

# REMOVAL/INSTALL INSTRUCTIONS: ENGINE REAR MAIN SEAL COVER

**ATTENTION:** Refer to the appropriate shop manual for your vehicle to obtain specific service procedures for this part. If you do not have a service manual or lack the skill to install this part, it is recommended that you seek the services of a qualified technician. Pay special attention to all cautions and warnings included in the shop manual. Read and follow all instructions carefully.

## REMOVAL/INSTALL OF ENGINE REAR MAIN SEAL COVER (635-518)

General Motors 2017–1997, Isuzu 2016–03, Saab 2009–05, Workhorse 2012–04

### General Tech Tips:

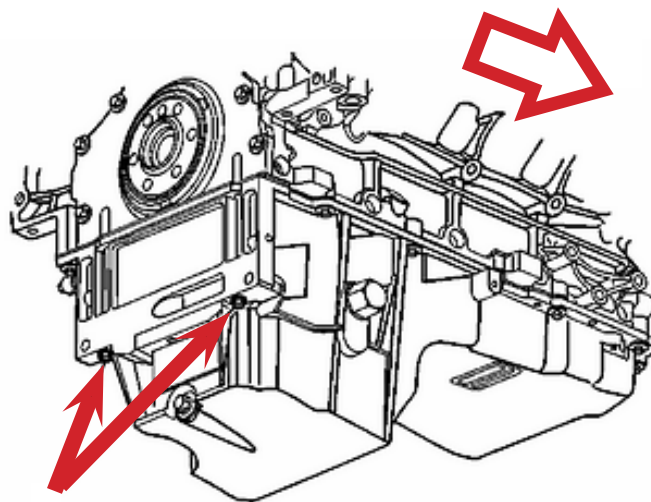
- Do not reuse the crankshaft oil seal or rear cover gasket.
- Do not apply any type of sealant to the rear cover gasket, unless specified.
- The special tool in this procedure is used to properly center the crankshaft rear oil seal.
- All gasket surfaces should be free of oil or other foreign material during assembly.
- The crankshaft rear oil seal **MUST** be centered in relation to the crankshaft.
- An improperly aligned rear cover may cause premature rear oil seal wear and/or engine assembly oil leaks.

**PLEASE WEAR  
SAFETY GLASSES!**

### Removal Instructions

**STEP 1:** Remove the automatic transmission flexplate.

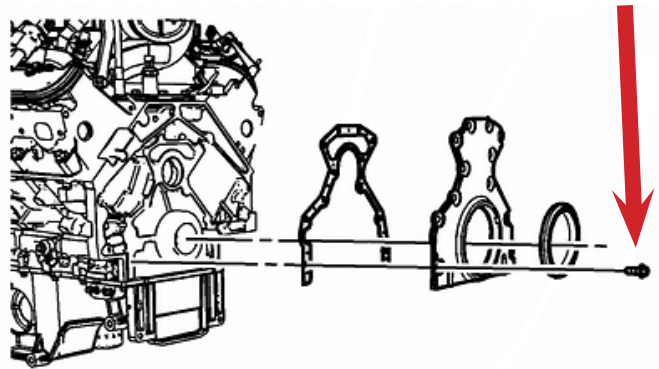
**STEP 2:** Remove the oil pan-to-rear oil seal housing bolts.



