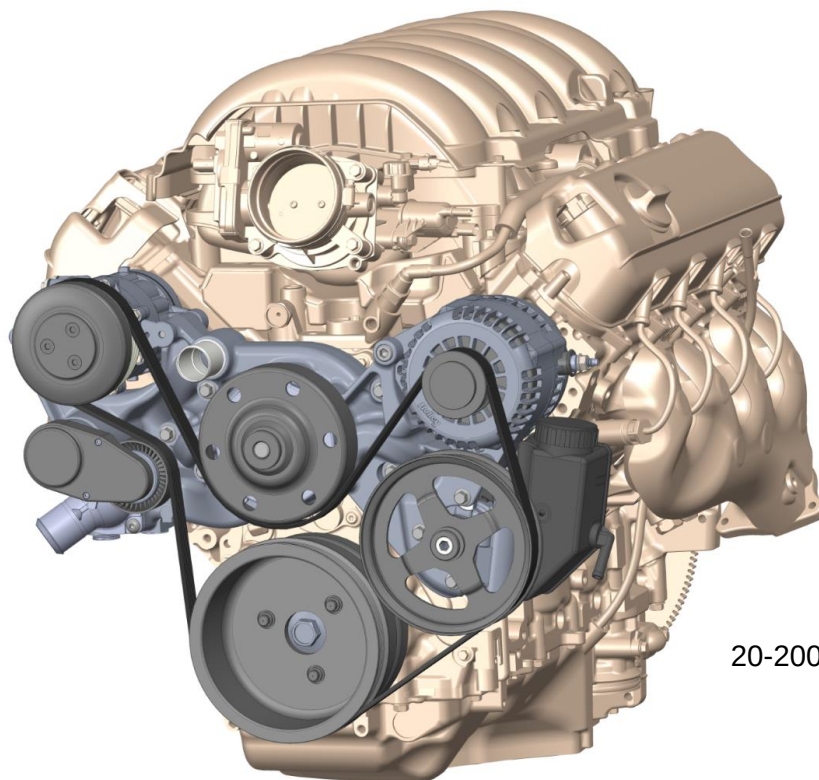




## Complete Holley Mid-Mount Accessory Drive Kit

**Part Numbers: 20-180, 20-180BK, 20-180P, 20-185, 20-185BK, 20-185P, 20-190, 20-190BK, 20-190P, 20-200, 20-200BK, 20-200P, 20-205, and 20-205BK**



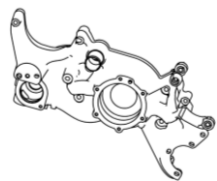
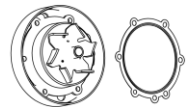
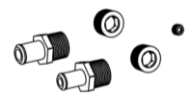
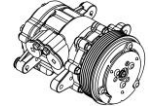
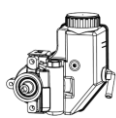
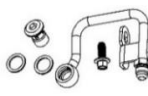
20-200 shown

Holley's Mid-Mount complete accessory system has all accessories pulled in tighter than other accessory drives. Among the many swap friendly features is the bracket-less assembly that actually mounts all accessories to the water pump directly.

### Features:

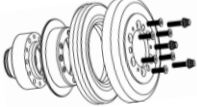
- Bracket-less accessory mounting with ultra-easy assembly
- Bottom outlet heater hose options for swap application clearance
- LT1 style hairpin premium alternator
- LT1 style water pump design
- Compact SD7 A/C compressor
- Type II power steering pump with baffled reservoir
- OE pulley ratios for optimal accessory performance
- Available for LS and LT applications
- Billet tensioner cover (does not apply to 20-185)
- Billet alternator and compressor pulley covers (does not apply to 20-185, 20-185BK, and 20-185P)
- SFI certified damper w/ hard anodized billet crank pulley (does not apply to 20-185, 20-185BK, and 20-185P)

## Parts List:

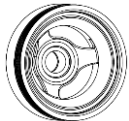
| PICTURE                                                                             | QTY | DESCRIPTION                                                               | REPLACEMENT<br>MANUFACTURER & P/N                                                                                                           |
|-------------------------------------------------------------------------------------|-----|---------------------------------------------------------------------------|---------------------------------------------------------------------------------------------------------------------------------------------|
|    | 1   | Manifold Assembly, Water Pump                                             | Holley 97-163 (LS natural) / 97-167 (LS black) / 97-165 (LS polished)<br><br>97-164 (LT natural) / 97-168 (LT black) / 97-166 (LT polished) |
|    | 1   | Gaskets, Water Pump                                                       | GM 12630223 (LS) / 12657430 (LT)                                                                                                            |
|    | 1   | Water Pump Drive Assembly / Gasket                                        | Holley 97-200 / GM 12619770                                                                                                                 |
|    | 1   | Belt, 6 Rib Serpentine                                                    | BANDO 6PK1715                                                                                                                               |
|    | 1   | Thermostat 180° / housing                                                 | Holley 97-169 (set)<br>GM 89018168 (thermostat only)                                                                                        |
|    | 1   | NPT Adapters (2) & Plugs (3)                                              | Holley 97-177                                                                                                                               |
|  | 1   | Tensioner Assembly with Smooth Pulley                                     | Holley 97-179<br>OR<br>Gates 38163                                                                                                          |
|  | 1   | Alternator / harness pigtail                                              | Holley 197-302 (natural) / 197-303 (black) / 197-304 (polished),<br>Pigtail Holley 197-400                                                  |
|  | 1   | SD7 A/C Compressor                                                        | Holley P/N 199-102 (natural) / 199-104 (black) / 199-106 (polished)                                                                         |
|  | 1   | Adapter Manifold for A/C Compressor                                       | Holley 199-202                                                                                                                              |
|  | 1   | P/S Pump with Reservoir                                                   | Holley P/N 198-101                                                                                                                          |
|  | 1   | P/S Pressure Hardline to -6 AN, Banjo Bolt, crush washers (2), & Hardware | Holley 198-203                                                                                                                              |
|  | 1   | P/S Pulley                                                                | Holley P/N 97-152                                                                                                                           |
|  | 1   | Damper Crank Bolt (OE)                                                    | GM 12557840 (LS1, 2, 3, 6, & LT) / 11570163 (LS7)                                                                                           |

| HARDWARE (REPLACEMENT KIT 97-162)                                                 |   |                                      | HARDWARE APPLICATION     |
|-----------------------------------------------------------------------------------|---|--------------------------------------|--------------------------|
|  | 1 | Oversized Washer, M8                 | Tensioner                |
|  | 1 | Button Head Bolt, M8 x 1.25 x 70     | Tensioner                |
|                                                                                   | 1 | Button Head Bolt, M10 x 1.5 x 80     | Alternator (outside)     |
|                                                                                   | 2 | Button Head Cap Bolt, M6 x 1.0 x 18  | Thermostat Housing       |
|                                                                                   | 6 | Button Head Bolt, M6 x 1.0 x 20      | Water Pump to Manifold   |
|  | 2 | Socket Head Cap Bolt, M8 x 1.25 x 95 | A/C Compressor           |
|                                                                                   | 1 | Socket Head Cap Bolt, M10 x 1.5 x 75 | Alternator (inside)      |
|  | 5 | Flange Head Bolt, M8 x 1.25 x 115    | Manifold to Engine Block |
|                                                                                   | 1 | Flange Head Bolt, M8 x 1.25 x 50     | Manifold to Engine Block |
|                                                                                   | 3 | Flange Head Bolt, M8 x 1.25 x 30     | Power Steering Pump      |

**Included Only With:** 20-180, 20-180BK, 20-180P, 20-190, 20-190BK, 20-190P, 20-200, 20-200BK, and 20-200P

|                                                                                   |   |                                                                                                              |                                                             |
|-----------------------------------------------------------------------------------|---|--------------------------------------------------------------------------------------------------------------|-------------------------------------------------------------|
|  | 1 | Crank Pulley                                                                                                 | Holley 97-159 (LS1, 2, 3, & 6) / 97-160 (LS7) / 97-161 (LT) |
|  | 1 | Hub, Inner Shell, Damper assembly, Outer Shell, & Hardware (crank pulley bolts included with this hardware). | Holley 97-190 (LS1, 2, 3, & 6) / 97-191 (LS7) / 97-192 (LT) |

