



FEL-PRO INSTALLATION TIPS

GENERAL INSTRUCTIONS

CLEAN MATING SURFACES. Use a degreaser.

CLEAN THREADS of bolts/studs; for nuts/threaded holes use a bottoming tap.

BOLT PREPARATION: Those **entering** coolant passages require a pliable non-hardening sealer on threads and underside of bolt heads. Those **not entering** coolant passages require oil on threads and underside of bolt heads. **Exhaust Assembly:** Apply a high temperature anti-seize lubricant to threadings.

CHECK CASTINGS for flatness. Straighten, resurface or replace if needed. **CYLINDER HEAD AND BLOCK:** Refer to OEM manual to determine flatness tolerances and resurfacing limitations.

FINAL ASSEMBLY: Torque all fasteners to OEM specifications unless noted. **CYLINDER HEAD** torquing is critical; we recommend that you confirm with OEM.

WATER OUTLET, WATER PUMP, FUEL PUMP AND TIMING COVER GASKETS

If a supplementary sealer is desired, apply a thin coat of gasket sealer to both sides of gasket(s).

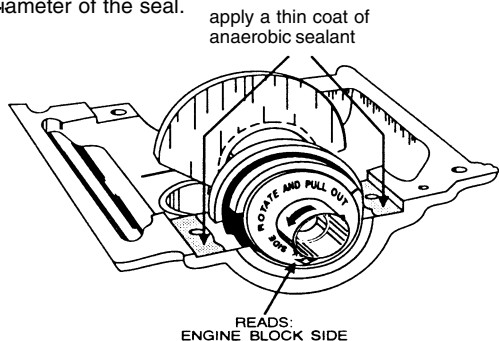
REAR MAIN BEARING SEAL

To properly install the rear main bearing seal, it is necessary to **remove** the crankshaft.

LUBRICATE SURFACE of seal lip and crankshaft by applying a thin coat of motor oil or grease. If engine will not be started within several days, grease is recommended.

IMPORTANT: Never install any seal without break-in lubricant protection.

PRIOR TO INSTALLING THE REAR MAIN BEARING SEAL, with the seal retained on the installation tool apply an anaerobic sealant to the outside diameter of the seal.



INSTALL SEAL to the crankshaft using the installation tool. The seal is properly installed when:

Its largest raised sealing lip is toward the **front** of the engine.
It seats itself onto the crankshaft.
Is properly aligned with the arrow on the tool pointing toward the engine block.

With the assembly in place, reinstall crankshaft to block. Now, remove the installation tool by rotating the tool in the direction of the arrow.

PRIOR TO INSTALLING THE REAR MAIN BEARING CAP apply an anaerobic sealant to the cylinder block mating surface where it meets with the rear main bearing cap.

REINSTALL CAP TO CYLINDER BLOCK. Torque to OEM specifications.

OIL PAN GASKET

The cork-rubber oil pan rear end strip supplied in this set replaces the molded rubber rear end seal supplied by OEM.

ATTACH AND ALIGN GASKET(S): Apply quick drying adhesive sparingly in several places on the engine casting or oil pan (depending upon engine model). Mount gasket on surface where adhesive was applied.

Allow time for adhesive to set. Test for slippage with light pressure. If gasket moves, allow more time.

PRIOR TO INSTALLING OIL PAN apply a small dab of silicone sealer where all gaskets and seal(s) meet.

OIL FILTER

For 1982 rear wheel drive "F" body and "ST" truck applications: Use the 2 5/8" diameter rubber "O" Ring on engines **with** the groove in the casting; use the paper gasket on engines **without** the groove in the casting.



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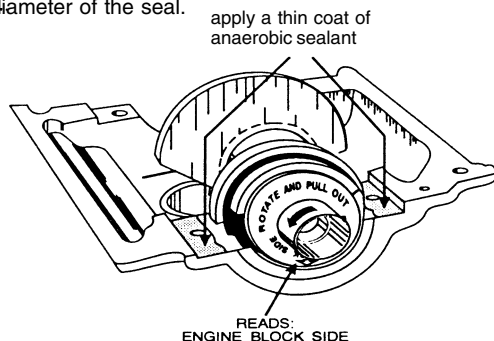
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