

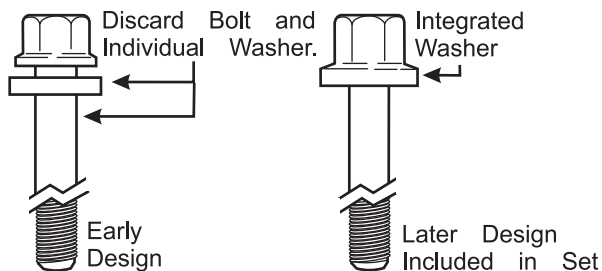


FEL-PRO INSTALLATION TIPS

HEAD GASKET

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.

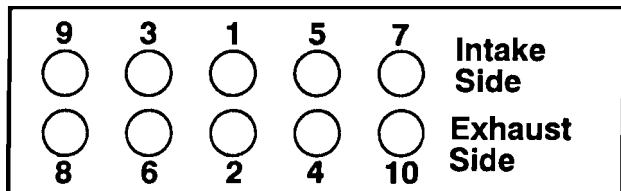


CYLINDER HEAD BOLTS: Install NEW cylinder head bolts every time the cylinder head is removed and replaced.

IMPORTANT: DO NOT reuse cylinder head bolts under any circumstances.

Previously installed bolts have been "STRETCHED" beyond their reusable limit and will no longer provide the required clamping force.

If flat washers are present, discard them and install integrated washer style head bolts. **DO NOT INSTALL ANY WASHERS.**



TORQUE SPECIFICATIONS: Following sequence shown in illustration, torque the NEW bolts in the following steps:

Torque all bolts to 44 ft. lbs.

Following the same torquing sequence, turn bolts 90° (1/4 turn).

To complete the tightening procedure the bolts must be turned in sequence again, 90° (1/4 turn).

IMPORTANT: Consult the latest OEM torque specifications as changes may have taken place since this printing.

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. **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



To effectively seal this sophisticated engine application, FEL-PRO has included PERMA-DRY® molded rubber gasket(s) in this set.

ATTACH AND ALIGN GASKET.

IMPORTANT: This molded rubber silicone gasket must be installed **DRY** without any chemical adhesive.

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 quick-drying adhesive sparingly. **PRIOR TO INSTALLING INTAKE MANIFOLD** apply a dab of RTV silicone sealer where all gaskets and seal meet.

INLINE ENGINES: Attach and align gaskets to cylinder heads.

IMPORTANT: WHEN INSTALLING STEEL SHIM GASKET(S): Apply sealer around intake ports on both sides. If gasket(s) have water ports, apply a 1/8" continuous bead of RTV silicone sealer around each water port on both sides. While RTV is wet, install intake manifold.

EXHAUST MANIFOLD GASKET

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

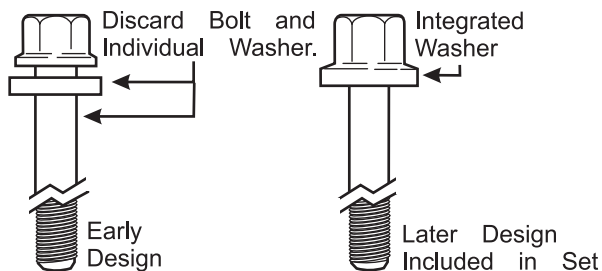


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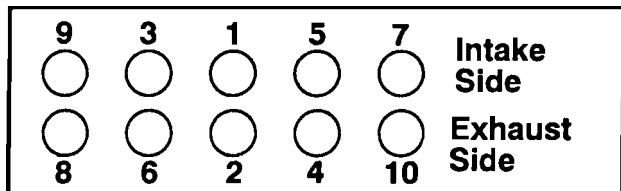


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