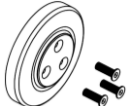
**Included Only With:** 20-185, 20-185BK, 20-185P, 20-205, and 20-205BK

|                                                                                     |   |                           |                                              |
|-------------------------------------------------------------------------------------|---|---------------------------|----------------------------------------------|
|  | 1 | One-piece damper / pulley | Holley 97-205 (LS1, 2, 3, & 6) / 97-325 (LT) |
|-------------------------------------------------------------------------------------|---|---------------------------|----------------------------------------------|

**Included Only With:** 20-180, 20-180BK, 20-180P, 20-185P, 20-190, 20-190BK, 20-190P, 20-200, 20-200BK, and 20-200P

|                                                                                     |   |                                  |                                           |
|-------------------------------------------------------------------------------------|---|----------------------------------|-------------------------------------------|
|  | 1 | Alternator Pulley Cover & O-ring | Holley 97-187 (black) / 97-188 (polished) |
|-------------------------------------------------------------------------------------|---|----------------------------------|-------------------------------------------|

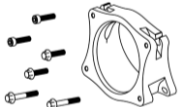
**Included Only With:** 20-180, 20-180BK, 20-180P, 20-190, 20-190BK, 20-190P, 20-200, 20-200BK, and 20-200P

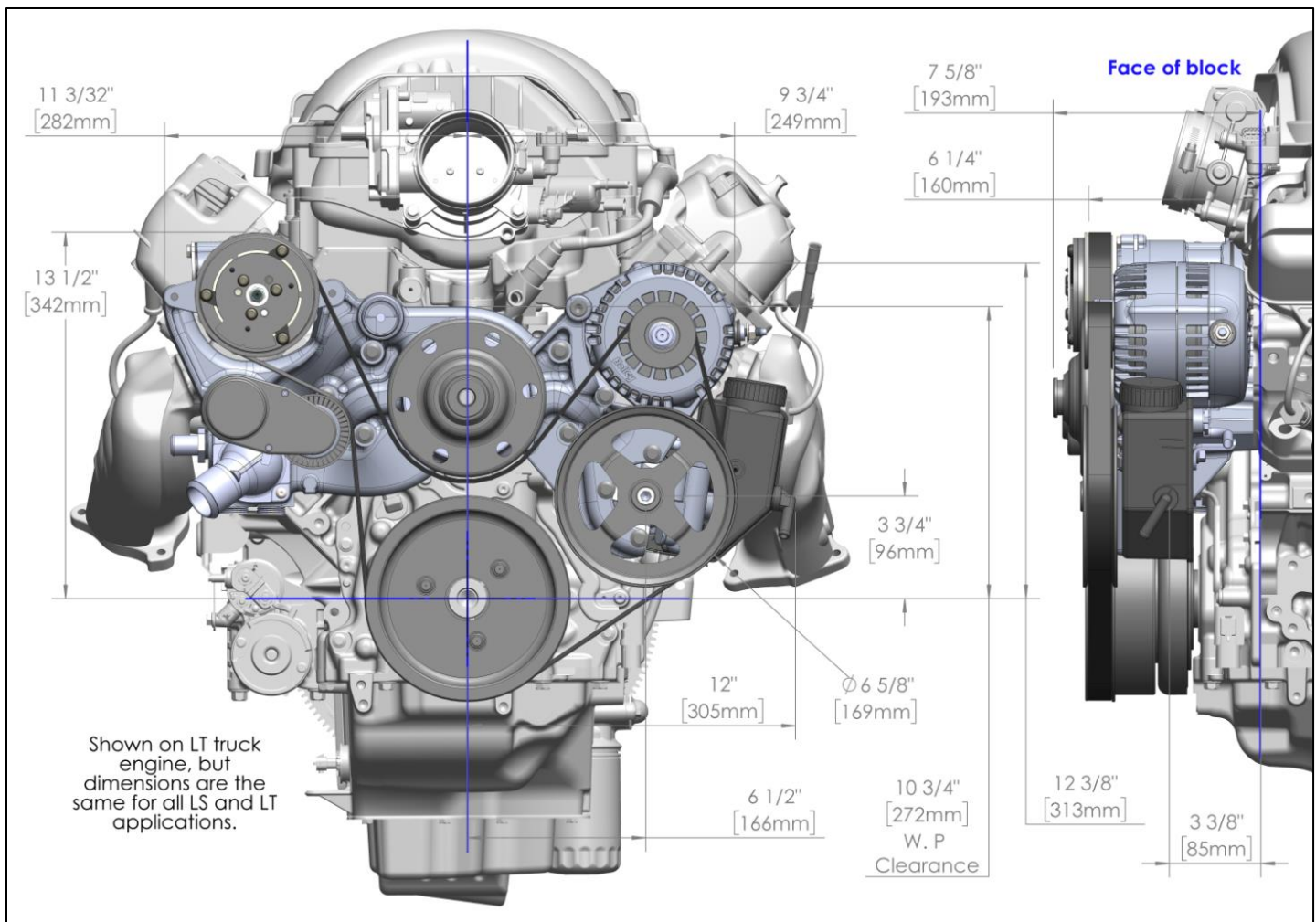
|                                                                                     |   |                                        |                                           |
|-------------------------------------------------------------------------------------|---|----------------------------------------|-------------------------------------------|
|  | 1 | A/C Compressor Pulley Cover & Hardware | Holley 97-185 (black) / 97-186 (polished) |
|-------------------------------------------------------------------------------------|---|----------------------------------------|-------------------------------------------|

**Included Only With:** 20-180, 20-180BK, 20-180P, 20-185BK, 20-185P, 20-190, 20-190BK, 20-190P, 20-200, 20-200BK, and 20-200P

|                                                                                     |   |                            |                                           |
|-------------------------------------------------------------------------------------|---|----------------------------|-------------------------------------------|
|  | 1 | Tensioner Cover & Hardware | Holley 97-158 (black) / 97-157 (polished) |
|-------------------------------------------------------------------------------------|---|----------------------------|-------------------------------------------|

**Included Only With:** 20-200, 20-200BK, and 20-200P

|                                                                                     |   |                                        |               |
|-------------------------------------------------------------------------------------|---|----------------------------------------|---------------|
|  | 1 | Throttle Body Angle Adapter & Hardware | Holley 717-15 |
|-------------------------------------------------------------------------------------|---|----------------------------------------|---------------|



**IMPORTANT NOTE IF PAINTING COMPONENTS:** The alternator and A/C compressor ground through the water pump manifold. If painting or coating the manifold, the mating surfaces must all be bare metal allowing a ground path from the accessories' mounting feet to the engine block and ultimately the negative terminal on the battery.

**Technical Support: 1-866-464-6553**

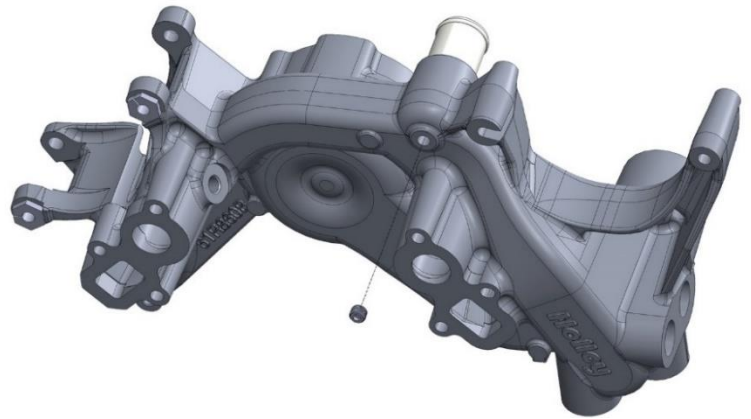
## **Assembly Instructions**

**HELPFUL HINT:** The below assembly order is optimized for explanation and the average application. It may be easier to preassemble some components to the manifold before mounting to the engine. Torqueing of the components may however be easier after mounting. The only component that cannot be preassembled is the tensioner, as it would prevent access to a mounting bolt. Keep in mind adding components increases overall size and weight and may require an additional person when mounting.



