record as measurement (H).
8. Measure the distance from the center of the turbine inlet to the centerline of the turbo housing and record as (E).
9. Measure the distance from the center of the compressor outlet to the centerline of the turbo housing and record as measurement (G).

# INSTRUCTIONS

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10. Measure the diameter of the compressor outlet and record as measurement (F).
11. Using your taken measurements or the supplied measurements in the Figure 2, begin assembling parts 1, 2, 7, 8, 9, and 10 with the flange nuts oriented as in Figures 1 and 2. Space 1, 2, 7 and 8 according to your measurements and leave the flange nuts loose.
12. Using parts 1, 6, 11, 12, and either 4 or 5 depending on your F measurement, assemble the compressor mock according to your D, and G measurements and tighten the bolts and nuts with two 7/16 wrenches. The slider, part 6, should be on the inside of both the compressor housing and compressor outlet.
13. Using parts 2, 3, 6, 11, and 12, assemble the turbine mock using your E and H measurements. Again, ensure the slider is on the inside of the turbine housing and inlet and tighten the four bolts and nuts.
14. Next, rotate your compressor and turbine housing mocks relative to each other to match your turbo configuration and tighten the serrated flange nuts with two 3/4 wrenches to lock the housings in place. At this time also tighten the serrated flange nuts on both sides of the compressor inlet and turbine outlet to lock those parts in place.
15. Lastly, remeasure your turbo mock spacing to ensure that your measurements match your measurements for your real turbo and adjust as needed.

