

Flycutter Head

BHJ's Flycutter Head makes fast work of surfacing cylinder heads and blocks and adds versatility and value to your existing milling machine for all types of general machining operations. The Flycutter Head is supplied with both a Carbide Cutter for machining aluminum and a CBN Cutter for use on cast iron. The CBN Cutter Insert enables speeds and feeds of more than three times that of carbide inserts when used on cast iron. Tests conducted in our factory indicate a .005" depth of cut on a cast iron Big Block Chevrolet head can be performed in four and a half minutes using the CBN Cutter.

The single-cutter design allows quick changing from carbide to CBN cutting without losing the ability to cut quickly and accurately. The 7" diameter Body can be adjusted to cut from 9" to 12" diameters and the 15-pound weight of the Head acts to dampen the cutting operation, resulting in a smooth, chatter-free cut. Recommended initial settings are 500-RPM Speed, .005" Depth and 5" per minute Feed. Speed and Feed can be varied from that point, based on results.



An R-8 style Arbor is included standard, which allows the Cutter will fit the spindle of most vertical mills. Other Arbor styles are available as well and can be quoted on request.

Precision Straight Edge

BHJ's Precision Straight Edge is second only to granite in accuracy and durability for precise measurement of straightness.

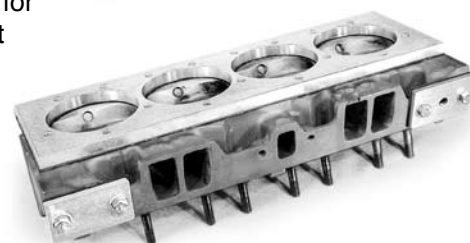


The Straight Edge weighs just-under ten pounds, measures .625" thick by 2.500" wide and has a 29" long measuring edge, which is beveled to .250" wide. After grinding, each unit is finished to .0005" straightness over its full length. Stress-relieved cast iron construction makes it virtually indestructible and a Finger Groove on each side ensures safe handling. A wooden Storage Block is included to prevent damage to the measuring edge.

Pressure Test Kits

BHJ's Pressure Test Kits are quick and easy to use. The kit is affordable for the shop that does only a small quantity of cylinder heads. Pressure test kits are available for all cylinder head and block applications. Simply install the Kit, pressurize the water jacket and submerge the head or block to locate the leaks.

Each Kit contains one aluminum Block-off Plate, all necessary Fasteners and durable, reinforced Rubber Gaskets. "X2" Kits are available for V6, V-8, V-10 and V-12 block configurations and include everything needed to seal the entire block.



Cylinder Head Intake Angle Levels

BHJ's Cylinder Head Intake Angle Levels provide quick and accurate measurement of the intake surface angle on small block Chevrolet or big block Chrysler cylinder heads. The Level is an absolute must for shops that angle-mill cylinder heads or just need to clean up the intake surfaces. The Levels guarantee the correct included angle, rather than assuming the existing angle is perfect from the factory. A Level is fastened to the milled deck surface of the head and the head is then indexed by zeroing the Intake Edge of the Level with a dial indicator or micrometer (not included).

The VT-4 Intake Angle Level is suitable for use in correction of the 80-degree included-angle found on cylinder heads such as small block Chevrolet and big block Chrysler with 23-degree valve angle. The VT-4A Intake Angle Level is suitable for 18-degree small block Chevrolet.