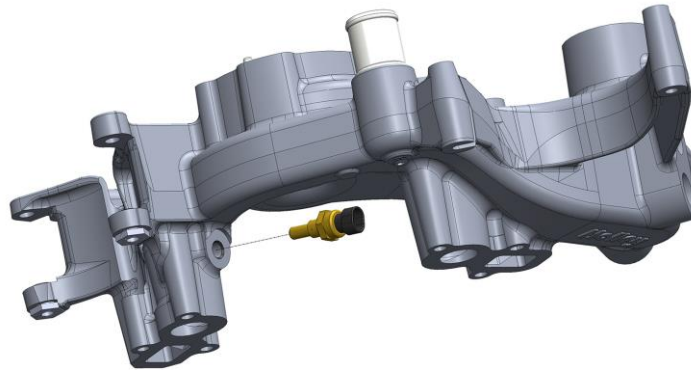
### **Steam Vent Inlet Port (optional):**

A port is provided for convenient and simple routing of LS steam venting. If not utilizing the steam inlet port, install the 1/8" NPT plug provided. Use thread sealant (Loctite® brand 567 pipe thread sealant or equivalent). Install to finger tight, and then tighten 2 to 3 rounds.



Suggested accessories (not included): Holley 26-552 complete LS steam tube plumbing kit

### **ECU Water Temperature Sensor Installation (LT applications only):**

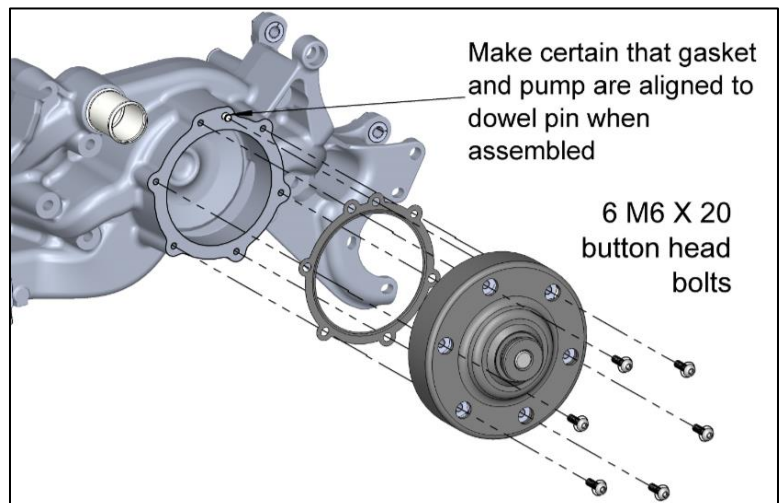


Install original temperature sensor removed from the LT water pump manifold. Torque to 15 ft./lb.

### **Water Pump and Gasket Installation:**

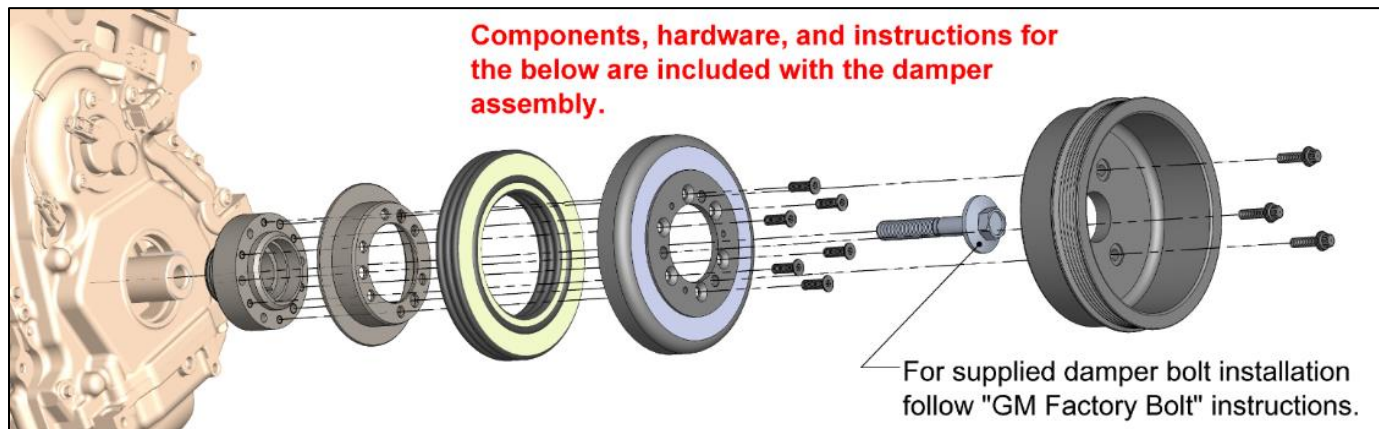
**Helpful Hint:** Do not confuse these M6 x **20 long** bolts with the two M6 x **18** bolts to be used later.

**NOTE:** Torque M6 button head bolts to 85 in/lbs. Use a standard 4mm hex tool. Do not use a ball hex tool.  
**Do not overtighten.**

