



FEL-PRO INSTALLATION TIPS

GENERAL INSTRUCTIONS

CLEAN MATING SURFACES. Use a degreaser.

CLEAN THREADS of bolts/studs; for nuts/threaded holes use a bottoming tap.

BOLT PREPARATION: Those **entering** coolant passages require a pliable non-hardening sealer on threads and underside of bolt heads. Those **not entering** coolant passages require oil on threads and underside of bolt heads. **Exhaust Assembly:** Apply a high temperature anti-seize lubricant to threadings.

CHECK CASTINGS for flatness. Straighten, resurface or replace if needed. **CYLINDER HEAD AND BLOCK:** Refer to OEM manual to determine flatness tolerances and resurfacing limitations.

FINAL ASSEMBLY: Torque all fasteners to OEM specifications unless noted. **CYLINDER HEAD** torquing is critical; we recommend that you confirm with OEM.

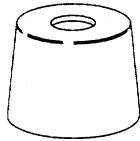
HEAD GASKET

Follow any directional markings shown on gasket(s). If no markings exist, install gasket(s). **Fiber Faced Gasket(s):** Install dry.

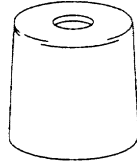
VALVE STEM SEALS



"O" Ring Exhaust
1964-76 = H.D.
330 Eng.
1973-76 - 359 &
389 Eng.
1964-72 = 361 &
391 Eng.



Umbrella Intake
1964-72 = H.D.
330 Eng.
1964-72 = 361 &
391 Eng.



**Intake & Exhaust
or Intake Only**
INTAKE ONLY:
1973-76 = H.D.
330 Eng.
1973-76 = 359, 361,
390 and 391 Eng.
Before Serial No.
C10, 001.
INTAKE AND EXHAUST
1964-72 = Med. D.
330 Eng.
1976-78 = H.D.
330 Eng.
1976-78 = 359, 361
389 and 391 Eng.
After Serial No.
C10.001.

Use the valve stem seals included in this set for the applications indicated.

UMBRELLA TYPE SEAL: Start valve stem seal over valve stem and push seal down on seal body until it touches top of valve stem guide or "boss." The seal will find its proper position on the stem once the engine starts.

"O" RING TYPE SEAL: Place "O" Ring seal on valve stem and position it into the proper groove.

VALVE COVER/PUSH ROD COVER

ATTACH AND ALIGN GASKET(S): Use a quick-drying adhesive applied sparingly. If gasket has installation tabs, adhesive is not required. **IMPORTANT:** If gasket is rubber, install dry.

INTAKE MANIFOLD GASKET

V-TYPE ENGINES - FIBER SIDE GASKET(S) ALONG WITH FRONT AND REAR END SEAL(S): Attach and align gasket(s) and end seal(s) using a quick-drying adhesive sparingly. **PRIOR TO INSTALLING INTAKE MANIFOLD** apply a dab of silicone sealer where all gaskets and seal meet.

INLINE ENGINES: Attach and align gaskets to cylinder heads.

EXHAUST MANIFOLD GASKET

ATTACH AND ALIGN GASKET(S). If gasket has only one steel faced side, install steel side towards manifold.



FEL-PRO INSTALLATION TIPS

GENERAL INSTRUCTIONS

CLEAN MATING SURFACES. Use a degreaser.

CLEAN THREADS of bolts/studs; for nuts/threaded holes use a bottoming tap.

BOLT PREPARATION: Those **entering** coolant passages require a pliable non-hardening sealer on threads and underside of bolt heads. Those **not entering** coolant passages require oil on threads and underside of bolt heads. **Exhaust Assembly:** Apply a high temperature anti-seize lubricant to threadings.

CHECK CASTINGS for flatness. Straighten, resurface or replace if needed. **CYLINDER HEAD AND BLOCK:** Refer to OEM manual to determine flatness tolerances and resurfacing limitations.

FINAL ASSEMBLY: Torque all fasteners to OEM specifications unless noted. **CYLINDER HEAD** torquing is critical; we recommend that you confirm with OEM.

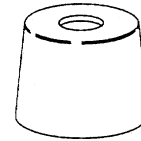
HEAD GASKET

Follow any directional markings shown on gasket(s). If no markings exist, install gasket(s). **Fiber Faced Gasket(s):** Install dry.

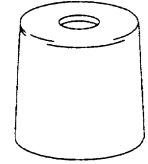
VALVE STEM SEALS



"O" Ring Exhaust
1964-76 = H.D.
330 Eng.
1973-76 - 359 &
389 Eng.
1964-72 = 361 &
391 Eng.



Umbrella Intake
1964-72 = H.D.
330 Eng.
1964-72 = 361 &
391 Eng.



**Intake & Exhaust
or Intake Only**
INTAKE ONLY:
1973-76 = H.D.
330 Eng.
1973-76 = 359, 361,
390 and 391 Eng.
Before Serial No.
C10, 001.
INTAKE AND EXHAUST
1964-72 = Med. D.
330 Eng.
1976-78 = H.D.
330 Eng.
1976-78 = 359, 361
389 and 391 Eng.
After Serial No.
C10.001.

Use the valve stem seals included in this set for the applications indicated.

UMBRELLA TYPE SEAL: Start valve stem seal over valve stem and push seal down on seal body until it touches top of valve stem guide or "boss." The seal will find its proper position on the stem once the engine starts.

"O" RING TYPE SEAL: Place "O" Ring seal on valve stem and position it into the proper groove.

VALVE COVER/PUSH ROD COVER

ATTACH AND ALIGN GASKET(S): Use a quick-drying adhesive applied sparingly. If gasket has installation tabs, adhesive is not required. **IMPORTANT:** If gasket is rubber, install dry.

INTAKE MANIFOLD GASKET

V-TYPE ENGINES - FIBER SIDE GASKET(S) ALONG WITH FRONT AND REAR END SEAL(S): Attach and align gasket(s) and end seal(s) using a quick-drying adhesive sparingly. **PRIOR TO INSTALLING INTAKE MANIFOLD** apply a dab of silicone sealer where all gaskets and seal meet.

INLINE ENGINES: Attach and align gaskets to cylinder heads.

EXHAUST MANIFOLD GASKET

ATTACH AND ALIGN GASKET(S). If gasket has only one steel faced side, install steel side towards manifold.