

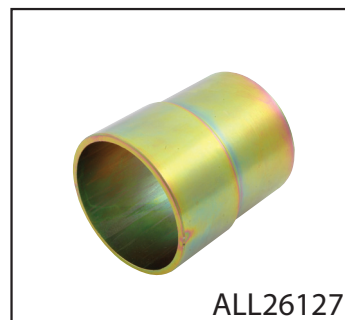


Rear Main Seal Adapter

INSTALLATION INSTRUCTIONS

Follow These Steps:

1. Inspect mounting surface on rear of block. Occasionally, the factory does not finish machining the area above the two upper mounting holes. If this is the case, use a file or deburring tool to smooth this area.
2. Install small diameter of alignment tool ALL26127 into rear main bearing housing bore without a bearing. The larger diameter end of the installation tool will protrude from the rear of the casting to properly center adapter. Install the rear main bearing cap and torque main bearing bolts to 50lb/ft.
3. Apply a light amount of oil on the protruding end of tool.
4. Apply a light film of RTV sealer to block contact half of adapter. At this point assemble the two halves of seal holder and evenly tighten the retaining bolts so that the adapter will slide freely on the alignment tool without binding.
5. Gently push adapter against the block (CAUTION: DO NOT install O.E. alignment dowel in block.) making certain that there is no movement of ALL26127 tool as you do so. NOTE: There may be a small difference in length between the oil pan rail of the block casting and the seal holder; this is normal and will be taken up by the oil pan gasket and a small amount of RTV sealer. DO NOT ATTEMPT TO ALTER THE ALIGNMENT OF THE SEAL HOLDER FOR THIS REASON.
6. Install Loctite #262 or equivalent on all four mounting bolts. Install bolts in rear of block casting and torque to specifications in an appropriate sequential pattern.
7. Remove ALL26127 Installation Tool from rear main bearing journal by loosening rear main cap and sliding tool out the backside of adapter plate.
8. Remove two recessed socket head cap screws holding two halves of adapter plate together to install both halves of rear main seal.



Due to irregularities in block and oil pans this adapter is not designed to use the original style rubber rear oil pan seal. Apply a generous amount of RTV sealant to the trough of the adapter plate in place of the rear pan seal for proper sealing. Note: Make sure sealing areas are clean and free of oil before installation.

Without the use of ALL26127 Alignment Tool or the appropriate use of a dial indicator to verify alignment of the seal holder with the center line of the crankshaft, severe leaks and engine failure may occur.

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