

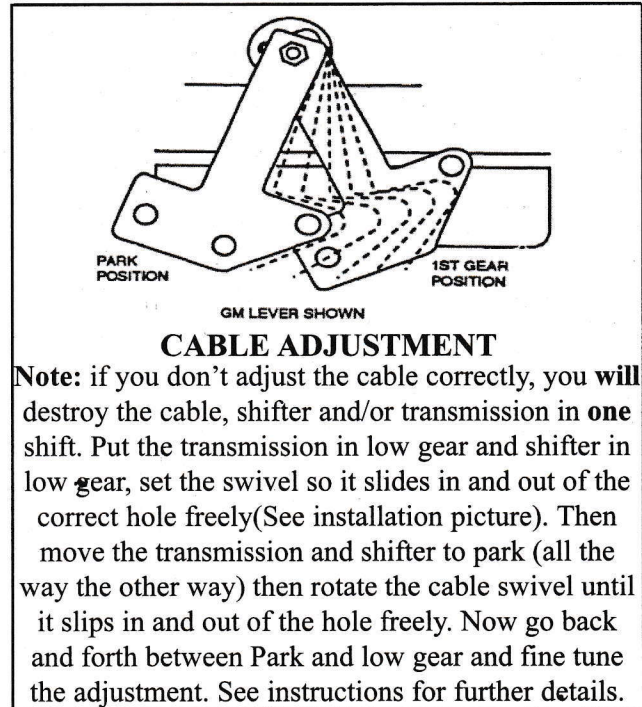
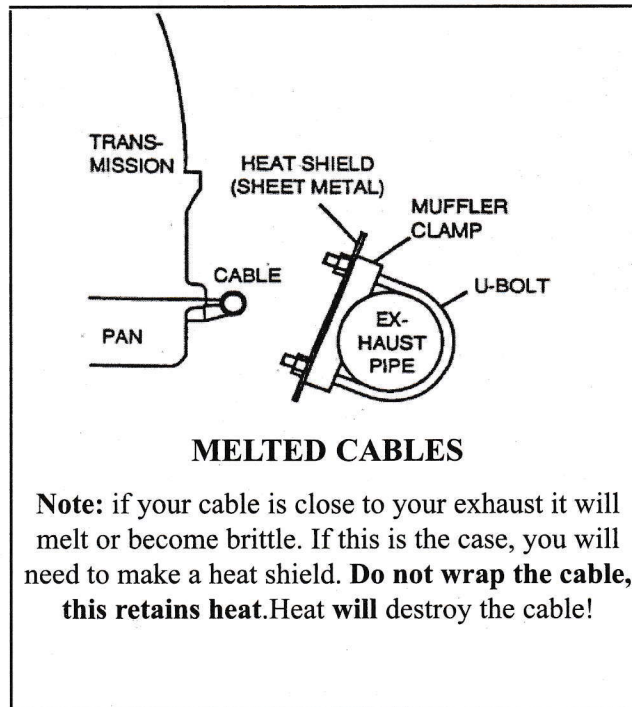
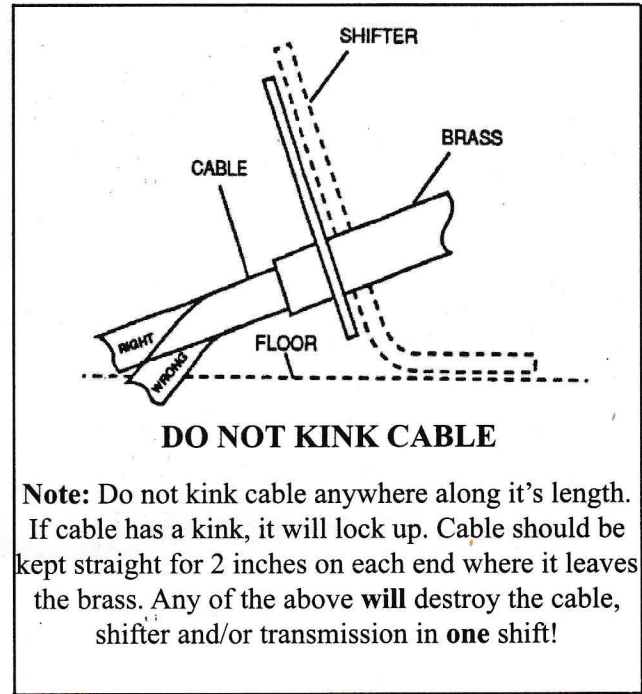
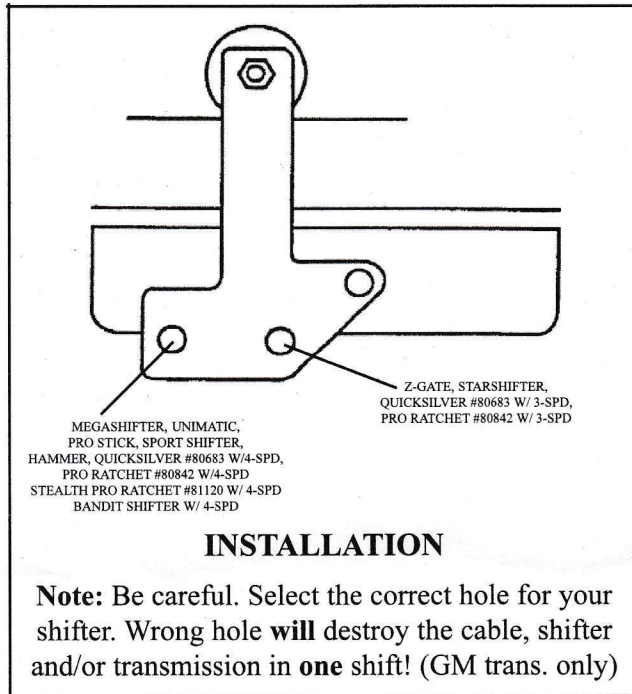


