INTAKE AND EXHAUST MANIFOLD GASKETS

Upon disassembly, it is likely to find the absence of an exhaust manifold gasket since none was offered as original equipment. However, this set includes an exhaust manifold gasket to accomodate slight casting distortion or corrosion that may have occurred over the engine's service life. Therefore, we recommend that the included exhaust manifold gasket be installed by the following directions.

REMOVE MANIFOLDS from cylinder heads. IMPORTANT: You must disassemble the intake manifold from the exhaust manifold to allow for corrected realignment for the manifolds to the cylinder head during the reassembly.

REASSEMBLE MANIFOLDS. Install the intake-to-exhaust gasket between the intake and exhaust manifolds. Only finger tighten the manifolds together.

ATTACH AND ALIGN GASKET(S) TO CYLINDER HEAD(S). If gasket is steel faced on one side and fiber on the other, install steel faced side toward the manifold.

ATTACH AND ALIGN fiber faced intake manifold gasket over the intake/exhaust gasket.

REINSTALL INTAKE AND EXHAUST MANIFOLD ASSEMBLY to cylinder heads. Torque securely to OEM specifications.

Now torque the intake manifold exhaust connection to OEM specifications. Over-torquing can fracture the manifold or cause the bolts and studs to break.

EXHAUST PIPE FLANGE AND E.G.R. VALVE BOLTS

CLEAN ALL THREADS by using a wire brush for bolts and/or studs. Apply a high temperature anti-seize lubricant to the bolt and/or stud threads.

ATTACH AND ALIGN GASKET

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 sealing beads, install **DRY**.

FEL-PRO INSTALLATION TIPS

GENERAL INSTRUCTIONS

CLEAN MATING SURFACES of all foreign material**.** Use a degreaser.

CLEAN THREADS of bolts/studs using a wire brush; all nuts/threaded holes use a bottoming tap.

Determine Which Bolts extend into the coolant passages. Those **entering** the coolant passages require a pliable non-hardening sealer on the bolt threads and the underside of bolt head. Those **not entering** the coolant passages require oil on the bolt threads and underside of the bolt head.

Exhaust Assembly: Apply a high temperature anti-seize lubricant to the threadings.

CHECK ALL CASTINGS for flatness; straighten, resurface or replace if out of flat conditions exists.

CYLINDER HEAD AND BLOCK: refer to OEM manual to determine flatness tolerances and resurfacing limitations.

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. **Metal Faced Gasket(s)** require a thin even coat of sealer, to be applied to the metal side(s) of the gasket.

FINAL ASSEMBLY always requires torquing of fasteners according to OEM specifications. For certain assemblies we have provided specific torquing specifications.

NOTE: CYLINDER HEAD torquing procedures are critical and therefore we recommend to double-check with OEM.

Some procedures may be repeated with additional specific information for your application.

VALVE STEM SEALS

INSERT VALVES INTO GUIDES of cylinder head assembly. Place assembly on a flat covered surface to prevent damage to valve heads and cylinder head gasket surface.

SUPPORT OR PROP UP EACH VALVE HEAD with a wood block or other resilient material prior to installing seals.

NYLON TYPE SEAL: Place directly on valve stem seal.

TAP SEAL DOWN gently using provided plastic tube placed over stem. Move seal down approximately halfway on stem. The seal will find its proper positiong on the stem once the engine starts.

VALVE COVER GASKET

Th valve cover gasket in this set replaces the molded rubber sealing bead gasket supplied by OEM.

CLEAN MATING SURFACES of all foreign material including old gaskets, RTV and oil. You may wish to use a degreaser. Also, clean oil return holes.

I**MPORTANT:** If valve cover flange has a molded rubber sealing bead use a sharp blade to remove the raised section of the bead flush to the flange surface.

ATTACH AND ALIGN GASKET. Apply 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.

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