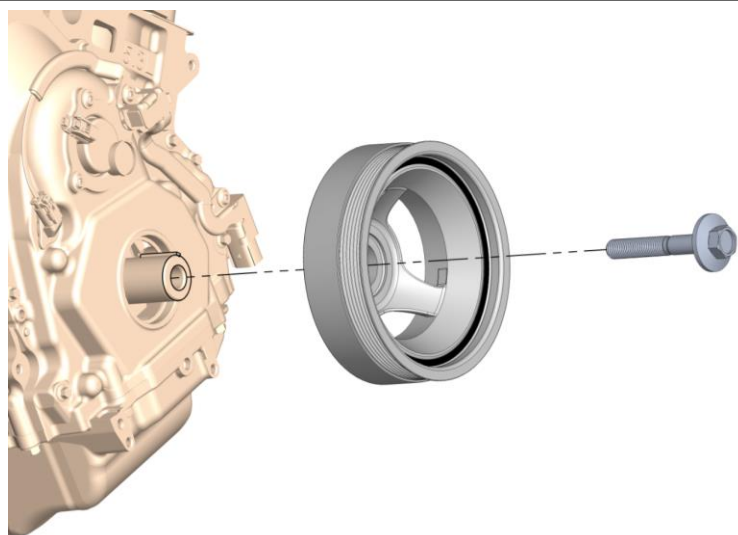


## ***Damper / Crank Pulley Assembly Installation (whichever applies to your kit):***

SFI certified damper and billet pulley



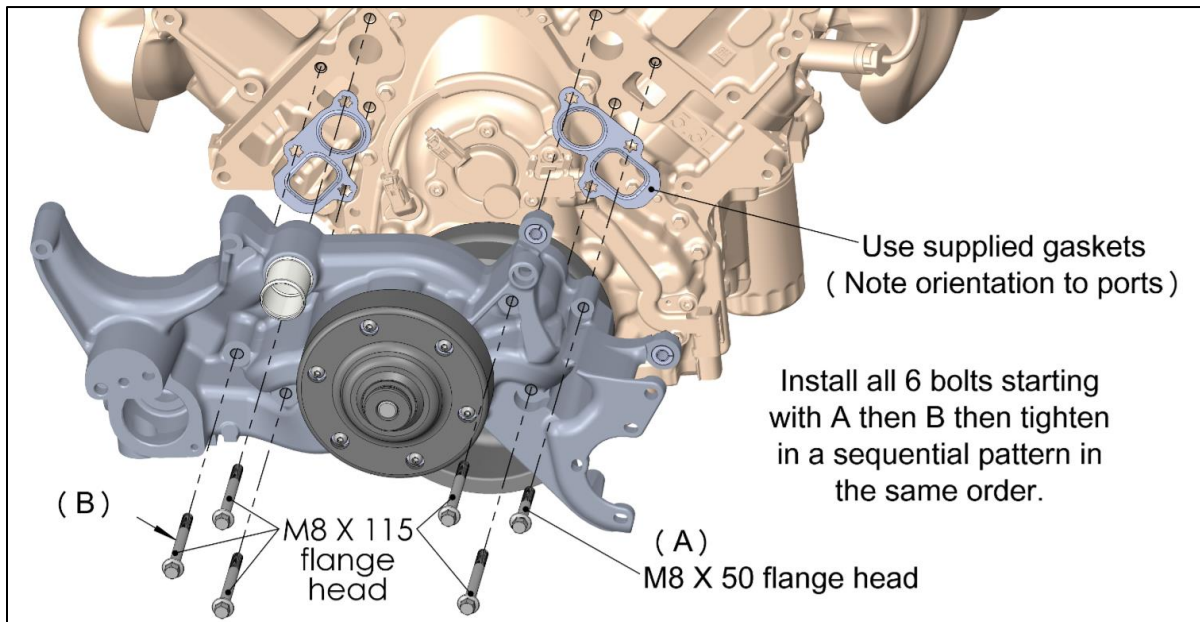
One-piece OE style damper/pulley



1. Remove original bolt (retain this bolt for later use)
2. Remove existing damper/pulley with an LS style puller like ICT P/N 551329.
3. Apply lubricate to the bore of the new damper hub and to the hub side of the original bolt head
4. Use an installation tool like ICT 551141 to install the new damper/pulley. Remove tool.
5. Install the original bolt and torque to 240 ft./lbs. to seat and then remove the bolt. During torqueing, use a flywheel holder like Trick Flow TFS-90326 to prevent the engine from turning.
6. Install and tighten the new (unused) bolt to 59 ft./lbs.
7. At this time, reference the front of the engine with the handle of the wrench. Mark with tape where 125° of clockwise rotation would be from where 59 ft./lbs. was obtained.
8. Rotate the wrench / bolt 125°. Remove the flywheel holder tool. The installation process is now complete

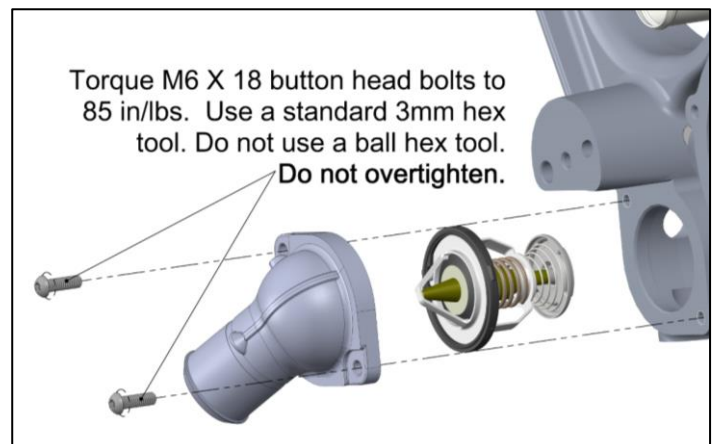
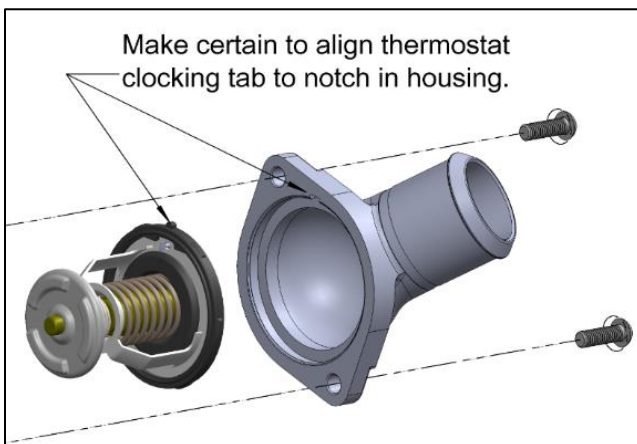
**NOTE:** Only use a new (unused) bolt for the last steps.

## Manifold Installation:

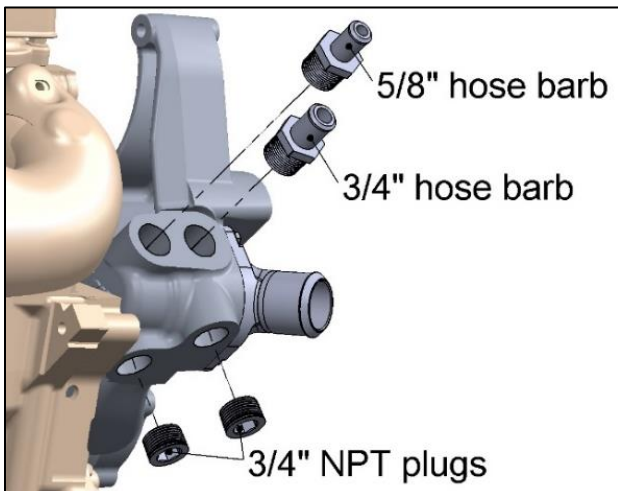


**NOTE:** Torque M8 bolts to 18 ft./lbs.

## Thermostat and Heater Hose Adapter Installation:



**WARNING:** Do not plug all heater passages. For safe LS/LT engine start up cooling this path must stay open. If not utilizing a heater core, install a jumper hose between the two barbs.



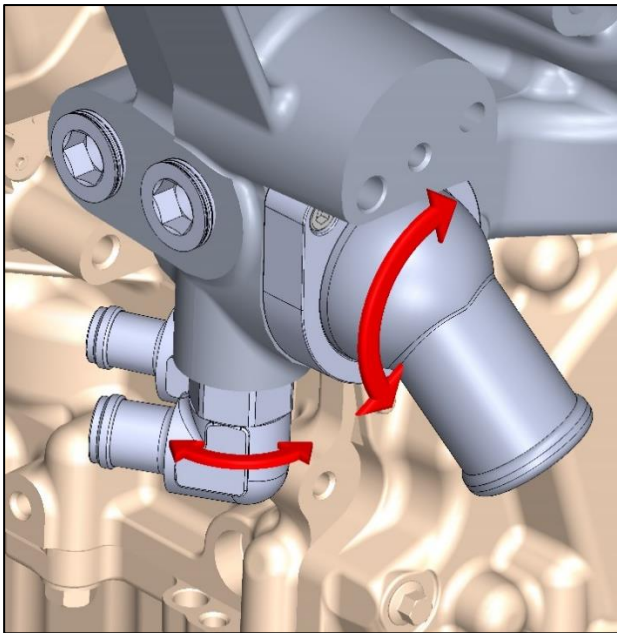
**Configurations:** On some swap applications there is not clearance for side heater hose outlets. There are optional bottom outlets for these applications.

**Assembly:** Install the smaller 5/8" barb on either the rear side or rear bottom port first, then the large 3/4" barb on either front port. Plug the unused ports.

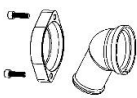
Use thread sealant (Loctite® brand 567 pipe thread sealant or equivalent). Install to finger tight, then tighten 2 to 3 rounds.