Cable Adjustment Warning

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GM TH-200, TH-350, TH-400, TH-200-4R

TH-700-R4, 4L60, 4L60-E, 4L65-E, 4L80-E & 4L85-E
lever shown.



E REAR MAIN BEARING SEAL

NOTE: BOTH UPPER AND LOWER HALVES MUST BE INSTALLED AS A PAIR.

1. Clean all foreign material from cylinder block, bearing cap, and crankshaft.

NOTE: CHECK CRANKSHAFT SEALING SURFACE FOR NICKS AND SCRATCHES AND REMOVE WITH CROCUS CLOTH BEFORE INSTALLING SEAL.

2. Lubricate new seal lips and back seal bead with light engine oil. Do not lubricate seal mating ends.

NOTE: MAKE SURE LIP SIDE (side with groove) IS TOWARD FRONT OF ENGINE.

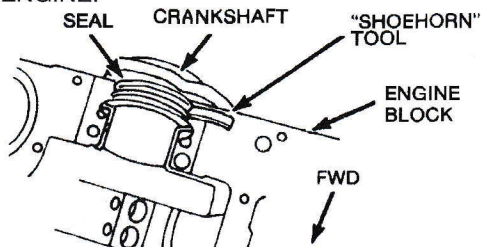


FIGURE #1

3. IF CRANKSHAFT IS OUT OF BLOCK, install one seal half in the cylinder block using the "shoehorn" installation aid provided to protect the back sealing bead from the sharp edge of the cylinder block locating flange. (See Figure 1). Press seal half into groove in block by thumb pressure. Seal ends must be flush with face of casting.
4. IF CRANKSHAFT IS IN BLOCK, remove old seals with needle nose pliers. Assist by rotating shaft. To install new upper seal, position "shoehorn" installation aid as in Figure 1 and push the seal around the crankshaft utilizing finger pressure or a blunt instrument to prevent damage to the seal. The "shoehorn" installation aid must remain in position until the seal is properly positioned with both seal ends flush with the engine block.
5. Remove the "shoehorn" installation aid.

