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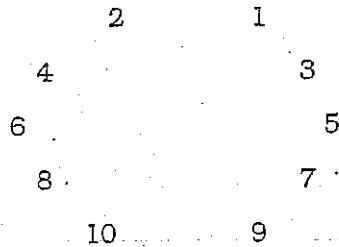
INSTALLATION FOR SMALL BLOCK CHEVROLET  
ENGINE AND ACCESSORY FASTENER KITS  
Pad No.: 534-9501, 534-9601, 534-9701, 534-9801

[1] Front Cover:

10 pieces 1/4-20 .515 bolts  
10 pieces 1/4" washers

**Preparation:** Make sure that block surface is clean and dry where gasket is to be placed and that bolt threads are clean and free of debris. Use a 1/4-20 tap if necessary.

**Installation:** Apply a sparing amount of silicone or gasket sealer to adequately cover the gasket surface of the block, then carefully place the gasket in position. Lubricate the bolt threads, under the head and the washer with either a 30wt motor oil or ARP Moly Assembly Lubricant. Position cover so that dowels in block enter holes in cover without binding. Do not force cover over dowels so that cover flange or holes are distorted. While holding cover, install and snug tight bolts in an alternating manner. Torque bolts to 15 ft. lbs. (motor oil) or 9 ft. lbs. (ARP Lube) in sequence shown below:



[2] Oil Pan:

14 pieces 1/4-20 x .515 bolts w/ washers  
4 pieces 5/16-18 x .560 bolts w/ washers

**Preparation:** Make sure that block is clean and dry where the gasket is to be placed and that bolt holes are clean and free of debris. Use a tap if necessary.

**Installation:** Apply a sparing amount of silicone or gasket sealer to adequately cover the gasket surface of the block and carefully position the gasket. Position the front and rear oil pan seals and place a blot of silicone approximately 5/16" diameter where the seals meet the gasket. Carefully place the oil pan in position. Lubricate the bolt threads under the head and the washer with a 30wt. motor oil or ARP Moly Lube. Torque the 1/4" bolts to 15 ft. lbs. (motor oil) or 9 ft. lbs. (ARP Lube) and the 5/16" bolts to 25 ft. lbs. (motor oil) or 19 ft. lbs. (ARP Lube) using the torque sequence shown below. NOTE: bolts 15-16-17-18 are 5/16".

11	7	3	1	4	8	12	17
16							
15							18
14	10	6	2	5	9	13	

[3] Fuel Pump:

2 pieces 1/4-20 x .515 bolts w/ washers  
2 pieces 3/8-16 x 1.250 bolts w/ washers

**Preparation:** Make sure fuel pump and cylinder block are clean and dry where the gasket is to be placed and that holes are clean and free of debris. Use a tap if necessary.

**Installation:** Apply a sparing amount of silicone or gasket sealer to adequately cover the gasket surface of the block and carefully place the gasket in position. Lubricate the bolt threads, under the head and washers with a 30wt motor oil or ARP Moly Assembly Lubricant. Insert the fuel pump push rod and locate the fuel pump in proper position. While holding the fuel pump, insert the 3/8" bolts and snug tighten bolts in an alternating and even manner till pump is almost flush with block. Insert 1/4" bolts and snug. Snug 3/8" bolts. Torque 1/4" bolts to 15 ft. lbs. (motor oil) or 9 ft. lbs. (ARP Lube) and 3/8" bolts to 40 ft. lbs. (motor oil) or 33 ft. lbs. (ARP Lube).

[4] Motor Mounts:

6 pieces 3/8-16 x .750 bolt w/ washers

**Preparation:** Make sure bolt holes are clean and free of debris. Use a tap if necessary.

**Installation:** Lubricate the bolt threads, under the head and the washers with a 30wt motor oil or ARP Moly Assembly Lubricant. Position the motor mount. Insert the bolts and snug. Torque bolts to 40 ft. lbs. (motor oil) or 33 ft. lbs. (ARP Lube).

[5] Intake Manifold:

12 pieces 3/8-16 x 1.000 bolts w/ washers

**Preparation:** Make sure cylinder head surface is clean and dry where the gasket is to be placed and that bolt holes are clean and free of debris. Use a 3/8-16 tap if necessary. Clean block surface where rubber manifold seals are to be placed.

**Installation:** Apply a sparing amount of silicone or gasket sealer to adequately cover manifold gasket surface of the cylinder heads and carefully place the gaskets. If rubber manifold end seals are preferred, put them in place or run a bead of silicone along the block approx. 1/4" diameter (the rubber end seals have a tendency to push out). Carefully place the manifold in position. Lubricate the bolt threads, under the head and the washers with a 30wt. motor oil or ARP Moly Assembly Lubricant. Run the bolts in an alternating manner. Torque all the bolts to 25 ft. lbs. (motor oil) or 19 ft. lbs. (ARP Lube) using the sequence shown below. Then torque the bolts to the final torque of 40 ft. lbs. (motor oil) or 33 ft. lbs. (ARP Lube) using the same sequence.

