



Cylinder Head Fixture (CHF-2)



BHJ's Cylinder Head Fixture ensures accurate positioning of any cylinder head from an established reference point, which is necessary to properly perform many cylinder head machining operations. The cylinder head is mounted in the Fixture from the valve cover side for most procedures, which leaves all other surfaces exposed for machining. On most cylinder heads, mounting in this manner leaves the valve guides and spring seats exposed for machining as well. The head can also be mounted from the deck, leaving the top surface fully exposed for additional machining operations.

Precise setup is accomplished by inserting locating dowels into the deck surface, and positioning the head using a pair of supplied adjustable-length Setup Standards. Once the head has been clamped in the Fixture, it can be rolled into position and leveled both across its width as well as end-to-end, using the Height-adjustment Feature located on the Protractor end of the Fixture. Setting-up in this manner ensures that the travel of the cutter head is always parallel to the dowel pin centerline as the head is rolled over in the Fixture. This is critical when correcting the included angle between the deck surface and the intake surface. Use of the large Protractor and Vernier Pointer allows this angle to be held within twelve minutes of one degree.

The Fixture utilizes massive Cast Iron End Supports, which are keyed for accurate alignment on a machine table. Supports are machined to accommodate the T-slot spacing of all common surfacing and milling machines. The infinite pivot point provides 360-degree rollover capability and accepts 4 cylinder, V-6 and V-8 heads up to 23-1/2" in length. Straight-6, V-10 and V-12 heads can be accommodated with the addition of the "XL" Step-Up Kit. Custom-length Bars are also available on a special-order basis.

Heads