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Yamaha 1100/1200 Billet Head Installation Instructions

<u>Quantity</u>	<u>ADA Part#</u>	<u>Description</u>
1	YA1100/1200SS	Billet head shell
3	YA21ccL	1100 Domes, (last 2 #'s = dome volume)
3	YA76ccL	1200 Domes, (last 2 #'s = dome volume)
3	OR020	Upper dome o'ring - groove in dome
3	OR024	Upper dome o'ring - groove in shell
3	OR043	Compression o'ring - viton
1	ORYA1100	Outer head shell o'ring - water sealing
2	BF183890	1/8" x 3/8" 90° brass barb
1	BF18PLG	1/8" npt brass plugs

Note:

Install the ADA Racing® billet cylinder head with the water outlets on the intake side.
Do not use silicone on any of the orings or surfaces!

Installation Procedure

- 1) Remove stock head and clean the top surface of the cylinder.
- 2) Install the 2 90° brass fittings in the outer cylinder locations. Install the 1/8" npt brass plugs in the center cylinder location.
- 3) Install all o'rings in the ADA Racing® billet head, use small amounts of grease to hold them in place, do not use super glue or silicone.
- 4) Apply a small amount of grease to the small (OR020) o'ring at the top of the dome. This will allow the dome to easily slip into the head shell. Be careful when turning the head upside down to install onto the cylinder, as the domes can slide out of the head shell.
- 5) Make sure all the o'rings are in place and place the head on top of the cylinder with the water outlet on the intake side. You must be sure that none of the o'rings slip out of their groove, as this will cause an o'ring to get pinched and a water or compression leak could result.
- 7) Torque all of the nuts to 15ft/lbs, in a center-out criss-cross pattern. Now, torque them again to 18ft/lbs.
- 8) After the 1st time out riding the head should be re-torqued.
- 9) The additional 1/8" npt hole in the ADA Racing® billet head comes with a brass plug, but a barbed fitting can be installed for custom water routing applications.
- 10) If you are using an ADA Racing® girdle head, please follow the instructions that came with your ADA Racing® girdle kit.



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Yamaha Girdle Kit Instructions

Kit Includes:

6 - stainless studs
6 - 10mm flat washers
6 - 10mm acorn nuts

- 1) Clean studs and nuts with a solvent, brake cleaner, or contact cleaner.
- 2) Apply anti-seize (preferred) or grease to the threads on both ends of the studs.
- 3) Check the threads on the studs by installing a nut onto each one of them. Make sure that they go on easily and then back off. Remove nuts from studs.
- 4) Install studs with the long ends of the threads into cases, make sure the studs go all of the way in. The studs should all be approximately the same height when sticking out of the cases. It may be necessary to clean the lock-tite from the case holes applied by the factory. Do not bottom the 10mm acorn nut to install the studs! It is best to use a stud tool. The studs do not need to be torqued into the cases, they should just be tightened until they stop.
- 5) The head can now be installed, hand tightening all head bolts and girdle nuts.
- 6) First torque the head bolts to 15ft/lbs, then torque the girdle nuts to 15ft/lbs. Then torque the head bolts to 18ft/lbs and the girdle nuts to 18ft/lbs. Torque the girdle nuts to 23ft/lbs.
- 7) Now, re-torque all head bolts to 18ft/lbs and the girdle nuts to 23ft/lbs. Periodically re-torque after initial use.

**ALWAYS TORQUE BOLTS WORKING FROM THE MIDDLE OUT
AND IN A CRISS-CROSS PATTERN**