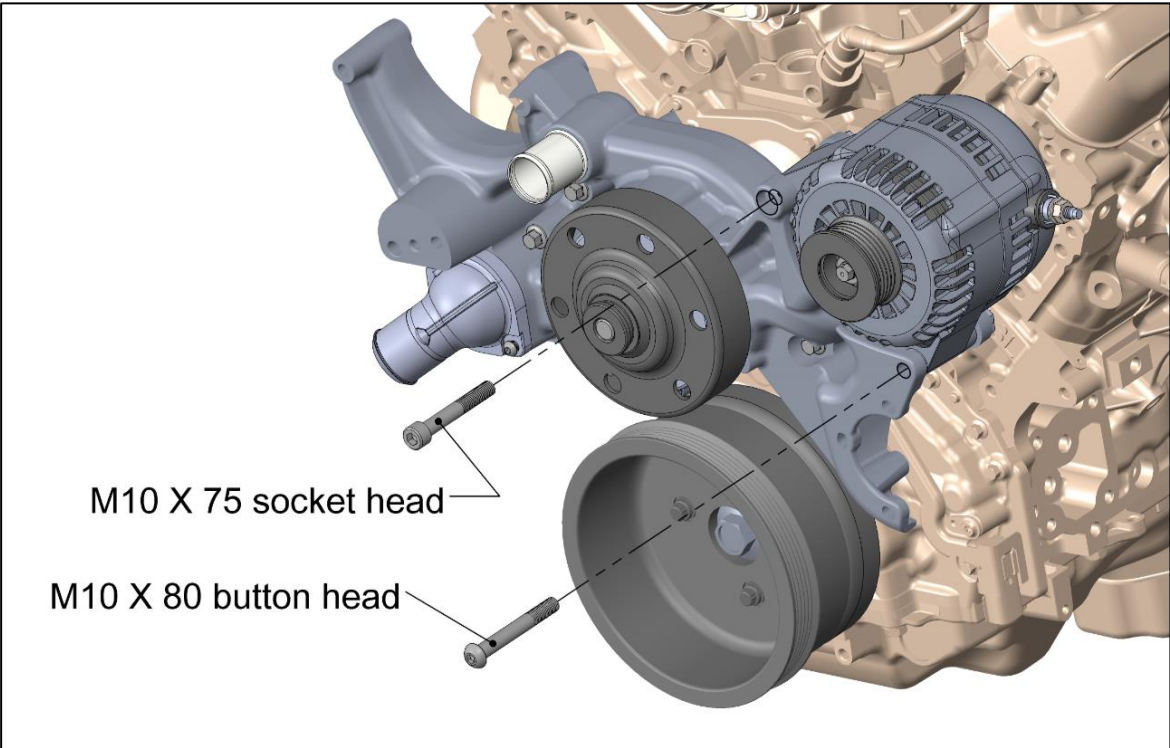
**Alternate Installation Option (additional parts required):**



For applications with interference on the passenger side, the shown swivel adapters are available **(not included)**.

| PICTURE                                                                           | DESCRIPTION                                    | MANUFACTURER & P/N                                                |
|-----------------------------------------------------------------------------------|------------------------------------------------|-------------------------------------------------------------------|
|  | Swivel<br>Thermostat Housing                   | Mr. Gasket<br>2670 (chrome)<br>2670BK (black)<br>2670NA (natural) |
|  | Early Style Thermostat<br>(required for above) | Mr. Gasket<br>6368                                                |
|  | Swivel 90°<br>3/4" Barb 3/4" NPT               | Earl's<br>SS988412ERL                                             |
|  | Swivel 90°<br>5/8" Barb to 3/4" NPT            | Earl's<br>SS988409ERL                                             |

