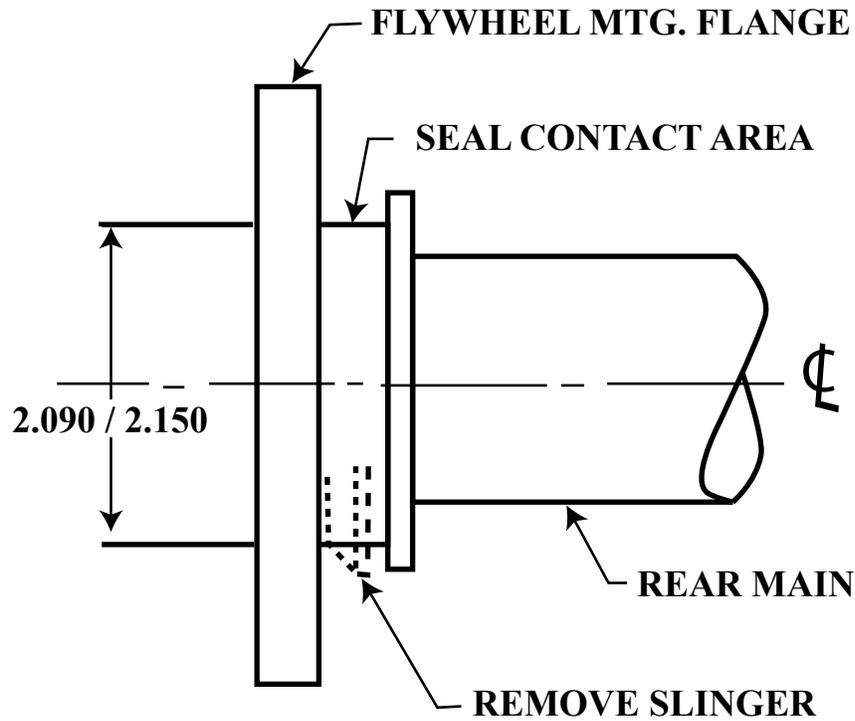


# A-6336 REAR MAIN SEAL INSTRUCTIONS



- 1) **Thoroughly clean** the grooves in the rear main bearing cap (A-6327) and block insert (A-6335) to remove all traces of dirt and oil, which may interfere with proper seal installation and sealant adhesion. Also, make sure rear main cap **drain pipe is clear**.
- 2) Without the crankshaft in place, assemble the seal with its lip facing towards the front of engine, shims, block insert, and rear main cap to the engine. Check to be sure the seal fits properly in its grooves, and is not distorted or offset relative to the rear main bearing.
- 3) Machine the rear slinger area of the crankshaft as shown in the drawing. **Finished diameter shall be between 2,090" and 2.150"**, and concentric with the rear main journal **within .001"** to prevent whipping of the seal lip outward. Machine crankshaft to largest diameter between limits consistent with cleanup. **Polish** seal contact area of the crankshaft to a bright smooth finish. **Main bearing clearance must be between .0010" and .0015" to keep the crankshaft from whipping the seal lip outward.**
- 4) Deburr the flywheel mounting flange. Carefully and without stretching it more than necessary, lubricate and slip the seal with lip facing towards front of engine over the flywheel mounting flange. A plastic sandwich bag placed over the flywheel mounting flange will protect the seal lip from damage due to small burrs, and a small blunt screwdriver may be required to ease seal over flange.
- 5) On final assembly, **apply either an RTV silicone adhesive or Permatex #2** sparingly to both grooves and all mating surfaces where shims, rear main cap, block insert, and block meet. **Avoid** getting adhesive on seal lip. Also apply sealant to rear main bolts.
- 6) Before installing oil pan, and after adhesive has cured, **test seal and rear main cap area** for leakage by pressurizing the rear main cap drain pipe with motor oil to 10 psi and check for leaks.
- 7) On occasion due to a hidden manufacturing defect, the seal will break while being stretched. If this should happen, return broken seal for a free replacement.