



REAR MAIN SEAL ADAPTER P/N 38315

PARTS LIST:

1	Seal Adapter Assembly	2	5/16-18 x 1-1/2" Cap Screws (Already installed in Adapter)
2	1/4-20 x 1 5/8" Cap Screws	2	Alignment Bushings (Already installed in Adapter)
2	1/4-20 x 3/4" Cap Screws	4	Lock Washers
2	5/16-18 x 1.6 Stud	1	Rear Main Seal Housing Gasket

INSTALLATION:

This Rear Main Seal Adapter is designed to install an early crankshaft into a Small Block Chevy Engine Block with one-piece rear main seal using an oil pan for a one-piece engine block.

The mounting surface of the engine block should be flat and defect free. The factory does not always finish machine the area above the two upper mounting holes. It may be necessary to clean up this area with a de-burring tool. NOTE: in most cases, a misalignment of up to .015" will seal properly. If it is necessary to indicate the Adapter, you may have to remove the alignment bushing, turn down the O.D. of the alignment bushing and reinstall to gain movement in the block.

Loosen the (2) 5/16-18 x 1-1/2" Cap Screws that are already installed in the Adapter, which attach the upper and lower halves of the Adapter together. Use supplied Rear Main Seal Housing Gasket between the Rear Main Seal Adapter and the engine block. Install the rear main seal, we recommend using FEL PRO Part #BS11829 Rear Seal. Attach the upper half of the Adapter to the engine block using the two 1/4-20 x 3/4" Cap Screws and the lower half of the Adapter to the engine block using the two 1/4-20 x 1 5/8" Cap Screws. Hand-tighten these Cap Screws at this time. Use a small amount of silicone sealant where the rear main seal surfaces will meet. Attach the bottom half of the Adapter to the top of the Adapter using the removed 5/16-18 x 1 1/2" Cap Screws and torque to 24 ft.lbs. Torque the four 1/4-20 Cap Screws holding the Adapter to 10-12 ft.lbs.

This Adapter is designed for use with MOROSO Part #93151 One Piece Oil Pan Gasket. If you are using a four-piece oil pan gasket you might need to remove the knobs. To prevent a possible leak, apply a small amount of silicone sealant at the corners where the seal meets the Adapter. After the oil pan is installed, torque the nuts to 10-12 ft.lbs.