**INSTALLATION INSTRUCTIONS**

Mopar Performance - Block Hardware Kit for Small Block V-8

Fits 1964-'92 LA*, 1992-'03 Magnum, R1, R2, R3, R4, 340 Replacement, and Magnum Race Blocks

PART NUMBER    P5249261AB

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Block Hardware Kit Includes The Following Components:
- 4 – Dowel - 5/16” x 1/2” long – Cylinder Head
- 2 – Dowel – Approx. 1/2” x 3/4” long – Bell-Housing
- 1 – Intermediate Shaft Bushing
- 1 – Plug – Rear of Camshaft
- 3 – Cup Plug – Oil Galley – Under Thrust Plate
- 2 – Cup Plug – 1.25” Water Jacket
- 9 – Cup Plug – 1.625” Water Jacket
- 1 – Cup Plug – Oil Galley Above #5 Main Cap
- 2 – Pipe Plug – 1/4” NPT – Coolant Drain
- 4 – Pipe Plug – 3/8” NPT – Oil Galley
- 1 – Pipe Plug – 1/2” NPT – Rear of Distributor
- 1 – Fitting – Oil Filter Plate
- 1 – Gasket – Oil Filter Plate *
- 1 – Oil Filter Plate *

Note: if this hardware kit is included with an engine block, some of the components are already installed on the block (i.e. water jacket cup plugs, intermediate shaft bushing, cup plug above the #5 main).

* Note: The oil filter plate and gasket will not fit 1965-'92 273/318/340/360 “LA” engines (use Mopar part numbers - plate 2402103, and gasket 04897939AA). This plate and gasket included with this kit are designed to fit R1/R2/R3/340 Replacement, and Magnum blocks.

Read all instructions before beginning installation - Warnings and Cautions

Mopar Performance Parts recommends professional installation by an ASE Certified technician. A torque wrench and specialized removal and installation tools may be required.

Applications
This block hardware kit is designed to fit:
- 1964-'92 3.9L/273/318/340/360 “LA” Blocks *
- 1992-'03 3.9L/5.2L/5.9L Magnum Blocks
- R1/R2/R3/R4 Race Blocks
- 340 Replacement Blocks
- Magnum Race Blocks

IMPORTANT NOTES: READ BEFORE BEGINNING INSTALLATION!

This kit has enough plugs to fit each of the above engines. There will be a few extra plugs left over since each of these engines is slightly different, and won’t use two of the plugs. Be very careful, and inspect all oil galley and water passages to make sure none of the plugs are omitted in error. Consult a service manual (if needed) to make sure all plugs and components are installed correctly.

Main Oil Galley Plug
Be sure to check that the small cup plug has been installed in the oil passage between the #5 mains bearing cap and the main oil galley. If this plug is omitted in error, the engine will have very low oil pressure and the oil will not pass through the oil filter. This plug is installed before the #5 main cap is installed, and must be pressed all the way down onto a step in this oil passage. Use a flashlight and confirm that the oil will travel up from the oil pump and out the side of the block into the filter. From there the oil will pass through the filter and back into the block up into the main oil galley. Any time a block has been hot tanked or stress relieved, this plug must be replaced. For more information on this plug see the oiling section in the Mopar Performance book on Small Block “A” Engines (P4876826)

Plug in Distributor Pocket
Also, check the oil plug that threads into the main oil galley on the odd bank of cylinders (cylinders #1-3-5-7) just in front of the distributor. This plug must be installed prior to the distributor, and before the larger plug on the back of the block.

Oil Filter Plate
This kit now includes the oil filter plate, oil filter plate gasket, and the fitting that holds the plate and gasket to the block. Be sure to install the pipe plug in the block before the plate is installed.

Intermediate Shaft Bushing
The intermediate shaft bushing must be installed using a special tool (Miller Special Tools – part number C-3053 – Phone 800-801-5420). This tool is used to drive in the bushing and extrude it to the proper size for the intermediate shaft. If the bushing is installed without this tool, it may not fit tightly in the block, and won’t be finished to the proper size for the intermediate shaft.

NO PARTS WARRANTY – “AS IS”
Mopar Performance parts beginning with a “P” prefix are sold “as is” unless otherwise noted. This means that parts sold by Mopar Performance carry no warranty whatsoever. **Implied warranties, such as warranties of merchantability, are excluded.** (An implied warranty of merchantability means that the part is reasonably fit for the general purpose for which it was sold). The entire risk as to quality and performance of such parts is with the buyer. Should such parts prove defective following their purchase, the buyer and not the manufacturer, distributor or retailer, assumes the entire cost of all necessary servicing or repair. Chrysler, Dodge and Jeep® vehicle and parts warranties are voided if the vehicle or parts are used for competition. The addition of performance parts does not by itself void a vehicle’s warranty. However, added performance parts (parts not originally supplied on the vehicle from the factory) are not covered by the vehicle’s warranty, and any failure that they may cause is also not covered by the vehicle’s warranty.