The EX Weld-In Fix oil pan drain plug repair part makes a permanent and correct repair of stripped or stretched oil drain plug holes easy, but some machining and welding is required. NOTE: The pan must be off the engine.

Install as follows:

1. Thoroughly clean and degrease the oil pan, especially in the area of the oil drain hole. Also remove any remaining traces of brazing in the weld area.
2. Machine a hole of 1-3/16” (1.187/ 1.190”) through the pan, concentric with the existing oil plug hole.
3. Note that the EZ Weld Fix part has a weld prep (45 degree chamfer) on one side to ensure good weld penetration without too much heat. Weld only on the outside of the pan to minimize distortion. Coat the threads of a stock Model T drain plug (3/4”-24 thread) with metallic type anti-seize compound and screw into the EZ Weld to minimize distortion.
4. The best welding method is TIG (filler rod) but MIG or GMAW (wire feed) works just fine in skillful hands. Place EZ Weld into the 1-3/16” hole in the pan, flush with the outside, chamfer out. Tack weld no more than 1/8” on one side, and check for straightness and flatness. Straighten as needed, and put another tack at 180 degrees and check again. Brazing works just fine also, but a few weld tacks will hold it straight.
5. After putting tack welds at 90 and 270 degrees, continue welding in 1/8” increments, allowing cooling between welds.
6. Remove drain plug and finish off weld with a sanding disk or similar method.
7. Check for leaks by installing a stock drain plug and gasket into the pan and adding a gallon of water overnight.