



## Installation Instructions

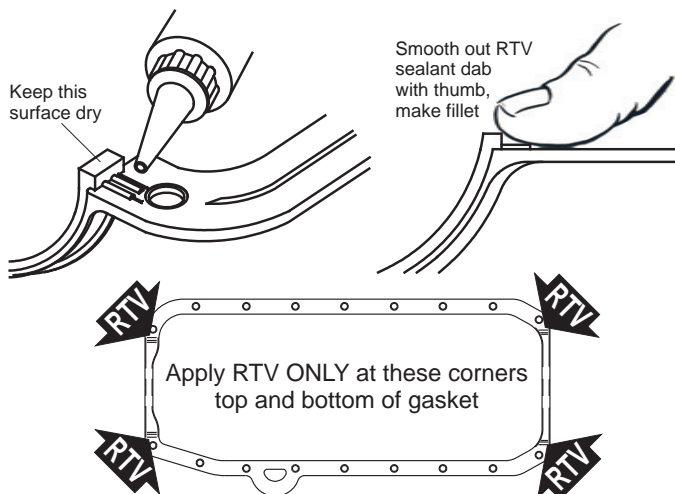
### SCE One-Piece Oil Pan Gaskets

To insure that your engine oil pan gasket is sealed properly and for prolonged care free performance, please follow these instructions.

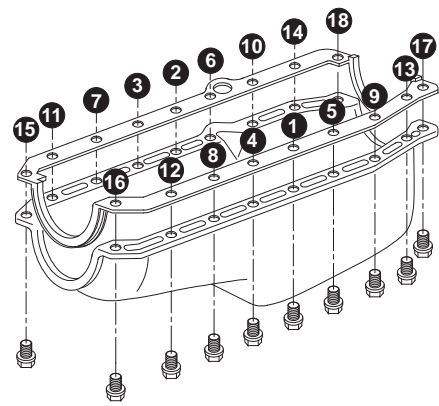
**Step 1** - Scrape and clean engine block and oil pan mating surfaces. Remove any oil or grease with proper cleaner.

**Step 2** - Check oil pan holes and flanges for flatness. Check bolts for stripped threads or heads, threads must be straight and clean, replace as necessary.

**Step 3** - To allow for differences in aftermarket oil pan stampings, use "small" dab of RTV sealant ONLY at rail ends front and back of oil pan as shown.



**Step 4** - Install SCE "One-Piece" oil pan gasket to engine block paying close attention to tab inserts at rear main cap and front cover assembly, then set oil pan in place carefully. Install oil pan bolts and torque to manufacturer's requirements in sequence, "crush limiters" will prevent damage to gasket from over tightening.



**Step 5** - Torque oil pan bolts.

Basic torque specifications for Chrysler, Ford, and GM engines.

**Chrysler -**

Torque to 100 inch-lbs.

**Ford -**

Torque to 100 inch-lbs.

**GM -**

Torque to 100 inch-lbs.

(For Chevy small block V6 and V8 engines 1986 and later).

Follow tightening sequence as shown above

**Step 6** - Add engine oil and check for leaks, then start engine and re-check for oil leaks.

## Under Car Installation Instructions

For under car installation of SCE "One-Piece" oil pan gaskets it is helpful to use a light adhesive such as "3M 88" aerosol or "Gasegacinch" (SCE p/n G1614) to hold the gasket in place during assembly. For ease of assembly please follow these tips.

1. Lay the gasket block side up and apply a light coat of adhesive on both pan rails, let tack for 5 minutes. Apply RTV sealant as shown in Step-3
2. Thoroughly clean all oil and grease from engine mating surfaces and apply a light coat of adhesive to engine block rails, let tack for 5 minutes.
3. Locate the pan gasket on the engine using 1 bolt in center of each pan rail, then stick gasket in place paying close attention to tab inserts at rear main cap and front cover as required.
4. Remove locating bolts and install oil pan and bolts, torque as required.

**Note:** It is critical that tab inserts at rear main cap are properly seated. Do not install gasket on oil pan first and attempt to assemble to block as it is difficult to align and insert tabs properly. If tabs are not seated properly serious leakage may occur.