

INSTRUCTIONS

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910-27003 - LS to Muncie/TKO Bellhousing

Kit Contents		
Qty	Part #	Description
1	910-27003.1	Bellhousing
1	910-27003.2	Cover Plate
1	910-27003.3	Hardware Kit

Speedway Motors safety bellhousings are manufactured in the USA. Not vehicle specific, they are designed to adapt specific engines to specific transmissions and may require minor work to fit your application.

USE CAUTION WHEN WORKING UNDERNEATH THE VEHICLE.

Do not work near or get underneath the vehicle until you are confident that it is safely secured and will not move or fall from its raised position. **DO NOT USE A BUMPER JACK.**

Speedway Motors bellhousings are designed to be used with factory OE starters or equivalent. Small compact high torque mini starters will work with all Speedway Motors bellhousings.

Always check fitment before final installation. It is recommended to check fit the transmission into the bellhousing before mounting it to the engine.

RETAIN THIS INSTRUCTION SHEET FOR FUTURE REFERENCE.

PREPARING FOR INSTALLATION:

1. Your vehicle must be on a solid, level surface to guarantee safe installation.
2. Raise vehicle using proper lifting device and support it using automotive approved support stands having adequate load capacity.

**DO NOT INITIATE INSTALLATION UNTIL YOU ARE CONFIDENT THAT
THE VEHICLE IS SECURE AND SAFELY SUPPORTED!**

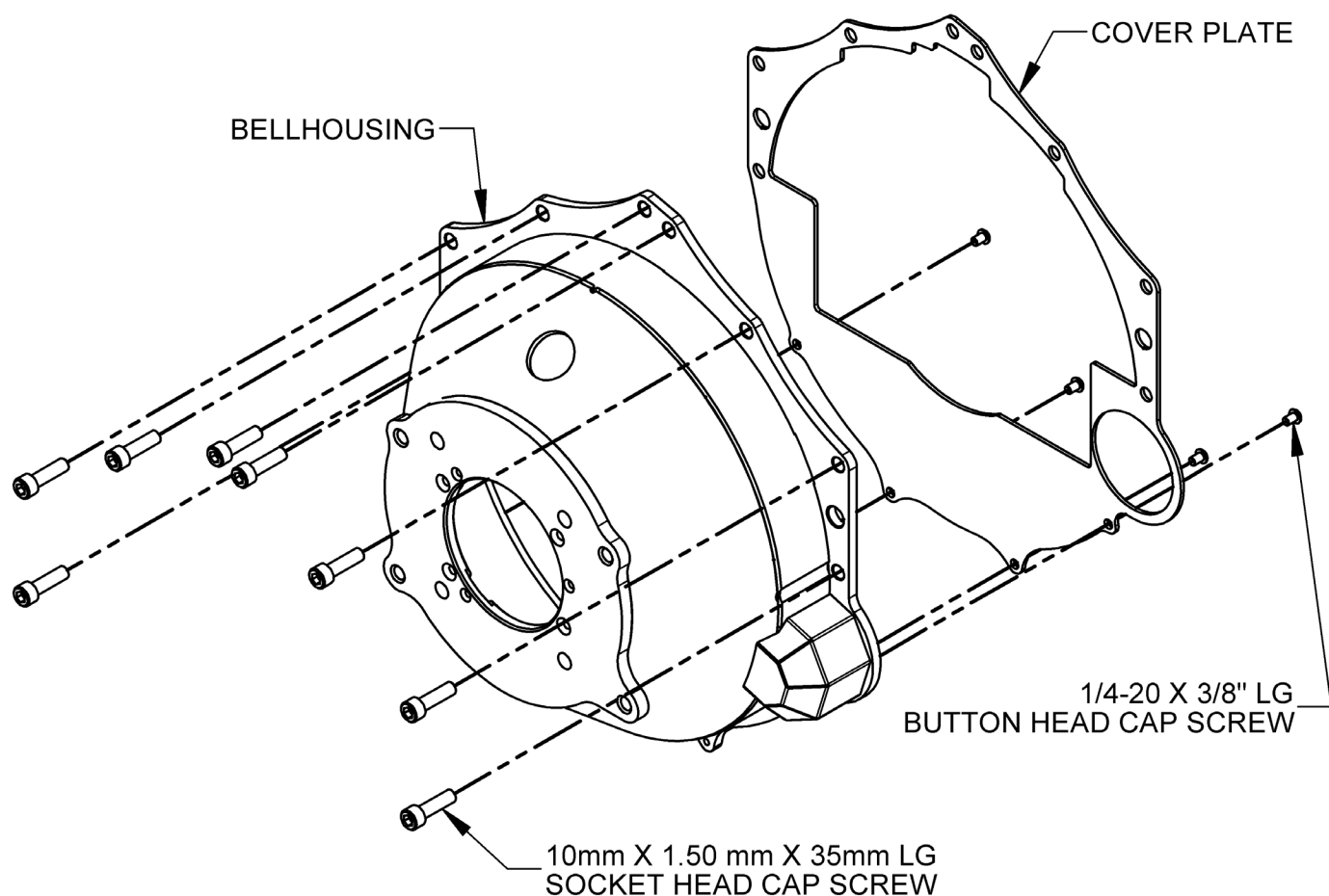
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INSTALLATION:

1. Verify proper fitment with the transmission before starting the install.
2. Disconnect the negative (-) cable from the battery. Raise the vehicle and support it with jack stands or a lift. Make certain the vehicle is safely supported and will not fall from its lifted position.
3. Remove the driveshaft, starter, transmission and bellhousing.
4. Remove the clutch assembly from the flywheel.
5. Check the bellhousing alignment with the crank shaft. (See bellhousing alignment guide included with these instructions)
6. After verifying proper bellhousing alignment remove the flywheel and install the cover plate onto the engine block dowels.
7. Install the flywheel and clutch assembly. Torque the bolts to the recommended specification from the manufacturer.
8. Slide the bellhousings onto the dowel pins of the engine block.
9. Loosely attach the bellhousing to the block using the supplied bolts.
10. Attach the cover plate to the bellhousing using the supplied bolts.
11. Torque the bellhousing bolts to the engine block to 40 ft/lbs.
12. Reinstall the starter, transmission, and driveshaft.
13. Lower the vehicle and reconnect the battery.



