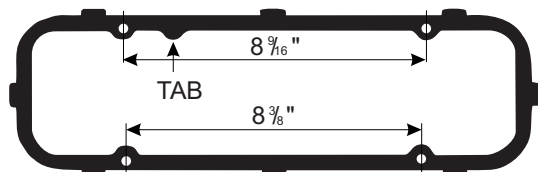


FOR RUBBER JACKET SEALS: Push seal over valve guide until it bottoms. **FOR SOLID/METAL JACKET SEALS:** Use of OEM service tool is recommended. If tool is unavailable, use deep socket or rigid tube of appropriate diameter. Center tool over shoulder of seal and tap seal down over guide until it bottoms.

UMBRELLA TYPE SEAL:

Start valve stem seal over valve stem; push seal down on seal body until it touches top of valve stem guide. Seal will find its proper position on stem once engine starts.

VALVE COVER GASKET



ATTACH AND ALIGN GASKET. Apply a quick-drying adhesive sparingly in several places on the mating surface of cover. If gasket has installation tabs, adhesive is **not** required. Mount gasket on cover. **Allow time for adhesive to set.** Test for slippage with light pressure. If gasket moves, allow more time.

INTAKE MANIFOLD GASKET

V-TYPE ENGINES - FIBER SIDE GASKET(S) ALONG WITH FRONT AND REAR END SEAL(S): Attach and align gasket(s) and end seal(s) using a quick-drying adhesive sparingly. **PRIOR TO INSTALLING INTAKE MANIFOLD** apply a dab of silicone sealer where all gaskets and seal meet.

INLINE ENGINES: Attach and align gaskets to cylinder heads.

EXHAUST MANIFOLD GASKET

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

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 them 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 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 an 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.

GENERAL INSTRUCTIONS

CLEAN MATING SURFACES. Use a degreaser.

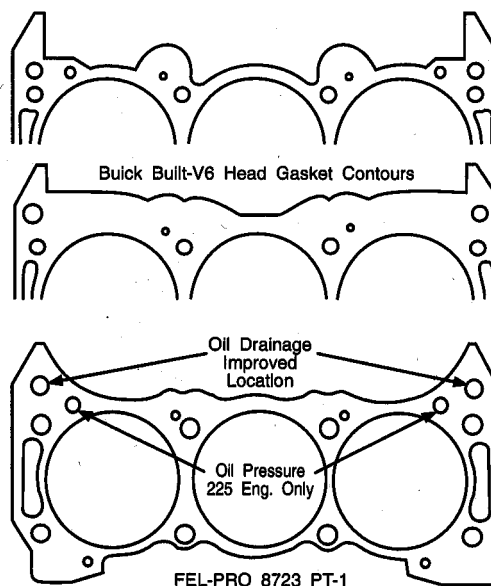
CLEAN THREADS of bolts/studs; for nuts/threaded holes use a bottoming tap.

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.

HEAD GASKET



IMPORTANT: Buick built V6 engine casting surfaces have different contours for each engine. Avoid intermixing cylinder heads and engine blocks of different displacements.

The head gasket in this set will effectively seal all engines covered by this set, even though it may not look identical to the one you removed.

ATTACH AND ALIGN GASKET(S) FOLLOWING ANY DIRECTIONAL MARKINGS SHOWN ON THE GASKET. If no markings exist, simply install the gasket by matching the gasket to engine deck surface.

FIBER FACED GASKET(S) are to be installed dry.

VALVE STEM SEALS

POSITIVE GUIDE SEAL:

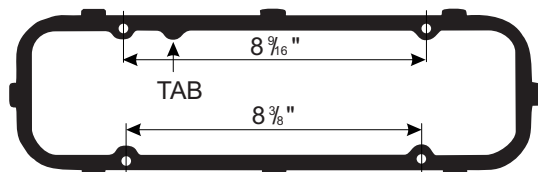
Use plastic installation sleeve(s), to prevent damage to lip of seal. Trim plastic sleeve so it extends 1/16" below keeper groove. Place sleeve on stem. Carefully start valve stem seal over sleeve. Remove and reuse plastic sleeve.

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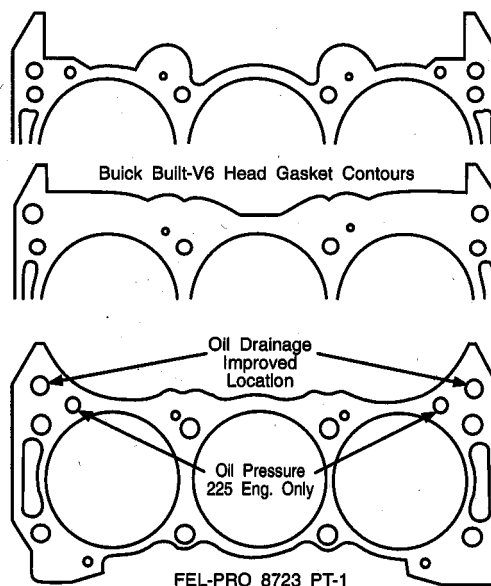
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