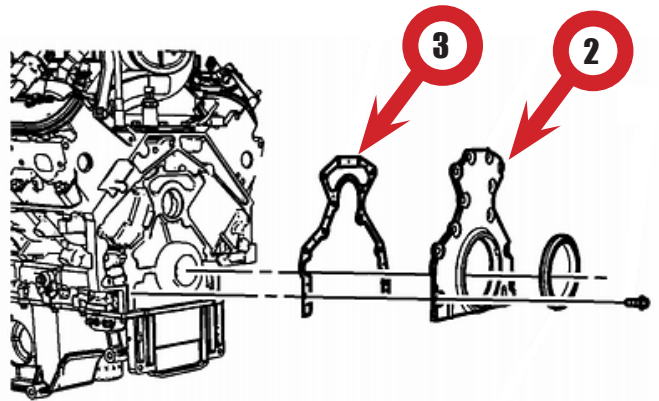
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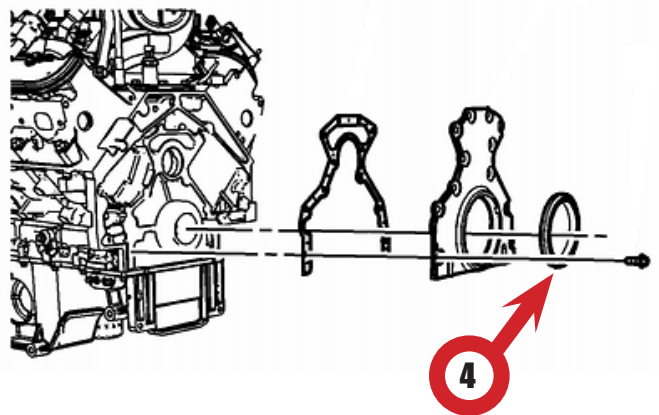
**STEP 3:** Remove the rear oil seal housing bolts.



**STEP 4:** Remove the rear oil seal housing (2) and gasket (3). Discard the gasket.



**STEP 5:** Remove and discard the rear oil seal.

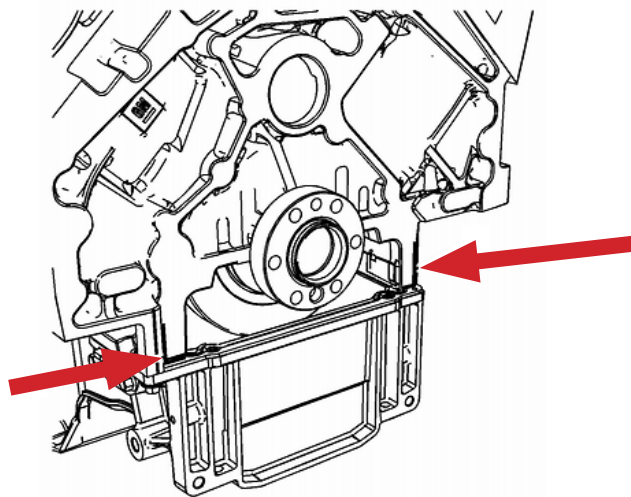


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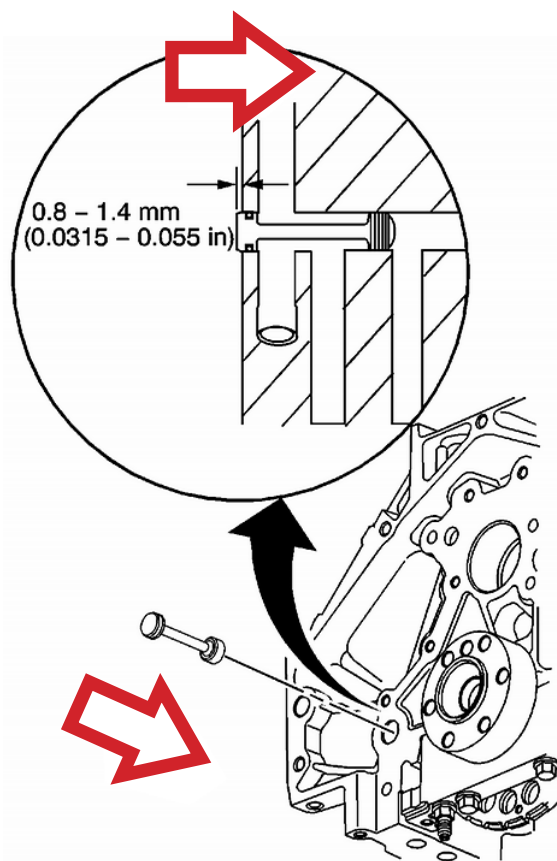
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## Installation Instructions

