

# INSTRUCTIONS

## 73 & Up A,B,F,M & J S6 to Small Block Conversion

**We strongly suggest that you purchase a Factory Service Manual for your car's year & model. This will be an invaluable tool for the success of your project.**

**Note:** *Your brackets should be marked L(left) and R(right). If not, the right hand bracket has 4 mounting holes, the left has only 3.*

**Installation:** Install bracket and insulator assembly to the engine as shown. Tighten fasteners finger-tight only, to allow greater adjustability in the leveling process, attaining the correct height, side-to-side clearance, etc. You will torque these fasteners to spec after this has been achieved.

Lower engine and install as per service manual onto K-member supports. (It may be helpful to secure the right hand side first, and then rock

the left into place.) Using a 4 ft. level across the valve covers, the engine can now be leveled within the engine compartment.

Please remember; your vehicle has to be on a level surface to get an accurate reading. To insure you have located the engine properly, it is helpful at this stage to install your transmission to the engine, and rear support cross member to the frame, as per your service manual. Your new transmission will mount in the same position as the one you took out.

Check your engine level and install washers & nuts to the thru bolts at the K-member

support. Tighten nuts to specified torque (65-75 lbs). Tighten bracket fasteners to specified torque (55 ft. lbs).

Every effort has been made to insure that the engine can be installed to factory specs while allowing adjustability to level the engine in its compartment. Due to sloppy tolerances from the factory when they built the K-member (no two K-members are exactly the same), there may be a few instances where it becomes difficult to level the engine or attain the correct height. If you find this to be the case, please call us at 206-364-7151 for technical assistance.

Your linkages, accessories and the rest of the drive train can now be installed as per your service manual.



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