



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.

TIMING COVER SEALS

This set contains 2 timing cover seals. Identify and install as indicated.

1979 and later engines - use seal with flange.

1978 and earlier engines - use seal without flange.

SEAL WITH FLANGE is properly installed from the outside of the timing cover with metal flange bottomed against the face of the timing cover.

SEAL WITHOUT FLANGE is properly installed from the inside of the timing cover with rubber face bottomed into the counterbored hole of the timing cover.

FLYWHEEL BOLTS

REINSTALL FLYWHEEL to crankshaft. Note: On some engines that use a one-piece rear main bearing seal, a condition may exist where the bolt holes in the crankshaft rear flange have been drilled too deep by the manufacturer. This can result in oil seepage which may be misdiagnosed as coming from the oil pan or rear main bearing seal. To prevent seepage, coat bolt threads with thread locking sealer. Torque securely to OEM specifications.

- Continued on reverse side -



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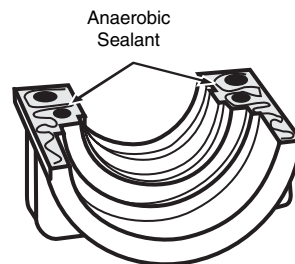
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REAR MAIN BEARING SEAL

CLEAN MATING SURFACES (cap, block and grooves of cap and block). You may wish to use a degreaser.

Check cap and block for steel pins. If steel pins exist in the casting grooves remove pins before installing molded rubber seals (presence of pins indicate prior installation of rope type seals).



PRIOR TO INSTALLING THE REAR MAIN BEARING CAP apply an anaerobic sealant to either the rear main bearing cap or cylinder block mating surfaces. **Never** apply sealant on the ends of the seals.

REINSTALL CAP TO CYLINDER BLOCK. Torque to OEM specifications.

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.

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.

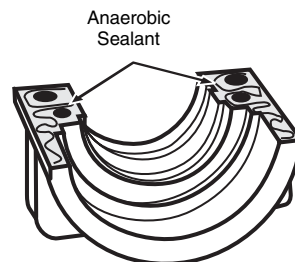
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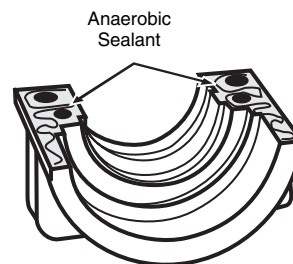
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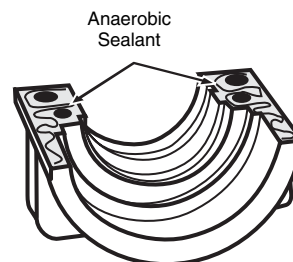
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