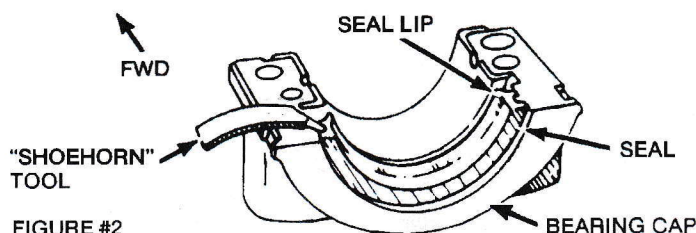


FIGURE #2

6. Install seal half in bearing cap again using the "shoehorn" installation aid to protect the back sealing bead as you feed the seal into the cap using light thumb and finger pressure (See Figure 2).

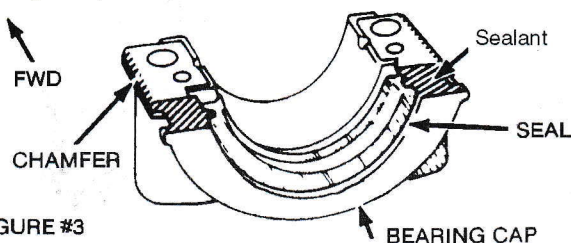


FIGURE #3

7. Apply a thin coat on the bearing cap mating surface immediately adjacent to the seal, and to the chamfer as shown (Figure 3).

CAUTION: KEEP SEALANT AWAY FROM SEAL MATING ENDS.

8. Place the rear main bearing cap in position and install the cap bolts finger tight.

NOTE: THE REAR MAIN BEARING CAP MUST BE POSITIONED BEFORE THE CAP IS TORQUED TO SPECS.

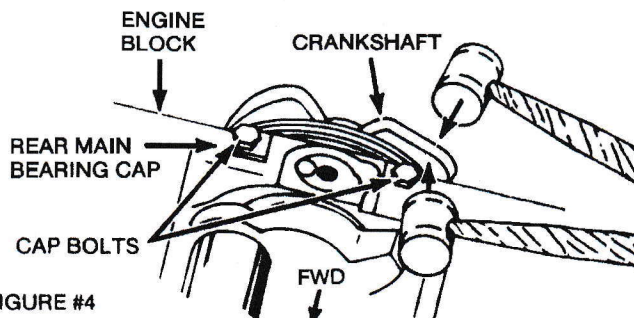


FIGURE #4

9. Initially torque the cap bolts to 10/12 ft. lbs. Tap the crankshaft first rearward and then forward with a lead hammer and leave in forward position (See Figure 4). Torque cap bolts to specs.
10. After seal is installed, rotate crankshaft slowly at least 15 to 20 turns to insure proper sealing of seal lip against crankshaft.

F IMPORTANT PREPARATIONS FOR ROTATING SHAFT SEALS

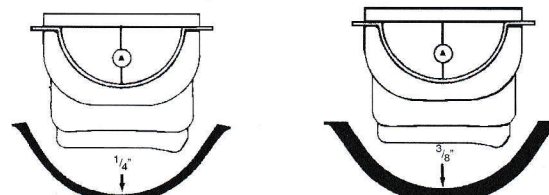
Wipe a thin film of lubricant on sealing lip and on shaft before installation.

NEVER INSTALL ANY SEAL WITHOUT BREAK-IN LUBRICANT PROTECTION.

G OIL PAN GASKETS

1. Clean pan gasket surface FREE of foreign particles. Wipe off excess oil with a degreasing agent.
2. Straighten the pan flanges. Severely distorted pans should be replaced.

NOTE: There are two pan front seals available.



Use 1/4" Thick seal on oil pans having "A" dimension of 2 1/4"

Use 3/8" Thick seal on oil pans having "A" dimension of 2 3/8"

For proper installation, lay a straightedge across the flanges at the front of oil pan. Measure the distance from the lowest point of the end strip area to the bottom of the straightedge.

3. Apply a fast drying adhesive to end seals at several places and install into proper cavity.
4. Install oil pan side rail gaskets using fast drying adhesive. Allow ample time for adhesive to dry prior to assembly.
5. Apply 1/8" bead of silicone rubber sealant at the four connecting joints of the side rails and end seals.
6. Install oil pan to crankcase; avoid over-torquing.