

MSD **IGNITION** **INSTALLATION INSTRUCTIONS**

MSD 3/8" Magnets PN 4309

IMPORTANT: Read the Instructions completely before attempting the installation!

CAUTION: These magnets are very brittle! Damage will result if the magnets are allowed to snap together or against a metal surface.

This kit is intended for custom installations. Instructions are only given for magnet installation. It is left up to the customer to install the pickup(s) and ignition.

Note: An aluminum flywheel is required. **Do not** install magnets to a steel flywheel.

Parts Included

2 - 3/8" Magnets, PN 4309

Parts Required, Not Included

JB Weld Adhesive 24 Hour or Scotch Weld

Drill Bit

Degree Wheel or Timing Tape

Note: Placement of the magnets is very critical to the timing of the engine. The magnet mounting holes should be drilled using a rotary table or indexing head. It is recommended to use a professional machine shop.

MAGNET POSITION

MOUNTING HOLE REQUIREMENTS

Bore Diameter: It is recommended for the magnet mounting hole to be approximately 0.015" larger than the magnet diameter. Bit size:

3/8" Magnet: Use a 0.390" (25/64) bit.

Depth: The magnets **must** be mounted flush with the flywheel or ring. The 3/8" are 0.125" (1/8) deep. To obtain a flat mounting surface for the magnets, an end mill is required.

Through Hole Diameter: This hole should be drilled all the way through the flywheel to allow the glue to escape. Use a 0.156" (5/32) bit for the other magnets.

INSTALLATION

After drilling the magnet mounts for your specific application, follow the procedure below to install the magnets.

Note: When installing a magnet for PN 4151 or PN 42351 ignition, the polarity of the magnet must be correct. The south side, which is marked, should face out toward the trigger pickup.

Place a small amount of JB Weld adhesive around the entire diameter and across the bottom of the magnet. Slide the magnet into the hole and then press firmly down on the magnet. To keep the magnet in place while the adhesive cures, place a metal object on the back side of the flywheel so the magnet will pull toward the metal surface.

Note: Refer to the installation instructions supplied with the JB Weld.

