ACCU-SEAL PRO™

– PREMIUM INTAKE GASKETS –

Figure 1

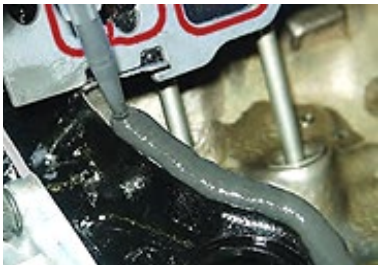

Figure 2

Installation Instructions

Steps:

1. Before installing the gaskets perform a visual check to ensure that no damage occurred during shipping.

2. Good engine building practice requires clean sealing surfaces. If the engine does not have a separate valley cover, place clean shop towels in the lifter valley to catch debris from cleaning. Prevent debris from falling down the ports by placing a wadded paper towel just inside each port. When surface cleaning is finished you will pull the debris out with the paper towel. Run a tap down all manifold bolt holes & clear debris. Being careful not to gouge the surfaces, scrape all gasket residue and sealant from the cylinder heads. If your engine does not have a separate valley cover, carefully clean the front & rear manifold sealing surfaces (sometimes called China Walls). Use a solvent degreaser to remove all oil residue.

3. Paying special attention to the front & rear manifold end sealing areas, clean all sealing surfaces of the intake manifold in the same manner as the cylinder heads.

4. Apply an even coat of Gasgacinch (SCE p/n G1614) on one-cylinder head sealing surface. Immediately apply an even coat of Gasgacinch on the cylinder head side (opposite red bead seals) of one intake gasket. Position the gasket on the head so it is aligned properly with the intake ports
(SEE FIGURE 1) & apply even pressure to the gasket affixing it in the aligned position. Do not apply sealant to the manifold side (with red bead seals) of the intake gasket. Repeat this procedure for the opposite intake gasket.

5. If your engine has a separate valley cover the intake manifold can now be installed. according to step 6. If your engine does not have a separate valley cover SCE recommends sealing the China Walls with High Temp RTV silicone (SCE p/n G1613). On the ***clean*** China Walls place a heavy bead of silicone. The objective is to create a thick bead about 1/4" to 3/8" high, properly done it will resemble a caterpillar (SEE FIGURE 2) on the front & back walls that will also adhere to the ***clean*** underside of the intake manifold.

6. Place the intake manifold in position. Using clean (or new) manifold bolts, finger tighten each bolt. Torque the intake manifold bolts to manufacturer recommendation (most often 25 -30-foot pounds) using an inside-out, criss-cross sequence. Allow the engine to sit for at least 2 hours so the silicone end seals will cure properly.