

REPAIRING CRACKS IN CAST IRON

Stitching a crack in cast iron parts such as the Model A cylinder head, engine block or timing gear cover can be done using the following method. This method has been used for many years.

- Use some 1/8" solid brass rod (as from a hobby store, welding rod has a coating that has to be removed), a 6-32 tap, a 6-32 die and a #36 drill (also from a hobby shop).
- Centre punch, drill and tap a starting hole at one end of the crack. Cut a thread about 3/8" long on the brass rod and screw the rod end into the threaded hole, seating it hard against the end of the thread. Cut off the rod flush with the surface.
- Centre punch and drill a second hole, using the joint line between the edge of the first plug and the cast iron as the centre punch point. The new hole will cut into the brass and cast iron resulting in the desired overlap. Thread the hole and rod as above and screw in the rod tight. Continue the process until the entire crack is filled with brass. File or grind the brass inserts to match the contour of the rest of the surface.