

## How to Modify Head Gaskets to Use in the EJ20/22 Head to EJ25 Block Application

*Reprinted with permission of Glastar Builder, James Rekieta.*

To anyone who may be considering removing and re-installing their heads, and taking into consideration that the *experts* on the Fly Soob site rate re-using head gaskets as one of the deadliest sins, you can modify these gaskets yourself without a shop full of expensive machines and tools. I modified a set with a drill press and a dremel tool. The key is to separate the multilayered gasket at the stamped corners and work on one layer at a time after first drilling areas that can be drilled. It can be done; it just takes some time.

Here's how I did it.

- Overlay a modified gasket on the new gasket and mark the offending areas with a fine tip felt marker.
- Pre-punch each area that can be drilled, at a distance away from the radius mark and step drill up to the mark.
- Start with a very small bit and step drill a few sizes up. Drill up with a small unibit to the outside radius of the marks.
- Carefully separate the gasket assembly and remove the remainder of the material using a dremel tool. (I started out with a straight burr and then finished up with a small straight abrasive bit that is used to sharpen a chain-saw chain.
- When all the offending areas are removed and de-burred, reassemble the layers and tap them back together using a small punch at each corner.

Pointers:

- Be very careful not to scrape the glue off the metal while machining or overheating the glue by rushing the process.
- The gasket material is very hard and you can create a lot of heat if your tools aren't really sharp. So always use sharp tools and bits. *I went through a couple straight burrs and a couple straight abrasive burrs.*

Take your time and don't force your work, you'll be surprised at the results.