**Alternator Installation:**

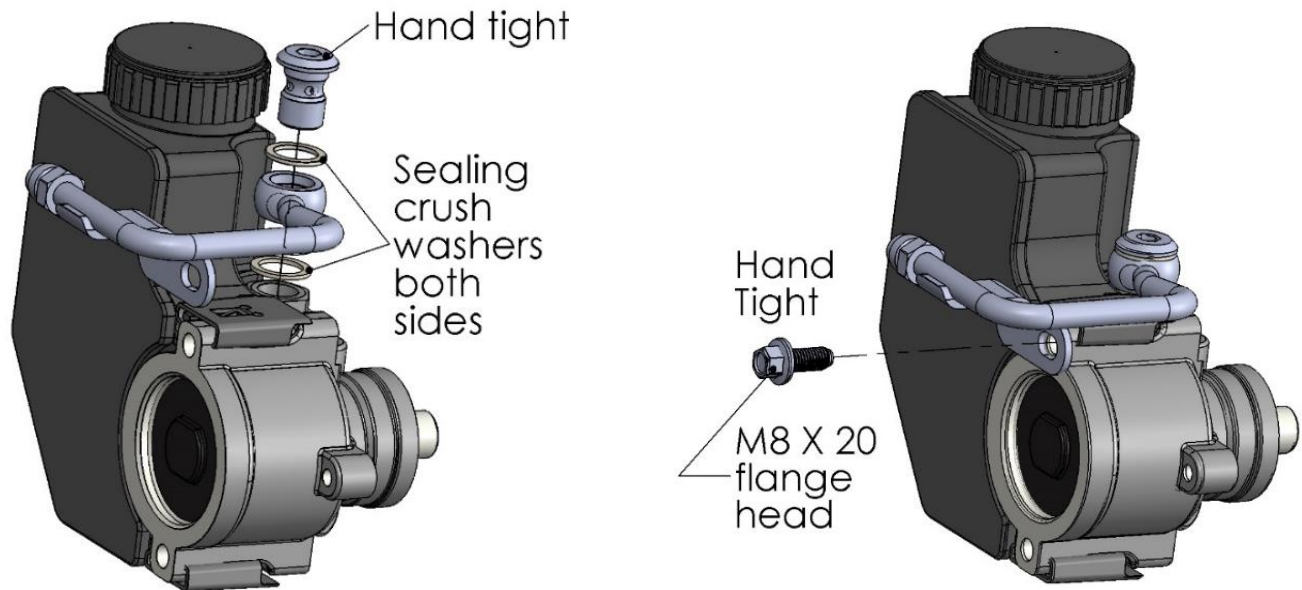


**NOTE:** Torque M10 bolts to 36 ft./lbs.

**ALTERNATOR WIRING:** See instructions included with the alternator for wiring directions.

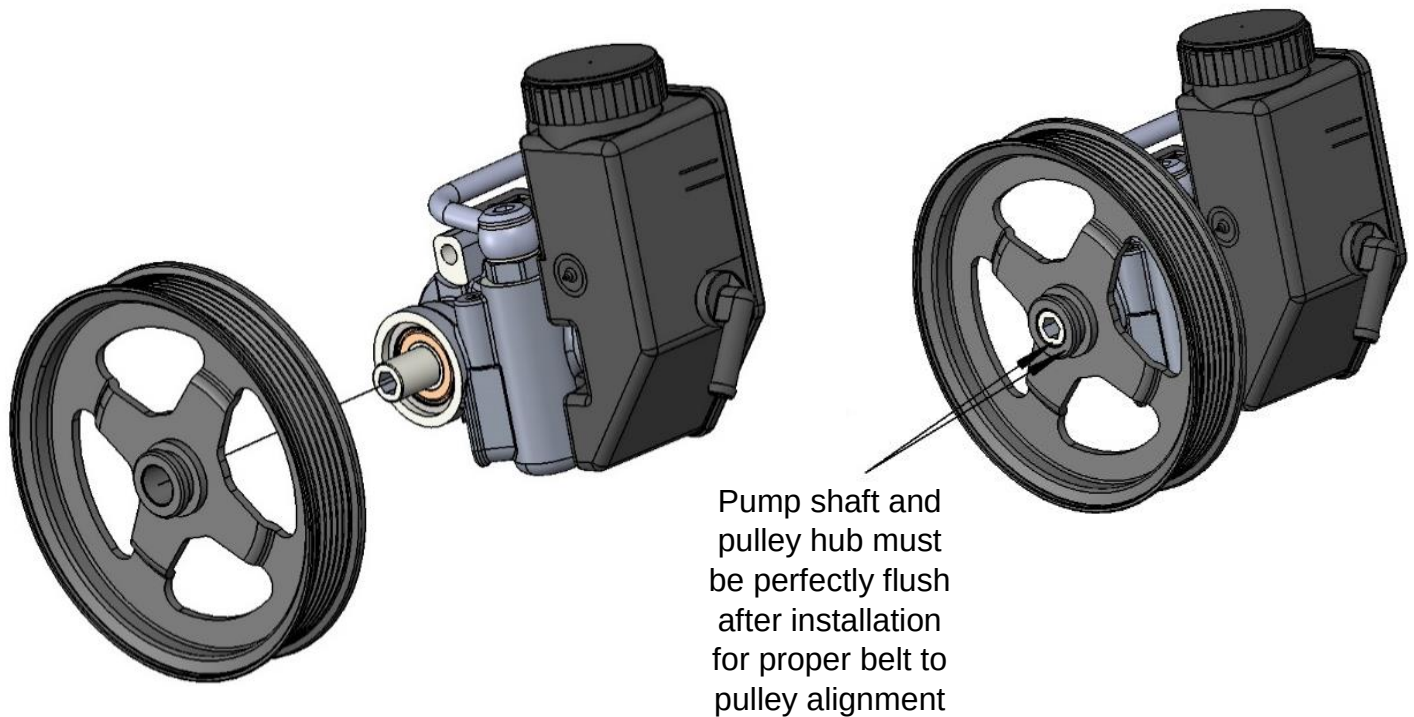


### ***P/S Pump -6 AN Adapter Assembly:***



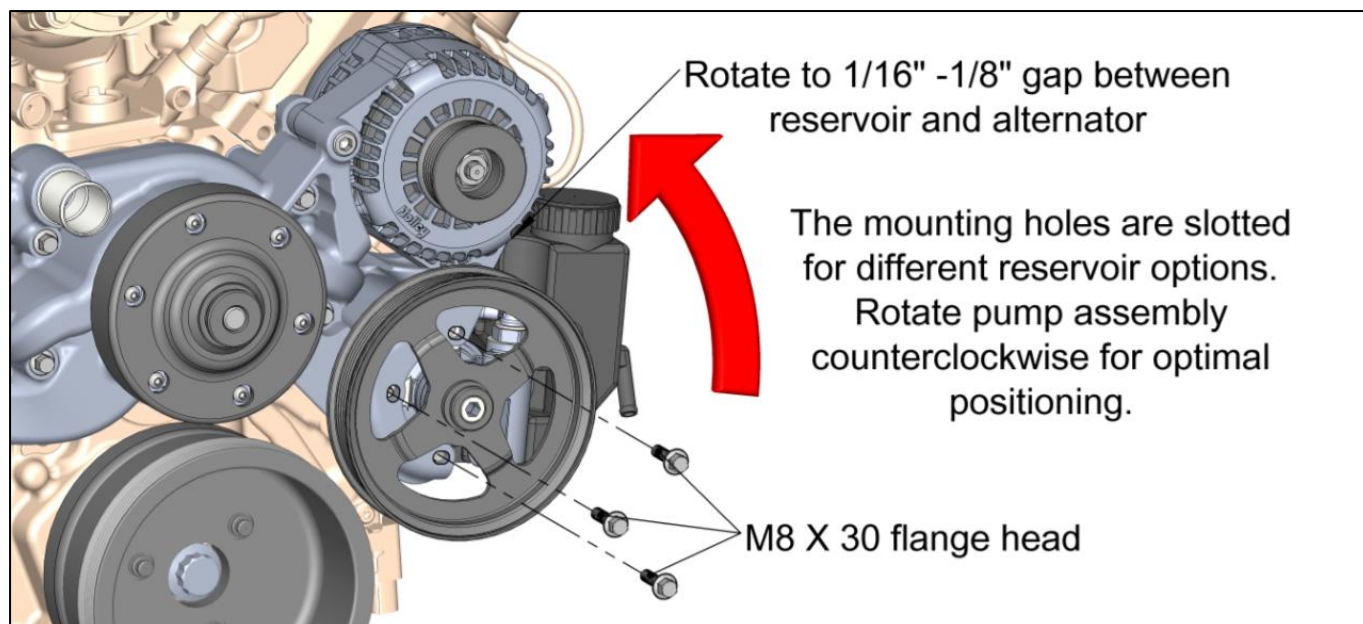
**NOTE:** After assembly torque M8 bolts to 18 ft./lbs. and banjo bolt to 25 ft./lbs.

### ***P/S Pump Pulley Installation:***



**HELPFUL HINT:** Pulley installation tools are available for rent at most auto parts stores.

### ***P/S Assembly Installation:***

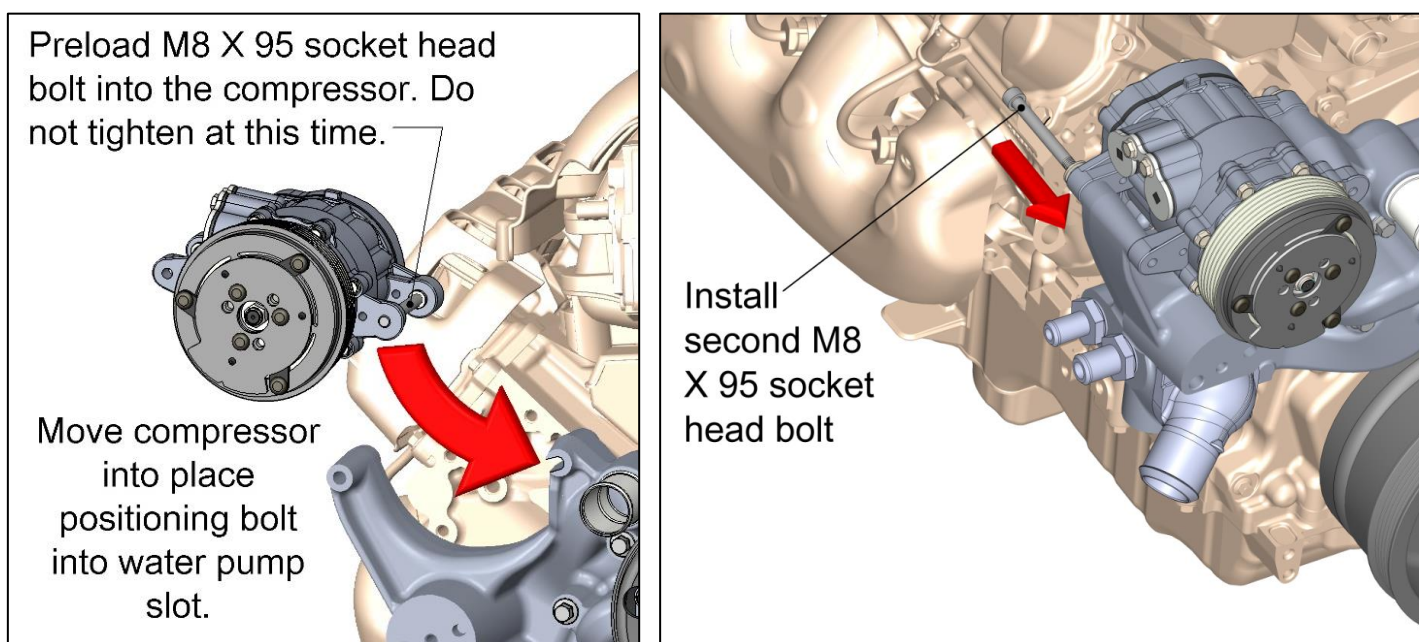


**NOTE:** Torque M8 bolts to 18 ft./lbs.

**IF THERE IS RESERVOIR INTERFERENCE:** In a few applications, the supplied reservoir may interfere with the vehicle. In these cases, use Holley P/N PS0001ERL to adapt the supplied P/S pump's inlet to a connection appropriate for use with most remote reservoirs. Reservoir options include Holley P/N 198-211 and 198-212 when used with adapter AT785010ERL.

