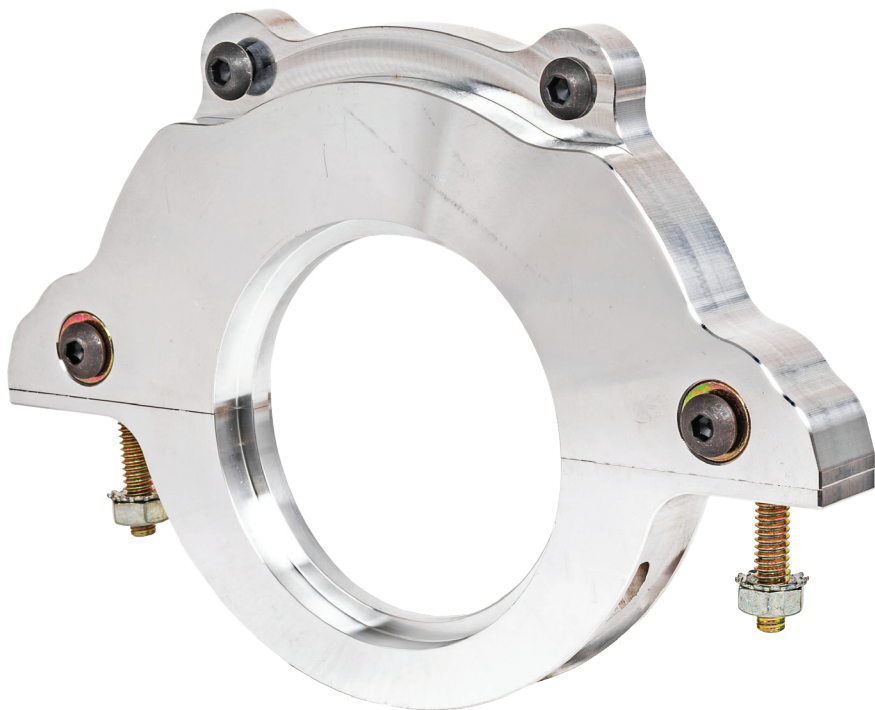


# **Installation Guide**

**Rear Main Seal Adapter**

**1986-2002 Small Block Chevy**

**555-502500**



# Parts List



| # | PART                            | QTY. | # | PART                                | QTY. |
|---|---------------------------------|------|---|-------------------------------------|------|
| 1 | Adapter Assembly                | 1    | 4 | Socket Head Screws (1/4-20 x 1 in.) | 2    |
| 2 | Locating Studs (1/4-20 x 1 in.) | 2    | 5 | Cap Screws (1/4-20 x 3/4 in.)       | 2    |
| 3 | Cap Screws (1/4-20 x 1 1/8 in.) | 2    | 6 | Nut with Star Washer (1/4-20)       | 2    |

# Installation

The 555-502500 Rear Main Seal Adapter fits 1986-2002 Small Block Chevy engines with a 1-piece rear main seal. It will fit both early and late style oil pans.

- Inspect the mounting surface of the block prior to installation. The area above the upper mounting holes on the block was not always machined at the factory. It may be necessary to clean up this area with a file or de-burring tool. If there is an alignment pin in the lower mounting hole on the passenger side of the engine block, it should be removed now.
- Place the **(#2) Locating Studs** onto the **(#1) Adapter** with the Studs sitting in the slots. Remove the **(#4)  $\frac{5}{16}$ -20 x 1" Cap Screws** securing the top and bottom halves of the Adapter. Install the rear main seal.
- Attach the upper half of the Adapter and Locating Studs with the gasket to the block using the **(#3)  $\frac{1}{4}$ -20 x 1- $\frac{1}{2}$ " Cap Screws** in the lower set of holes and the **(#5)  $\frac{1}{4}$ -20 x  $\frac{3}{4}$ " Cap Screws** in the upper holes. *Fig. 1*
- Hand-tighten the cap screws at this time. Use a small amount of silicone sealant where the rear main seal surfaces will meet.
- Attach the bottom half of the Adapter to the top using the removed **(#4)  $\frac{5}{16}$ -20 x 1" Cap Screws** and torque to 80 in.-lbs. Torque the four  $\frac{1}{4}$ -20 cap screws holding the adapter to 190 in.-lbs.

- This adapter is designed for use with a GM oil pan seal, and must be modified by cutting the ends flush. *Fig. 2*
- To prevent a possible leak, use a small amount of silicone sealant at the corners where the seal meets the adapter.
- After the oil pan has been installed, torque the nuts on the **(#2) Locating Studs** to 84 in.-lbs.

## NOTE (Gaskets)

- CRANKSHAFT REAR OIL SEAL HOUSING GASKET: GM 12555771
  - Supersedes: GM 12555714
- REAR SEAL: Fel Pro BS11829

# Diagrams

Figure 1

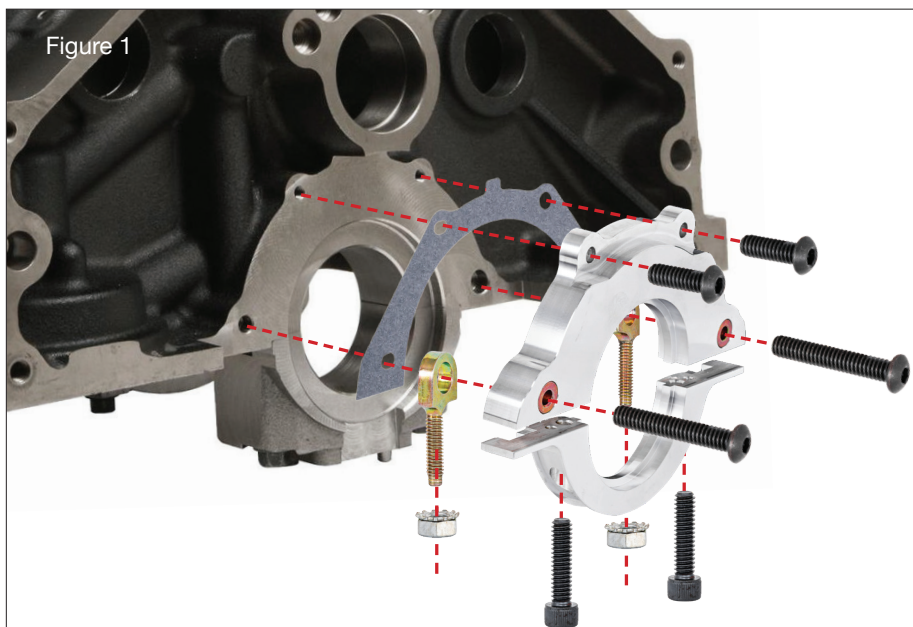


Figure 2