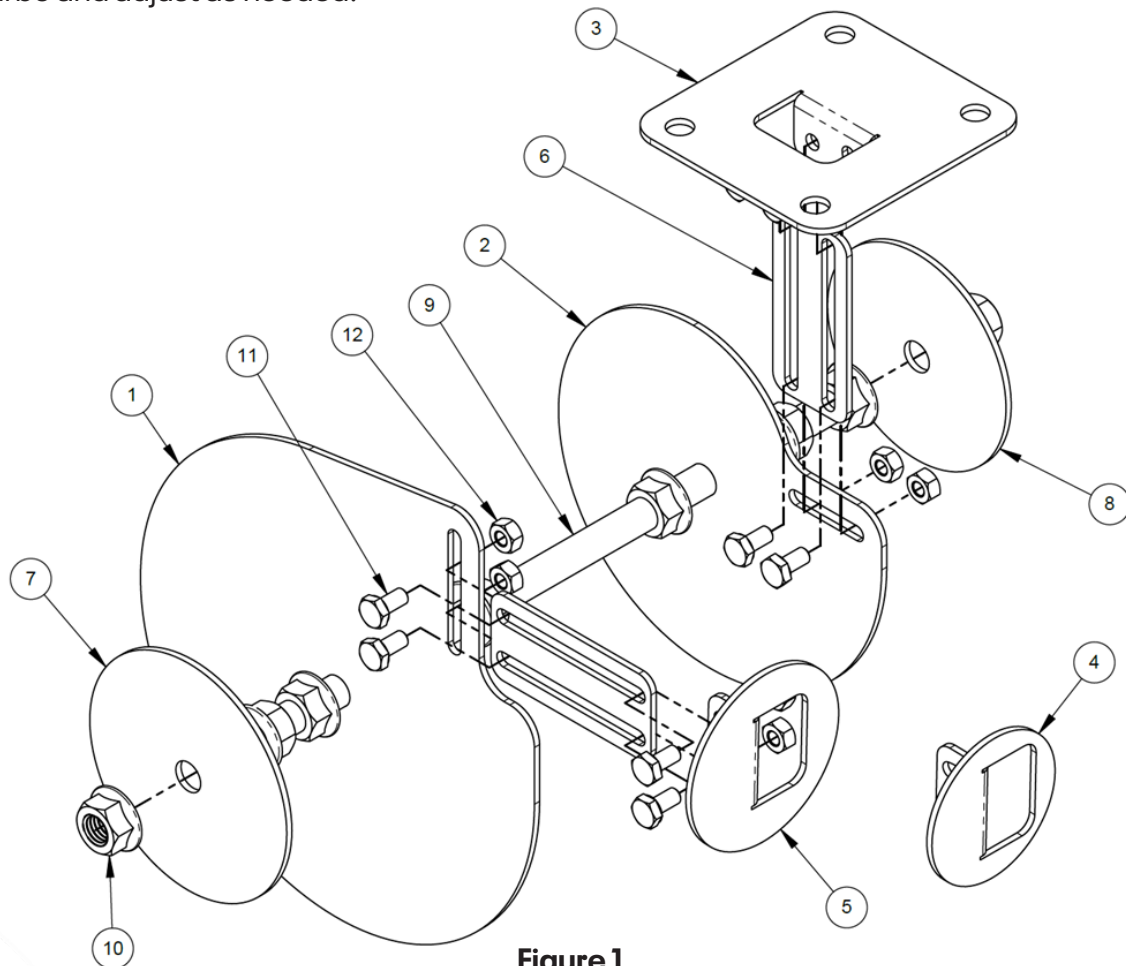


Figure 1.

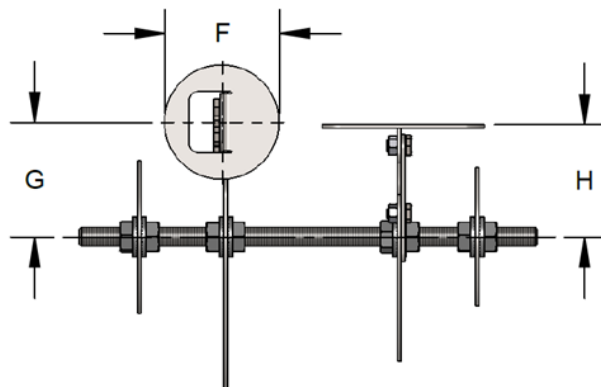
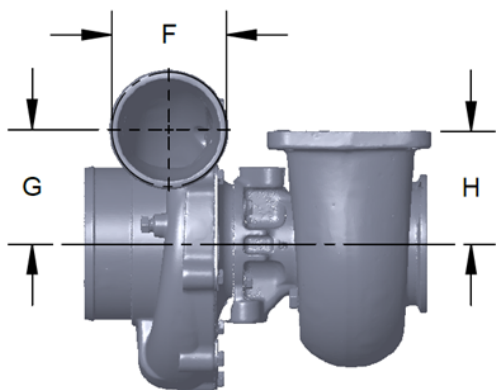
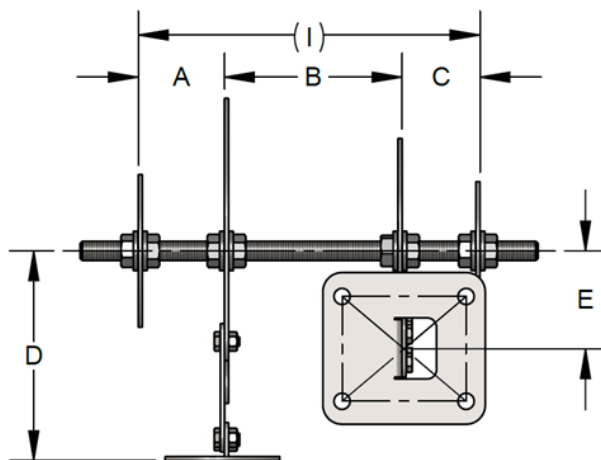
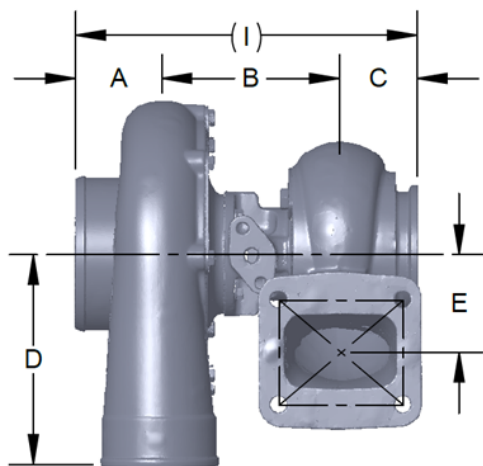
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Figure 2.

SKU#	A	B	C	D	E	F	G	H	I
6038870	2.15	4.81	2.74	5	2.56	2.5	3.5	3.5	9.7
60312300	2.31	4.77	2.07	5.5	2.59	3	3.15	2.95	9.15
60312727	2.27	4.58	2.1	5.5	2.55	3	3.17	2.95	8.95
60331794	2.26	4.65	2.04	5.5	2.57	3	3.01	2.95	8.95



## 91015031.INSTRUCTIONS

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 DIMENSIONS NOTED [ ] ARE THE NEAREST 1/16 INCH

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