



## ***Installation Instructions & Warranty Information***

SKC101 - 64-67 GM A Body LS Swap

Transmission Crossmember



**PerTronix®** thanks you for choosing **DOUG'S HEADERS**, the best fitting, highest quality Header and Engine Swap products on the market. To realize the full potential of our good fit, please read and understand these instructions completely prior to starting work.

Check to make sure you received the proper parts for your application against the parts list in these instructions. If you are unsure you have received the proper parts, please call PerTronix before you start work.

**Be sure to work safe!** Whenever you work under the vehicle be sure that it is located on level, solid ground and is supported by adequate safety stands!

**Remember: Hot asphalt will not support most jack stands!**

### **WARNING:**

This product can expose you to chemicals including Lead, Nickel, Cadmium and Chromium which are known to the State of California to cause cancer and birth defects or other reproductive harm. For more information go to [www.P65Warnings.ca.gov](http://www.P65Warnings.ca.gov)

## **NOTE: Read Before Starting Installation**

1. This Crossmember kit is designed to be used exclusively with Doug's Engine Mounts, part #SK103. This is part of the Doug's Engine Swap offering that includes Headers and Exhaust kits as well.
2. Doug's Oil Pan part # SKOP100 is required to make this conversion.
3. You will need a GM Style Transmission rubber mount such as Anchor #2268 or Energy Suspension #3.1108
4. Included in this kit are 2 transmission spacers, depending on your transmission you will either use one of them or neither.
5. This crossmember is designed for the standard 4th Gen Camaro T-56, T-56 Magnum, 4L60/4L65, 4L70/4L75, 4L80/4L85, TH400, and 200-4R transmissions with the following details;
  - ▶ 4L60/65 & 4L70/75 - Slight "hammer" clearance to the firewall above the upper left bellhousing to engine bolt area May be necessary. "Hammer" clearance WILL be necessary at the 2-4 servo cap on the right side of the transmission.
  - ▶ 4L80/85 - Clearancing around the following areas will be necessary; the output speed sensor, the electrical plug on the left side, the cooler fitting areas on the right side, and the two rear band anchor that protrude on the upper right side of the case near the rear. This will best be accomplished with assistance from a heat source like a torch.
  - ▶ T-56/T-56 Magnum - This trans will require some cutting of the floor. Cut a slit down the center of the trans tunnel, full length of the transmission. The area over the transmission extension will need to be removed. After installing the motor and trans using the Doug's motor mounts #SK103, raise the trans and pry the slit open until the trans will go high enough to locate the SKC101 crossmember.
  - ▶ TH350, TH400, 200-4R - No clearancing is required.
6. This installation requires that you mount your LS/LT engine using the Doug's SK103 before attempting to install this crossmember. Your transmission of choice will need to be installed to the motor and raised tight against the floor after the floor modifications are made.

## **INSTALLATION**

1. Attach the left and right frame adaptor brackets to the frame. The longer tapered end goes towards the front. There are three holes for frame mounting, 64-66 cars will use the two that are closest together, 67 cars will use the two that are furthest apart. Use the supplied 3/8-16 x 1" bolts, 4 flat washers, 2 lock washer, and 2 hex nuts. Drill 3/8" holes through the frame using the two holes that are on the upright section on the bracket and use 2 more 3/8-16 x 1" bolts, 4 flat washers, 2 lock washers and 2 hex nuts per side.
2. With the transmission raised as high as possible, attach the recommended transmission rubber mount to the trans, and place the crossmember on top of the mounting brackets. There are 7 bolt holes in the brackets (One is slotted) that bolt the crossmember to the brackets.
3. For the 4L60/65 & 4L70/75 you will use the forward most hole and the slotted hole to bolt the crossmember to the bracket. For all other transmissions use the third and sixth holes from the front. Use 2 7/16 x 1" bolts, 2 flat washers, 2 lock washers and 2 nuts per side.
4. 4L80/85 will mount to the holes in the center of the crossmember, all other transmissions will mount to the forward cantilevered set of holes. For T-56 installation use the supplied 5/16" spacer between the mount and the crossmember. 4L60/65 & 4L70/75 will use the 1" spacer between the mount and crossmember. TH350, TH400, & 200-4R will use the 1.30" tall spacer. Use 7/16 x 1 1/2" bolts, flat washer, and lock washers if using the Aluminum Spacer. Use stock trans mount bolts if you are not using the Aluminum spacer. Doug's also includes a 5/16" spacer that can be used with ALL transmission to assist with driveline angles for your particular application. Use the combination of 3/16" and 5/16" spacers along with the appropriate aluminum blocks for your specific application to obtain the ideal driveline angles. For more information about driveline angles see [www.spicerparts.com](http://www.spicerparts.com)
5. Once you have the transmission bolted to the crossmember, level the engine and trans left to right and tighten all motor mount to crossmember bolts.
6. You can now mount the Doug's Headers and exhaust system to complete you engine swap.

### Parts List

1	Crossmember	2	Side Adaptor Brackets	8	3/8 Lock Washer
1	3/16 Thick Steel Spacer	1	5/16 Thick Steel Spacer	6	7/16 Lock Washer
1	1" Aluminum Spacer	1	1.30" Aluminum Spacer	6	7/16 Flat Washer
4	7/16 x 1" Bolts	4	7/16 Flange Nuts	8	3/8 x 1" Bolts
8	3/8 Flange Nuts	2	7/16 x 1 1/2" Bolts	16	3/8 Flat Washers



This product is designed for swapping a non-original engine into a vehicle that did not offer it. Laws vary by state regarding emissions regulations for engine swaps. This product is illegal for Street or Off Highway use on any 1975 or newer vehicle originally equipped with a catalytic converter and may further be illegal depending on state or federal engine swap emissions laws regardless of vehicle year and would therefore only be legal for Closed Course Competition use. *PerTronix Performance Brands 2021*

### DOUG'S HEADERS LIMITED WARRANTY

All Doug's Headers and Exhaust products are guaranteed, to the original purchaser, to be free of defects in material and workmanship for one year from date of purchase. This warranty covers the replacement or repair of the product and does not cover the cost of removal and installation, customer applied coatings, or Any discoloration or corrosion of finished surfaces.

Damage or product failure resulting from collision, improper installation, off road use, road hazards, the use of exhaust insulating wrap, or rust occurring after installation is not covered by the warranty. This warranty extends only to the original purchaser.

Should a part be deemed defective, it should be returned to the original selling retailer and must be accompanied by the sales receipt. If there is no retailer in your area, contact PerTronix direct for a return authorization and return the part prepaid to the factory for inspection. PerTronix reserves the right to replace or repair the alleged defective part and return the part freight collect.



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