



FEL-PRO INSTALLATION TIPS

A HEAD GASKET

In order to apply proper clamp load to the head gasket, it is important that:

1. All bolt holes be cleaned out with a tap.
2. All threads be thoroughly cleaned with a wire brush.
3. All bolts that enter water jackets have a sealer applied to them.
4. All bolts that do not enter water jackets be lightly oiled.

B VALVE COVER GASKET

Remove foreign particles from gasket surfaces. Remove excess oil with a degreasing agent. Straighten the cover flanges. Severely distorted covers should be replaced. Cement gasket to cover using a quick drying adhesive. Apply sparingly and allow 1-2 minutes to set prior to gasket installation. Install cover and avoid overtorquing.

C INTAKE MANIFOLD GASKET

NOTE: BEST PERFORMANCE WILL BE OBTAINED BY MATCHING THE GASKET PORTS TO THE HEAD PORTS. READ THE FOLLOWING INSTRUCTIONS THOROUGHLY, THEN PROCEED.

1. INSTALL EXHAUST CROSSOVER RESTRICTORS.
 - a. Holding one of the restrictor insert halves with tabs up, position the open center port of the manifold gasket directly over the insert half.
 - b. Position other restrictor (insert tabs down) directly over open center port of gasket and bottom insert half.

NOTE: BOTH RESTRICTOR PIECES MUST FIT INTO RECESS AROUND PERIMETER OF CENTER PORT BEFORE AND AFTER PRONGS ARE BENT. FAILURE TO DO SO MAY CAUSE RESTRICTOR TO SLIDE OFF CENTER. THE FLANGED OUTER CIRCUMFERENCE OF BOTH THE UPPER AND LOWER RESTRICTORS MUST OVERLAP THE GASKET BODY.

- c. Bend the two (2) prongs of the lower restrictor piece outward over the upper restrictor piece using a blunt tool. Turn gasket over and repeat step 3. Make certain that the prongs are pressed down tightly so that the restrictor assembly is held securely in the gasket body.
2. Using a quick-drying adhesive cement the side rail gaskets to the cylinder heads; include the narrow walls between the intake ports.

IMPORTANT: Install the manifold gaskets with the blue beads facing up towards the manifold.

3. Carefully place the manifold onto the gaskets. Snug down several bolts and allow the adhesive to dry thoroughly.
4. Remove the manifold and using a sharp cutting tool, trim the gasket port to match the head ports.

5. Clean the end seal surface of the block with a degreasing agent.
6. Peel the backing from the end strips and press them into place.
7. Apply a 1/8" bead of silicone rubber sealant at the side rail and end seal intersections in four places.
8. Install the manifold. Torque to specifications.

NOTE: CHECK END SEAL GAP BETWEEN THE MANIFOLD AND BLOCK. END STRIP SHOULD BE COMPRESSED 15%-60%.

D IMPORTANT PREPARATIONS FOR ROTATING SHAFT SEALS

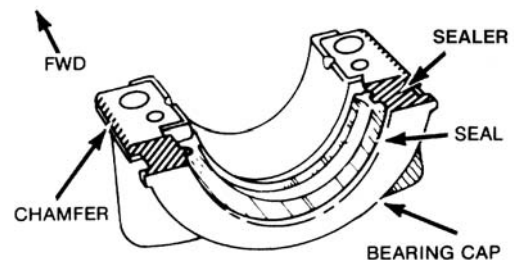
Wipe a thin film of lubricant on sealing lip and on shaft before installation.

NEVER INSTALL ANY SEAL WITHOUT BREAK-IN LUBRICANT PROTECTION.

E REAR MAIN BEARING SEAL

1. Clean all foreign material from cylinder block, bearing cap, and crankshaft.

NOTE: CHECK CRANKSHAFT SEALING SURFACE FOR NICKS AND SCRATCHES AND REMOVE WITH CROCUS CLOTH BEFORE INSTALLING SEAL.



2. Apply a thin coat of sealer on the bearing cap mating surface immediately adjacent to the seal, and to the chamfer as shown.

CAUTION: KEEP SEALANT AWAY FROM SEAL MATING ENDS AND MAIN BEARINGS.

3. Place the rear main bearing cap in position and install the cap bolts. Torque to specs.
4. After seal is installed, rotate crankshaft slowly at least 15 to 20 turns to insure proper seating of seal against crankshaft.

F OIL PAN GASKET

1. Clean pan gasket surface. Remove excess oil with a degreasing agent.
2. Straighten the pan flanges. Severely distorted pans should be replaced.
3. Apply a fast drying adhesive to end seals at several places and install into proper cavity.
4. Install oil pan side rail gaskets using fast drying adhesive. Allow ample time for adhesive to dry prior to assembly.
5. Apply 1/8" bead of silicone rubber sealant at the four connecting joints of the side rails and end seals.
6. Install oil pan to crankcase, avoid over-torquing.



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IMPORTANT: Install the manifold gaskets with the blue beads facing up towards the manifold.

3. Carefully place the manifold onto the gaskets. Snug down several bolts and allow the adhesive to dry thoroughly.
4. Remove the manifold and using a sharp cutting tool, trim the gasket port to match the head ports.

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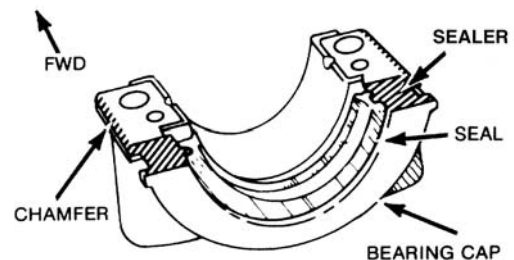
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