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Yamaha 701/760 Girdled Billet Head Instructions

<u>Quantity</u>	<u>ADA Part#</u>	<u>Description</u>
1	YA701M	Billet girdled head Shell
2	YA21ccL	701 Dome(81-83.5mm bore)cc = dome size)
2	YA76ccL	760 Dome(84-86mm bore)(cc = dome size)
2	OR043	Compression Oring - Dome to Cylinder
2	OR024	Head Shell to Dome Oring
2	OR020	Oring Around Top of Dome
1	ORYA701	Outer Head Shell Water Sealing Oring
2	BF1838	Brass Fitting - 1/8" npt by 3/8" hose barb
1	BF18PLG	Brass Plug - 1/8" npt

Read First!

Please read these instructions completely through before starting the installation. If you are also installing a girdle kit, read those instructions beforehand as well.

Please note that the ADA billet head is installed with the water outlets on the carburetor side of the engine. The ADA billet head does not use a head gasket and must be installed with the outlets on the carb side for proper cooling.

Do not use silicone or gasket sealer on any of the head surfaces.

This head uses standard reach spark plugs, like NGK BR8ES or BR9ES.

Installation Procedure

- 1) Remove the stock head and clean the top surface of the cylinder.
- 2) Install the domes and all orings in the ADA billet head. Use small dabs of grease to hold orings in place, do not use glue or gasket sealer of any kind! When installing the larger outer oring, push it back as you are installing it into the groove, otherwise it may appear that the oring is too long.
- 3) Install the ADA billet head onto the cylinder with the water outlets on the carburetor side. Make sure that all orings stay in place and do not come out of their groove, causing them to get pinched.
- 4) Install the stock head bolts, first torque to 15ft/lbs then to 18ft/lbs. The torque pattern should be done the same as the stock head, center of head outwards. Re-torque the head bolts after the initial use and then periodically thereafter.
- 5) Water routing can be done different ways and careful experimentation is recommended. However, it is best to start with the stock water routing or if using an aftermarket exhaust system, the recommendations of the pipe manufacturer. When experimenting with water routing, always check front and rear cylinder temperature for consistency.
- 6) If you are using a girdle head, please follow the instructions on the reverse side for installing the girdle kit.



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Yamaha Girdle Kit Instructions

Kit Includes: 6 - stainless studs 6 - 10mm flat washers 6 - 10mm acorn nuts
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- 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 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**