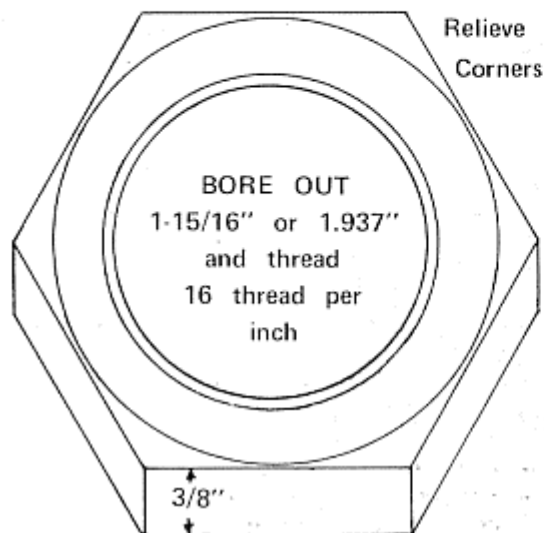


MAKING A TOP WATER COVER NUT FOR A WILLYS-KNIGHT

4 CYLINDER AND BIG 6 MODELS

by Earl Stidworthy



1 1/2" X 2" Pipe
Reducing bushing
Black iron or
Galvanized

Face off or file nut
smooth and flat. Relieve
hex corners on fiber
washer side.

Face off or file top
side a little.

To make a top water cover nut for a Willys-Knight 4 cylinder or big 6, often broken while removing the top water cover, follow these steps:

1. Take a 1 1/2 x 2 inch pipe reducing bushing and set it up in a 3-jaw lathe chuck.
2. Cut off the threaded end next to the hex end.
3. Bore out pipe threads with a boring tool (boring bar) to 1-15/16 inch or 1.937 inch and thread with a threading tool 16 threads per inch.
4. Do not remove from chuck till threads are finished. You should test fit with an old cylinder head that has well cleaned threads.

Note: "O" rings that fit between the nut and water cover on 1920-25 4 cylinder and 1926 6 cylinder big sixes are the same as Dodge, Plymouth, Chrysler gas tank neck seal Mopar # 1730087.

Light six "O" rings are the same as Valient and Dart Mopar # 2073938.