BELLHOUSING ALIGNMENT GUIDE:

Having a bellhousing not installed concentric with the crank shaft can cause several issues. You may experience difficulty shifting, accelerated bearing wear, and excessive noise. The relationship of the engine block dowels pins and the crankshaft centerline may be misaligned due to manufacturing tolerances. Whenever a bellhousing is installed, you should check if the register bore is within acceptable alignment.

1. You will need a dial indicator for checking alignment. It is best to use an indicator with a magnetic base.
2. Inspect all components and ensure the mating surfaces are clean and there are no nicks, burrs or excessive paint build up.
3. Remove the clutch assembly from the flywheel.
4. Attach dial indicator to your engine or oil pan perpendicular to the fly wheel surface.
5. Adjust the plunger and zero out your indicator. Mark the starting point.
6. Rotate the engine by hand 360 degrees and verify the plunger stays in contact the entire rotation.
7. Rotate the engine a few revolutions and note any high readings. If you have more than .005" total indicator reading than you may have a warped or damaged flywheel.
8. If your flywheel is within spec, then continue with bellhousing alignment.
9. Install the indicator on the flywheel.
10. Adjust plunger and zero out the indicator against the bellhousing register bore. Verify the plunger stays in contact the entire rotation.
11. Rotate the engine a few revolutions and note any high readings. Misalignment is half of the total indicator reading. Offset dowels will need to installed if misalignment is over .005".
12. Mark the direction of the misalignment.
13. Select the offset dowel pin that is closest to half of your total indicator reading. (See chart)

1/2 of the Total Indicator Reading	Size of the Offset Dowel
.006" - .010"	.007"
.011" - .017"	.014"
.018" - .026"	.021"

14. Remove the stock dowel pins from the engine block.
15. The offset dowels should be installed in pairs and parallel to each other. Lubricate the dowels and press them into the engine block.
16. Recheck the register bore runout and make adjustments until the alignment is within spec.

IMPORTANT

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DAMAGE CLAIMS Please inspect all packages upon delivery and in the presence of the delivery driver when possible. The driver must note any visible damage and provide procedures for handling damage claims. To allow for a claims process, please retain original box, packing material and damaged merchandise. Contact Speedway Motors for instructions regarding damage claim within 5 days of receipt. Speedway Motors assumes no liability after this period.

SHORTAGES Please check the contents of your delivery to ensure that all parts ordered are received. Refer to your invoice to cross check all items received and inspect all packing materials for contents of small items. Retain original shipping box and packing materials. Orders may be split into multiple boxes which can be delivered on different days. Contact Speedway Motors for instructions regarding shortage claim within 5 days of receipt. Speedway Motors assumes no liability after this 5 day period.

REFUSALS All refused packages will be billed the freight to and from the destination and refused COD orders will be billed a 15% restocking charge plus freight to and from destination.

WARRANTY CLAIMS If the item is used or installed and a warranty claim request is submitted, warranty work is done by the manufacturer and may take up to 30 days for processing. Speedway Motors will be required to follow the manufacturer's warranty instructions to allow for a credit refund or exchange when specified.

RETURNS We want you to be satisfied with your purchase. If you are not satisfied, you may return your new, unused item within 60 days for refund or exchange.

All exchanged or returned merchandise must be in original factory condition with no modifications or alterations. Returned merchandise must include original packaging materials, warranty cards, manuals, instructions, etc. If the returned item requires repackaging, your refund / exchange will be subject to a repackaging charge. Return/Exchange transactions less than \$99 are excluded from the free shipping offer.

HOW TO RETURN AN ITEM Please re-pack the item in a sturdy box, include a copy of your invoice and completed return form. Returns must be shipped prepaid. CODs are not accepted. Shipping costs for exchanged merchandise will be charged to your credit card.

Items that are returned after 60 days are subject to a 15% restocking charges. Fiberglass items returned will be subject to a 15% restocking charge. We are unable to accept returns on electrical parts, video tapes, DVD's, books, special order or closeout merchandise.

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EXHAUST INSTALLATION ALERT Exhaust systems and other component surface finishes are not permanent. Coatings, paint and other factory supplied cosmetic treatments are only intended to protect from surface corrosion in an unused state. No returns are allowed after the parts have been installed. Header flanges must be clean and clear of paint and surface contaminants prior to mating to exhaust gaskets. Exhaust fasteners must be re-torqued after the initial heat cycle and regularly thereafter to ensure a proper gasket seal is maintained. Should you decide to install this exhaust product at your home, be warned that pleasure car or light duty truck/van "bumper" jacks are intended for emergency use only. The use of frame contact jack stands in conjunction with a floor jack as a main support is highly recommended to minimize accidental dropping of a vehicle while the installation proceeds. We recommend the use of a shop hoist if possible. Please use caution! Speedway Motors, Inc. makes no warranties either expressed or implied including any warranty of merchantability or fitness for a particular purpose, other than those contain in its current catalog or website with respect to the goods identified on the face of the invoice. There is no warranty expressed or implied as to whether the goods sold hereby will protect the purchaser or ultimate user of such goods from injury or death.

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