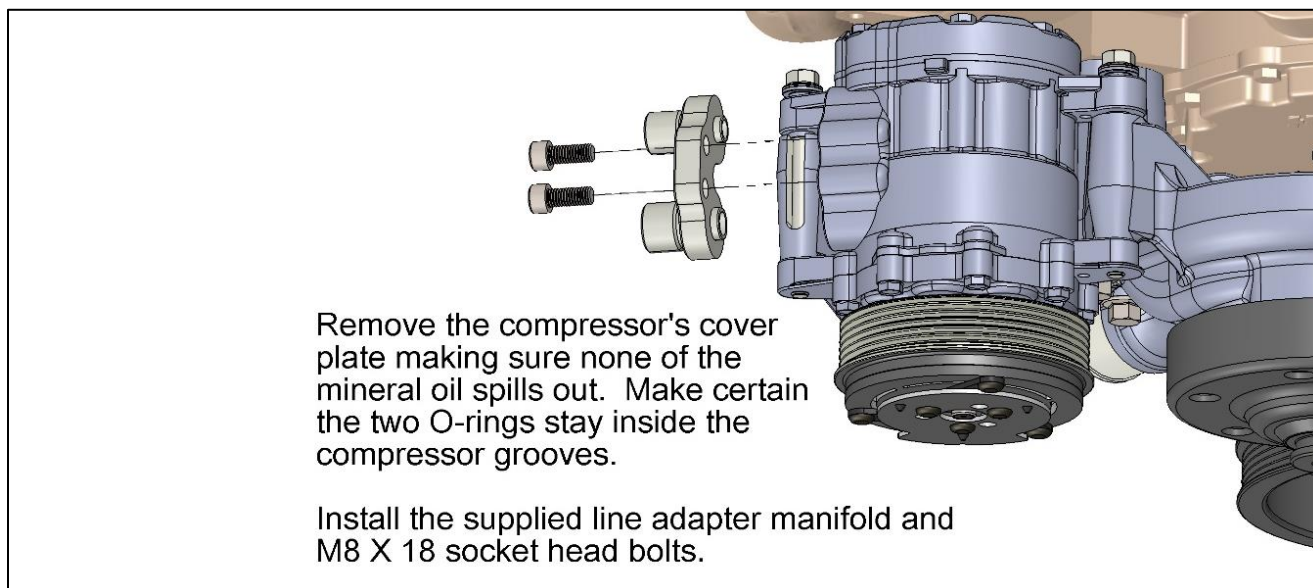
**HYDRO-BOOST BRAKE APPLICATIONS:** These applications often require an additional reservoir inlet. Use PS0001ERL and AT785010ERL adapters with either 198-211 or 198-212 Holley reservoirs for these applications.

### ***A/C Compressor Installation:***



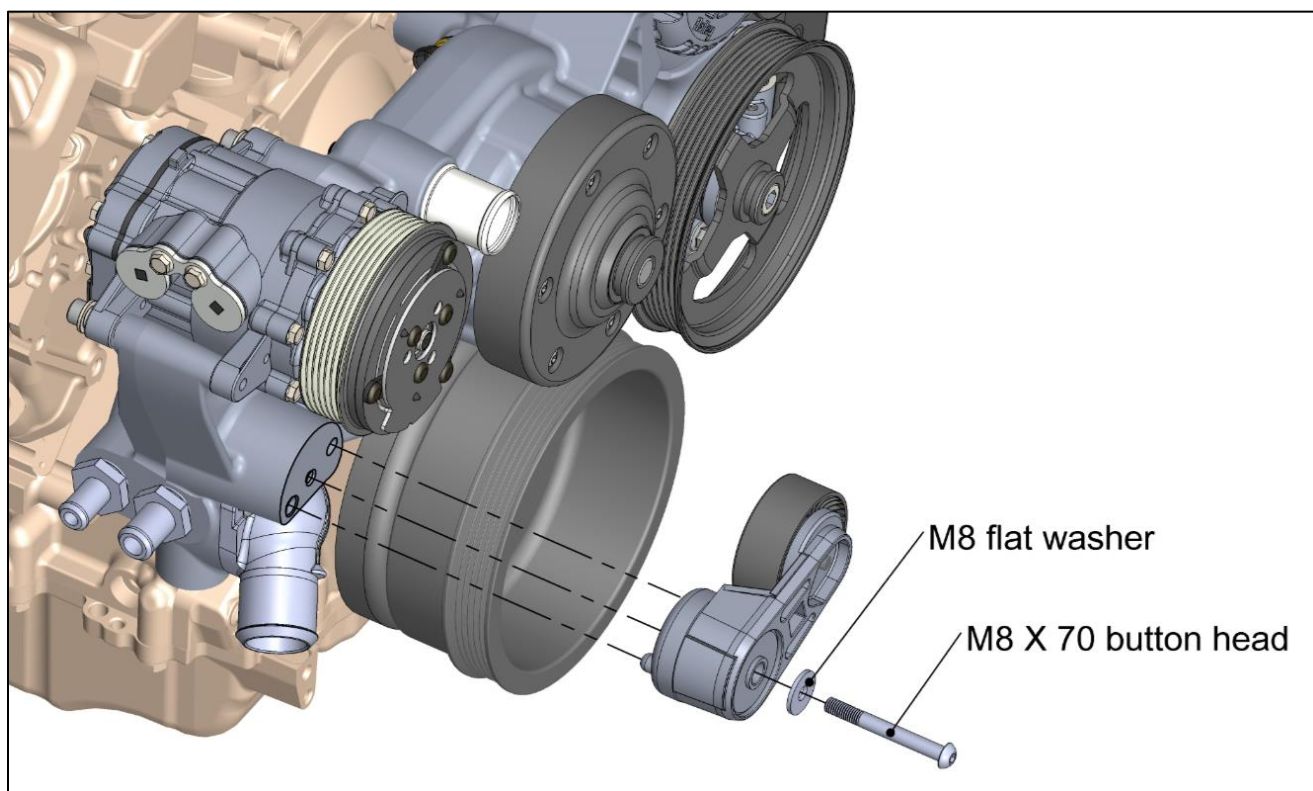
**NOTE:** After assembly torque M8 bolts to 18 ft./lbs.





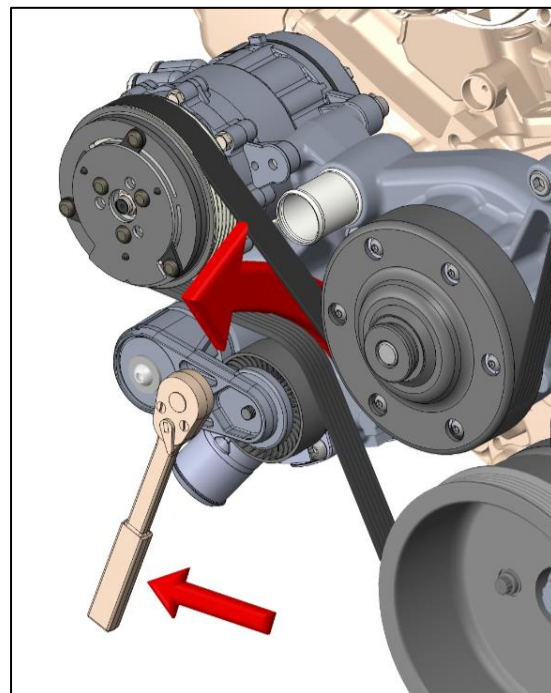
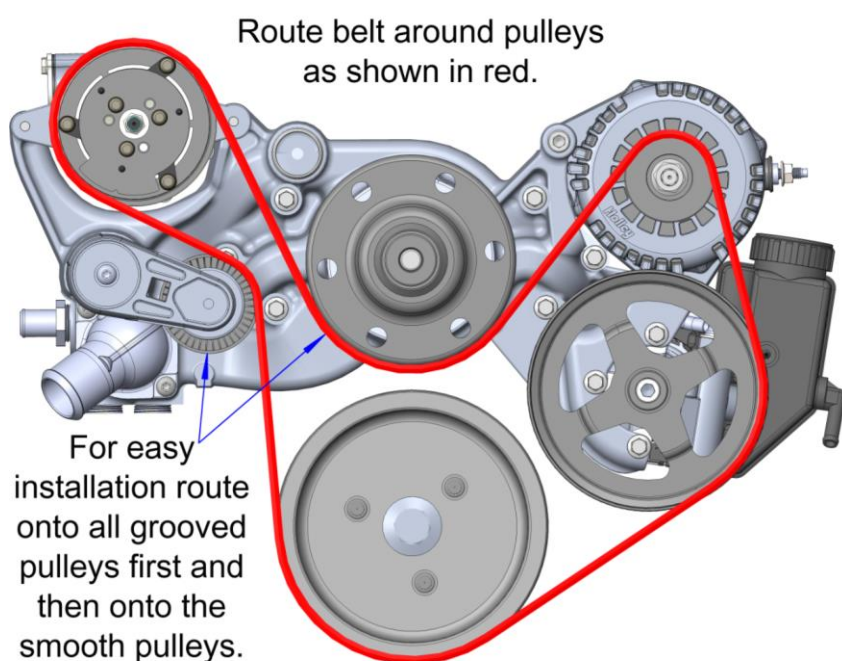
**NOTE:** Torque M8 bolts to 18 ft./lbs.

