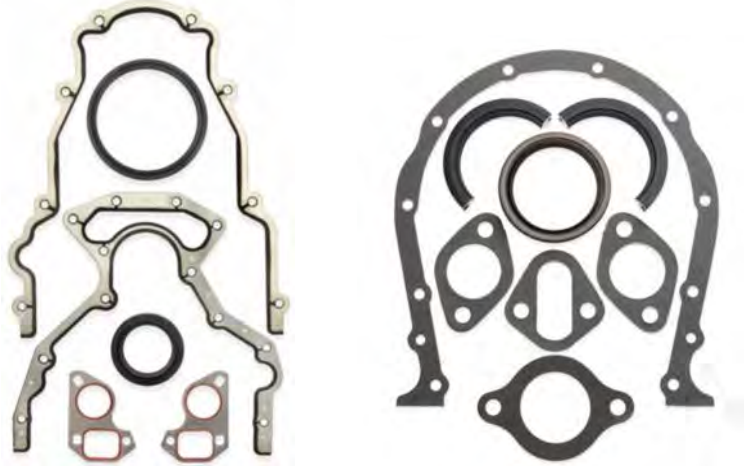




SBBK

SHORT BLOCK BASE KITS



Installation Instructions

Note: Provides remaining gaskets and seals common to the engine type, regardless of customization

Steps:

1. Thoroughly clean and degrease component mating surfaces.
2. Install rear main seal:
 - Lubricate sealing lip area with clean engine oil.
 - Install block-side split seal with undercut of seal lip facing inward (on oil side of engine block).
 - Install crankshaft.
 - Install main-cap split seal or one-piece rear seal. Some engines require rear main bearing cap to block seals, be sure they are fully seated (it may be necessary to move rear main cap in a slight up and down motion while inserting side cap seals).
 - Install remaining main caps in their original location and orientation. Tighten main cap bolts to factory torque specification.
3. Install timing cover oil seal in timing cover, lubricate sealing lip.
4. Apply Gasgacinch (SCE p/n G1616) on block to hold timing cover gasket in place, affix timing cover gasket over dowels and apply Gasgacinch to gasket. Install timing cover and bolts.
5. Install oil pan. To install 4-piece pan gaskets, apply Gasgacinch to both sides of pan rail gaskets and front/rear end seals. To install 1-piece pan gasket, use only a small dab of silicone (both sides of gasket) at the four corners (interface of Timing Cover/pan and Rear Main cap/pan)
6. Install water pump gasket(s) onto water pump using Gasgacinch gasket sealer. Install water pump.
7. Install water outlet gasket onto water outlet using Gasgacinch gasket sealer. Install water outlet onto intake manifold.