

# Power Brake Sales

## HYDROBOOST MASTER CYLINDER KIT

### ASSEMBLY INSTRUCTIONS

## CUTTING & SHAPING THE ROD TO FIT

Since we started offering this hydroboost kit we have received multiple calls every week about how to properly cut the rod to fit between the hydroboost and master cylinder. We hope the following information will help to answer any questions.

To keep this as basic as possible I used hand tools to cut and shape the first rod and then basic shop tools on the second rod. I have done this to prove it is possible to do it both ways. Hand tools just take a little longer but the results are the same. With basic shop tools this should take about 10-15 minutes and expect 25-30 minutes with only hand tools. Add 15-30 minutes if you have never done anything like this before. IT IS EASY TO DO it just takes a little time.

ALL UNITS ARE NOT THE SAME! USE COMMON SENSE TO DETERMINE THE CUT!

Start with gauging how much you need to cut off (there are tools that you can buy but I don't think it is worth it for one or two times). I line up the hydroboost and master cylinder with only the rod inside, **with the grooved end in the hydroboost** (this way I don't damage the centering disc) and with them firmly hand pressed together (do not clamp) I mark the rod flush with the hydroboost (Fig.1). You can see the mark in the second image (Fig.2).

Fig.1

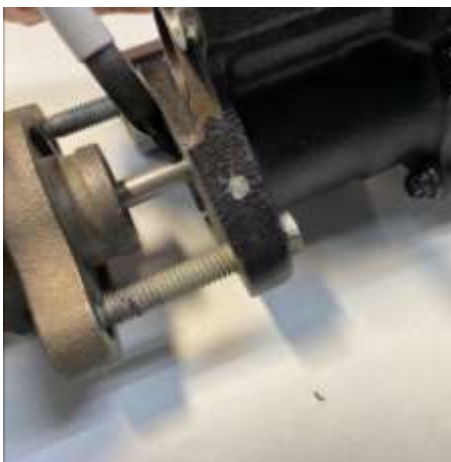


Fig.2



**DO NOT CUT THE GROOVED END OF THE ROD!**

Once I have a rough mark I put the rod in a vise and using a hacksaw I cut OUTSIDE the line! (Fig. 3&4). You do not want to cut this short so sneak up on your correct measurement. I then use a file or bench grinder (Fig. 5&6) to shape the end of the rod (**do not skip this step or you will damage the master cylinder**). Use the off-cut end as a guide (Fig. 7&8) to shape the rod.

Fig. 3



Fig. 4



Fig. 5



Fig. 6



Fig. 7



Fig. 8



Once you have the rod shaped, install it between the master cylinder and hydroboost. Expect a gap the first time (Fig.9). Use that gap as a guide to tell you how much material to remove by cutting, filling or grinding. Once you get within a 1/4" do not cut any more, only file or grind or you risk removing too much material. You want the rod to be 1/32" to 1/16" clear of the master cylinder once the hydroboost and master cylinder units are mated flush (Fig.10). It takes me two or three times to get the proper fit so expect that or more the first time.

Fig. 9

(1<sup>st</sup> expected gap. Within 1/4" only file or grind)



Fig. 10

(perfect fit after filing a few times)



**Make sure to install all parts in the kit as directed in the included instructions detail.**

**Toll Free 800-624-8185 or [www.powerbrakes.com](http://www.powerbrakes.com)**