

# Tappet Hold Down Kit

## Jaguar 3.4, 3.8 4.2 XK Engines

1. Be certain that all of the tappet guides (follower guides) are tight in the head and are firmly seated against the head before installing the locking plates.
2. Position the plates in the correct places on the cylinder head, while holding one of the plates firmly in place, use a ¼" drill bit and dimple the cylinder head slightly at one of the holes in each locking plate to provide a starting pocket for the tap drill. This will help to prevent the tap drill from wandering.
3. Using the cam cap studs to align the drill for the correct angle, drill the tap drill hole with a number 8 (.199) drill bit.  
(Note) if the cylinder head is still on the car or where chips getting into the oil galley area of the head is a problem, use a drill stop or mark the drill bit. Do not drill through the upper part of the casting. In this case, after tapping the hole with a starting tap be sure to finish tapping them with a bottoming tap. You will also find it helpful to place rags in the oil drain back hoses to keep chips out. The use of a vacuum cleaner can be very helpful in removing chips after drilling. Where chips are not a problem, the holes can be drilled through the upper web of the casting into the oil galley area.
4. Tap each hold with a ¼ - 20 tap. If needed be sure to finish with a bottoming tap.
5. Install one ¼ - 20 x ¾ zinc plated cap screw in each plate and secure the plates to the head. With one bolt holding each plate in place, use the ¼ drill bit and dimple the cylinder head at the second hole in each plate to provide a starting pocket for the tap drill.
6. With the number 8 drill and the ¼ - 20 tap, drill and tap the second hole in each plate using the locking plate as a guide.
7. After all holes have been drilled and tapped, remove the ¼ - 20 cap screws and discard them. These cap screws are only to be used temporarily to hold the plates in place while drilling to keep from damaging the Nylok inserts on the permanent locking bolts.
8. After cleaning all the holes and removing all chips, install the locking plates on the head using the lock washers and the 12 ¼ - 20 x ¾ socket head cap screws. Tighten the cap screws firmly, but do not over tighten. The use of Loctite or a similar product on the bolts as an added safety precaution is also recommended. Loctite may be purchased at most auto part stores.