



## FEL-PRO INSTALLATION TIPS

### A VALVE STEM SEALS

There are two (2) styles of valve stem seals included in this set. Proper application of each may be identified as follows.



R 13955  
Intake  
340 Eng., 1968-71



R 70537  
Intake  
318 Eng.,  
340 Eng.,  
1972-73

Exhaust  
318 Eng.,  
340 Eng., 1972-73

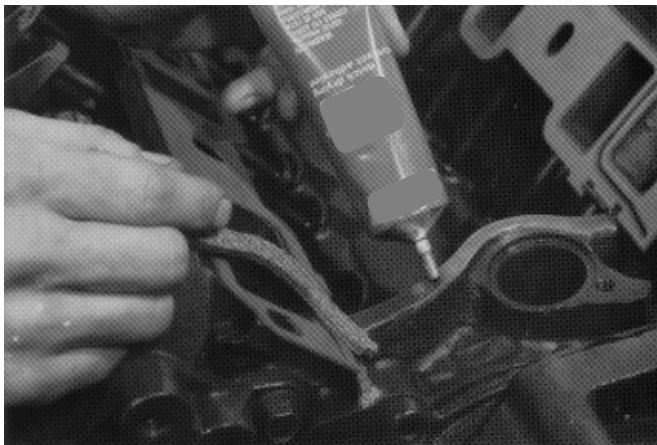
1. Remove spring assemblies and keepers.
2. Using a fine stone or crocus cloth, remove any burns from valve stem. Clean stems and guides and lubricate lightly.
3. Place plastic installation sleeve over end of valve stem. Trim sleeve so it extends 1/16 inch below keeper groove. Sleeve protects stem seal.
4. Start valve stem seal care fully over sleeve. Push seal down until it touches top of guide.
5. Holding seal jacket, push seal down over valve guide until top section of seal bottoming against top of guide.
6. Remove plastic installation sleeve and use for installing remaining seals.
7. Replace valve spring assemblies. Compress springs only enough to install keepers. Excessive compression can cause spring retainer to damage valve seal.

### B INTAKE MANIFOLD

To hold gasket in place during assembly, apply a thin even film of good general purpose sealer, to both sides of the gasket.

**NOTE** as a convenience, this set may be designed to fit more than one vehicle. If so, you may have additional parts left over after you have completed the installation.

### INTAKE MANIFOLD END SEALS



Apply a good firm-setting adhesive as an installation aid at several places on the front and rear engine block casting. Install front and rear manifold end seals.

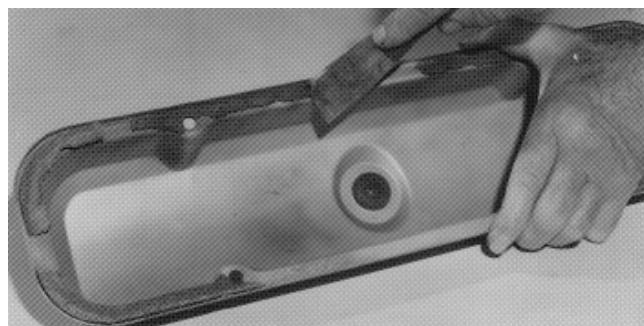
### INTAKE MANIFOLD END SEAL JOINTS



Apply 1/8" bead of RTV Black, included in this set, at the side rail and end seal intersections in four places. Install intake manifold casting.

### C VALVE COVER GASKET

You are installing the finest gaskets made the result of exhaustive research and exacting manufacture. But no gasket is better than its installation!

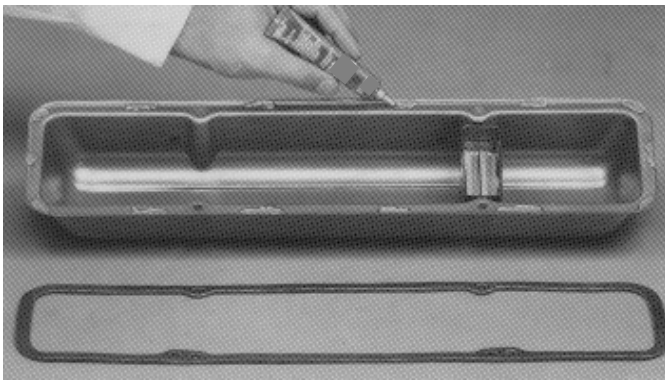


1. **CLEAN SURFACES OF FOREIGN MATERIAL** - Accumulation of foreign particles of any kind can form channels through which oil can travel.