**STEP 1:** Apply a 5 mm (0.2 in) bead of sealant, 20 mm (0.8 in) to the 2 joints at the rear of the block/pan.



**STEP 2:** Inspect the rear oil gallery plug for proper installation.

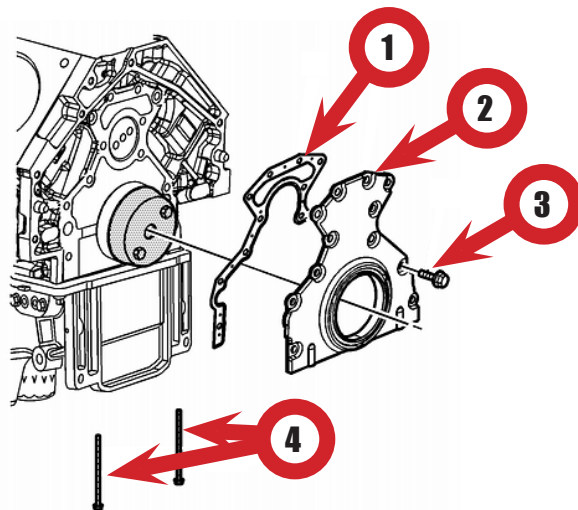


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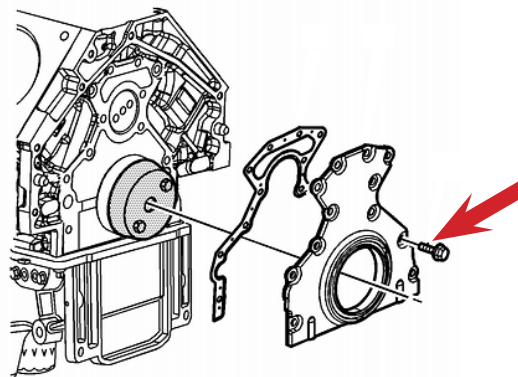
**STEP 3:** Install the J-41479-2A - guide cone and bolts onto the rear of the crankshaft.

**STEP 4:** Install the NEW rear housing gasket (1), rear housing with seal (2), rear housing-to-engine bolts (3) and oil pan-to-rear housing bolts (4).

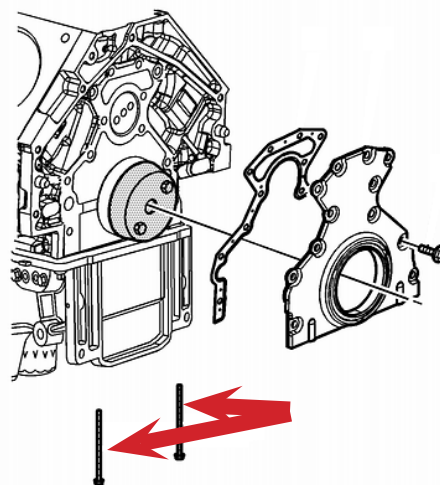


**STEP 5:** Tighten the rear housing-to-engine bolts until snug. Do not overtighten.

**NOTE:** Refer to shop manual or specific service procedures for fuel tank fastener safety.



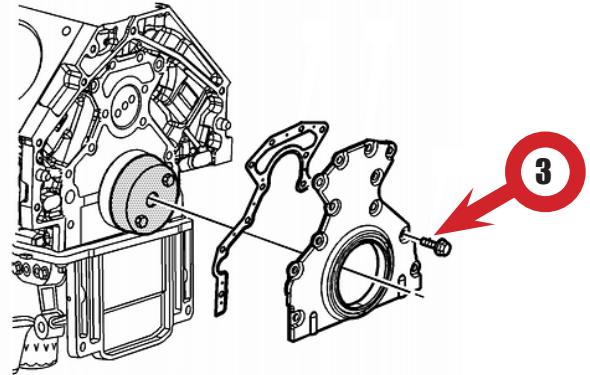
**STEP 6:** Tighten the oil pan-to-rear housing bolts to **12 N·m (106 lb·in)**.



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**STEP 7:** Tighten the rear housing-to-engine bolts to **30 N·m (22 lb·ft)**.



**STEP 8:** Remove the J-41479-2A - guide.

**STEP 9:** Install the automatic transmission flexplate.