

INTAKE MANIFOLD GASKET

Use proper gasket as indicated for the right and left side.

DO NOT CUT the Intake manifold gaskets for clearance of pushrods. Cutting the gasket will reduce its structural integrity and welcome failure. Install pushrods after the gaskets are already in position.

CREATE INTAKE MANIFOLD END SEALS by applying a continuous 3/16" bead of silicone sealer across the front and rear ends of the cylinder block, from one cylinder head to the other.

EXHAUST MANIFOLD GASKET

ATTACH AND ALIGN GASKET(S). If gasket has only one steel faced side, install steel side towards manifold.

MISCELLANEOUS FLUID SEALING GASKET(S)/SEAL(S)

ATTACH AND ALIGN GASKET(S)/SEAL(S): If supplementary sealer is desired, apply a thin coat of gasket sealer to both sides of gasket(s). However, molded rubber gasket(s) or those with colored Printoseal® sealing beads, install **DRY**.

ROTATING SHAFT SEALS

RUBBER SEAL(S): Install seal with its **largest raised sealing lip toward the engine**. Two-piece rubber seals may be installed using a "shoehorn" installation aid placed underneath seals to protect the from sharp edges.

ROPE SEALS: Install seals into grooves of cap and block by firmly pressing packing into grooves with a "packing tool." Ensure that the ends of seals protrude above face of cap and block.

IMPORTANT: Final interference of rope packing seals against crankshaft is critical. To achieve proper interference, it is best to install packings using correct **Packing Tool** for your engine. With "packing tool" in position, cut protruded ends of seals flush with cap and block.

LUBRICATE SEALING LIPS AND CRANKSHAFT with 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.

REAR MAIN BEARING CAP: Prior to installation, apply anaerobic sealant to mating surfaces of cap or block. **AVOID** sealant on ends of seals.

OIL PAN GASKET

ATTACH AND ALIGN GASKET(S). Apply a quick-drying adhesive sparingly. Mount gasket and/or seals.

PRIOR TO INSTALLING OIL PAN apply a dab of silicone sealer where all gaskets and seals meet.



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 bolts 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.

HEAD GASKET

Follow any directional markings shown on gasket(s). If no markings exist, install gasket(s). **Fiber Faced Gasket(s):** Install dry. **Metal Faced Gasket(s):** Requires a thin even coat of sealer applied to the metal side(s) of gasket.

VALVE STEM SEALS



Positive
Intake



"O" Ring
Intake & Exhaust

For 1981 and later applications use **Positive Intake** in addition to the "O" Ring. Prior to 1981 use "O" Ring **Intake & Exhaust** only.

POSITIVE GUIDE SEAL: Use the plastic installation sleeve(s), included in this set, to prevent damage to the lip of the seal. Trim the plastic sleeve so it extends 1/16" below the keeper groove. Place the sleeve on the stem.

Carefully start valve stem seal over sleeve.

Remove plastic installation sleeve and reuse for installing remaining seals.

FOR RUBBER JACKET SEALS: Push seal down over valve guide until it bottoms.

FOR SOLID OR METAL JACKET SEALS: The use of an OEM service tool is recommended. If tool is unavailable, use a deep socket or rigid tube of appropriate diameter. Center tool (or socket) over the shoulder of the seal and tap the seal down over the guide until it bottoms.

VALVE COVER/PUSH ROD COVER

ATTACH AND ALIGN GASKET(S): Use a quick-drying adhesive applied sparingly. If gasket has installation tabs, adhesive is not required. **IMPORTANT:** If gasket is rubber, install dry.

INTAKE MANIFOLD GASKET

Use proper gasket as indicated for the right and left side.

DO NOT CUT the Intake manifold gaskets for clearance of pushrods. Cutting the gasket will reduce its structural integrity and welcome failure. Install pushrods after the gaskets are already in position.

CREATE INTAKE MANIFOLD END SEALS by applying a continuous 3/16" bead of silicone sealer across the front and rear ends of the cylinder block, from one cylinder head to the other.

EXHAUST MANIFOLD GASKET

ATTACH AND ALIGN GASKET(S). If gasket has only one steel faced side, install steel side towards manifold.

MISCELLANEOUS FLUID SEALING GASKET(S)/SEAL(S)

ATTACH AND ALIGN GASKET(S)/SEAL(S): If supplementary sealer is desired, apply a thin coat of gasket sealer to both sides of gasket(s). However, molded rubber gasket(s) or those with colored Printoseal® sealing beads, install **DRY**.

ROTATING SHAFT SEALS

RUBBER SEAL(S): Install seal with its **largest raised sealing lip toward the engine**. Two-piece rubber seals may be installed using a "shoehorn" installation aid placed underneath seals to protect the from sharp edges.

ROPE SEALS: Install seals into grooves of cap and block by firmly pressing packing into grooves with a "packing tool." Ensure that the ends of seals protrude above face of cap and block.

IMPORTANT: Final interference of rope packing seals against crankshaft is critical. To achieve proper interference, it is best to install packings using correct **Packing Tool** for your engine. With "packing tool" in position, cut protruded ends of seals flush with cap and block.

LUBRICATE SEALING LIPS AND CRANKSHAFT with 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.

REAR MAIN BEARING CAP: Prior to installation, apply anaerobic sealant to mating surfaces of cap or block. **AVOID** sealant on ends of seals.

OIL PAN GASKET

ATTACH AND ALIGN GASKET(S). Apply a quick-drying adhesive sparingly. Mount gasket and/or seals.

PRIOR TO INSTALLING OIL PAN apply a dab of silicone sealer where all gaskets and seals meet.



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 bolts 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.

HEAD GASKET

Follow any directional markings shown on gasket(s). If no markings exist, install gasket(s). **Fiber Faced Gasket(s):** Install dry. **Metal Faced Gasket(s):** Requires a thin even coat of sealer applied to the metal side(s) of gasket.

VALVE STEM SEALS



Positive
Intake



"O" Ring
Intake & Exhaust

For 1981 and later applications use **Positive Intake** in addition to the "O" Ring. Prior to 1981 use "O" Ring **Intake & Exhaust** only.

POSITIVE GUIDE SEAL: Use the plastic installation sleeve(s), included in this set, to prevent damage to the lip of the seal. Trim the plastic sleeve so it extends 1/16" below the keeper groove. Place the sleeve on the stem.

Carefully start valve stem seal over sleeve.

Remove plastic installation sleeve and reuse for installing remaining seals.

FOR RUBBER JACKET SEALS: Push seal down over valve guide until it bottoms.

FOR SOLID OR METAL JACKET SEALS: The use of an OEM service tool is recommended. If tool is unavailable, use a deep socket or rigid tube of appropriate diameter. Center tool (or socket) over the shoulder of the seal and tap the seal down over the guide until it bottoms.

VALVE COVER/PUSH ROD COVER

ATTACH AND ALIGN GASKET(S): Use a quick-drying adhesive applied sparingly. If gasket has installation tabs, adhesive is not required. **IMPORTANT:** If gasket is rubber, install dry.