2. **STRAIGHTEN METAL FLANGES** Check cover by visual sighting or straightedge method. Straighten as required. Severely distorted covers should be replaced.
3. **WIPE OFF EXCESS OIL.** Wipe excess oil from mating surfaces prior to installation of gasket, clean oil return holes in the cylinder head.

- continued on reversed side -



**4. ADHERE GASKET TO SHEET METAL** - Affix gasket to cover with good adhesive, wherever possible, usually to outer edge of cover, in radius of skirt. Allow ample time for adhesive to set.

**5. ALIGN GASKET PROPERLY** - Check fit alignment of gasket to mating surfaces.



**6. AVOID OVER-TORQUING** - Excessive tightening is destructive! Visible distortion of sheet metal cover is indication of over-torquing.

**7. TEST RUN ENGINE** - Thoroughly check all sealing areas to insure perfect sealing.

You have properly installed FEL-CoPrene®, the gasket material designed to meet today's automotive needs.

## **D WATER OUTLET GASKET**

To hold gasket in place during assembly, apply a thin even film of a good general purpose sealer to both sides of the gasket.

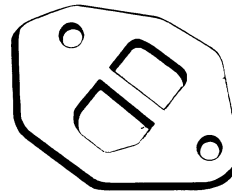
## **E E.G.R. MANIFOLD GASKETS**

Rough Engine Idle. The use of the incorrect gasket on the intake manifold's exhaust gas recirculation valve pad can cause rough engine idle. Because two manifold EGR valve pad passage designs were used on 1973, the correct gasket (see illustration) must be used to seal the passages properly. Improper seal will result in rough idle.

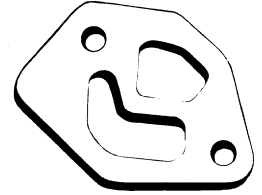
USE AS FOLLOWS:

YEAR

|            |       |
|------------|-------|
| 1972       | 70554 |
| 1973 Early | 70554 |
| Late       | 70557 |
| 1974-81    | 70557 |



EARLY MANIFOLD  
USE GASKET 3671436  
(90074) 70554

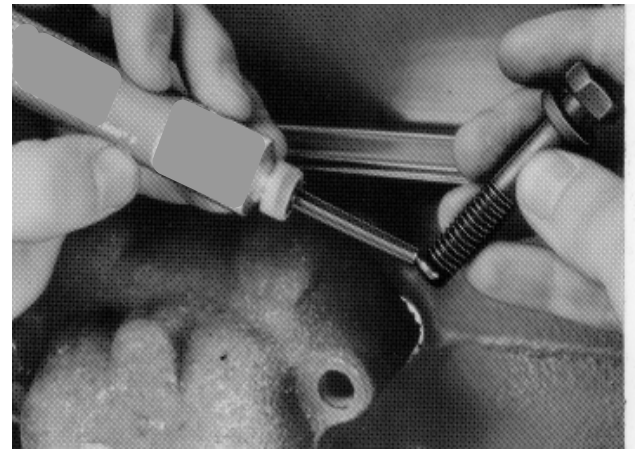


LATE MANIFOLD  
USE GASKET 3751714  
(90074) 70557

## **F EXHAUST MANIFOLD GASKETS**

**INSTALL METAL SIDE OF GASKET TOWARD MANIFOLD CASTING. WHEN REUSING A HEAT SHIELD, GASKETS MUST BE INSTALLED BETWEEN MANIFOLD CASTING AND HEAT SHIELD.**

## **G EXHAUST PIPE FLANGE MOUNTING BOLTS, EXHAUST MANIFOLD BOLTS, E.G.R. MOUNTING BOLTS**



To prevent seizing and galling, apply a high performance lubricant, to bolt threads.

