

# Lower Cylinder Baffling Instructions

This is a way to direct airflow around the cylinder head fins and cylinder fins. It was developed by Dan Horton and shown to me by Mark Frederick. It replaces the sheet metal baffles on the lower half of the cylinder heads and cylinders.

You will need 1 mil plastic, thin cardboard for patterns, sharpie marker, .020 to .032 aluminum, a large tube of high temp silicon and small pieces of 5 to 9 ounce fiberglass.

Make a pattern that covers the total height of the cylinder fins and wraps approximately 1/4 of the circumference. Fig 1. Clean, degrease and lightly sand the edge of the fins where the baffle will go.

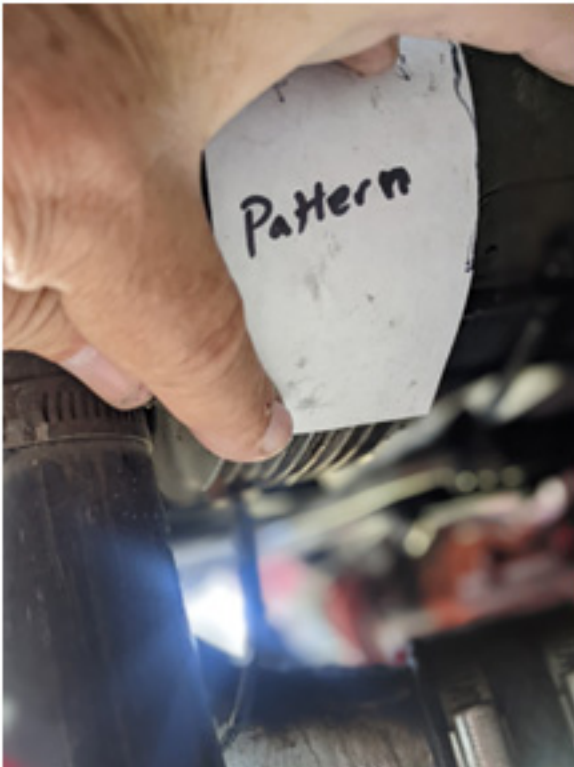


Fig 1

Lay the pattern on the plastic sheeting that is several inches larger and trace the pattern.

Fig 2



Fig 2

Apply silicon to the pattern Fig 3. Lay an oversize piece of fiberglass on the pattern. Put another piece of plastic on top of the fiberglass and silicon. Fig 4. Use a round item to roll the fiberglass into the silicon.



Fig 3



Fig 4

Fig 5



Fig 5

# Lower Cylinder Baffling Continued

When the silicon has saturated the fiberglass evenly cut plastic, fiberglass and silicon to the pattern size. Fig 6.



Fig 6

Peel the plastic from the engine side of the layup and apply to the cylinder fins. Fig 7



Lightly press it down to be touching all the fins and smooth it out. Fig 8



Fig 8

Let cure and peel the remaining piece of plastic off. Fig 9



Fig 9

Repeat for the other cylinders.

Cylinder heads are done similar except the area on the intake valve where the fins are very short and almost flat. Figs 10, 11, 12

Bend a small piece of aluminum sheet to make a hump over the area about 1/4" tall. This allows airflow over and around this area. Make your pattern to cover the sheet metal and the other cylinder head fins around it.



Fig 10



Fig 11



Fig 12



## Lower Cylinder Baffling Continued

Use the same technique to seal between the cylinders.