### ***Tensioner Installation:***



**NOTE:** Torque M8 bolt to 18 ft./lbs.

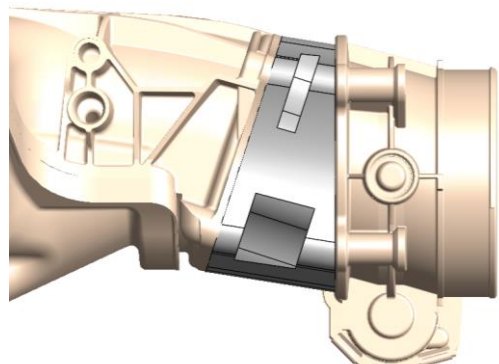
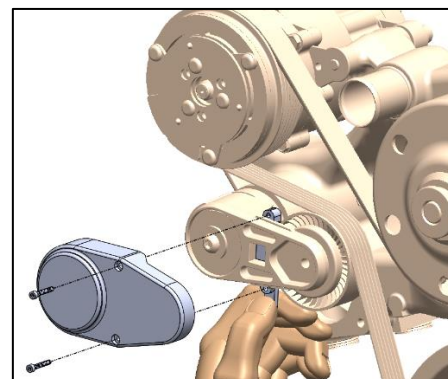
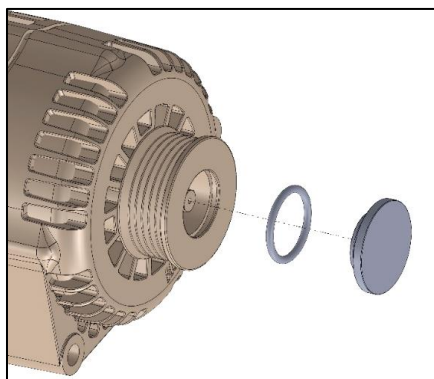
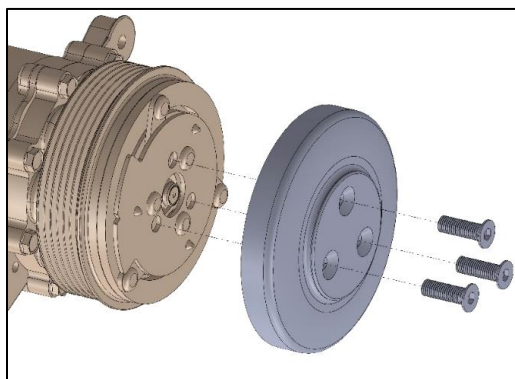
## **Belt Installation:**



After routing the belt use a 1/2" square drive wrench to pull the tensioner all the way down and work the belt on from the rear.

## **Accessory and Tensioner Covers:**

*(Cosmetic covers are included with some kits. If not included, these can be purchased individually. See instructions included with cover for installation procedures)*



### **Throttle Body Angle Correcting Adapter** **(LT applications only):**

The angle adapter is required when using an LT car style intake to prevent interference from the downward facing throttle body. See included instructions for installation procedures.

**199R11335**

**Revision Date: 11-15-21**





## OIL PAN P/N 302-3, 302-3BK, & 302-5



### Instruction Sheet 199R11351

**CONGRATULATIONS** on your purchase of a Holley® **LS Retro-fit Oil Pan**! We feel that you have purchased the finest performance oil pan manufactured today. Should you need information or parts assistance, please contact our Technical Service Department at 1-866-464-6553 or 1-270-781-9741, Monday through Friday, 8 a.m. to 6 p.m. CST. Please have the part number of the product you purchased on hand when you call.

**WARNING!** These instructions must be read and fully understood before beginning installation. Failure to follow these instructions may result in poor performance, vehicle damage, personal injury, or death. If these instructions are not fully understood, installation should not be attempted.

Requires use of Holley 302-15 Dipstick and Tube Kit or LS3 dipstick (GM P/N 12669528) and tube (GM P/N 12625031).

### INTRODUCTION:

Holley® Performance Products has written this instruction sheet for the installation of the **LS Retro-fit Oil Pan**. This instruction sheet contains all the information needed to install the oil pan. Please read all the **WARNINGS** and **NOTES**, as they contain valuable information that can save you time and money. Holley® Performance Products cannot and will not be responsible for any alleged or actual engine or other damage, or other conditions resulting from misapplication of the oil pan described herein. However, it is our intent to provide the best possible products for our customer; products that perform properly and satisfy your expectations.

### APPLICATIONS:

These Holley® LS Retro-fit oil pans are designed specifically for LS engine retrofit in 1967-69 F-body, 1982-92 F-body, 1968-74 X-body, 1964-72 A-body, 1978-88 A/G-body, 1979-2004 Ford Mustangs, or 1979-1986 Mercury Capri II vehicles. These oil pans may also service other popular muscle/classic car and truck chassis where more engine-to-chassis clearance is required near the front half of the oil pan.

### IMPORTANT APPLICATION NOTES:

- These pans provide OEM fitment and oil filter mounting provisions.
- These pans are not intended to be used with engines that originally utilized a dry sump system.
- May not be used on LS7 engines or engines with a stroke longer than 4.00".
- You have two options for which windage tray to use:

**1)** GM "F-body" windage tray, GM P/N 12558253. A modification to the windage tray is required to provide clearance to the pick-up tube. See the instructions showing the windage tray modifications required.

**OR**

**2)** A full-length windage tray may be used if the tray is shortened and also cut to provide clearance to the pick-up tube. See the instructions showing the windage tray modifications required.

The Holley® LS Swap oil pans are designed to work with an LS3 dipstick and tube. Below are the part numbers:

- LS Dipstick – GM P/N 12669528
- LS tube – GM P/N 12625031

**NOTE:** There are LS engine applications that have a plug installed in the dipstick hole location to be used with this oil pan. This plug will need to be removed before the oil pan is installed on the engine to allow the installation of the proper dipstick tube.

#### PAN CAPACITIES:

|                                      |         |
|--------------------------------------|---------|
| Sump Oil Capacity –                  | 5.6 Qts |
| Total Oil Capacity w/ stock filter – | 6.1 Qts |

#### PARTS NEEDED:

- Oil Pan Gasket (Mr. Gasket P/N 6665G, GM® 12612350, or equivalent)
- High Quality RTV sealer
- Oil
- Oil Filter (AC Delco® PF48 or PF48E, Mobile M1-113, Wix 57060, K&N HP-1017, or equivalent)
- Oil Pan Bolts (2 required – GM #12554990)

#### REMOVAL:

1. Drain the engine oil. Remove oil filter.
2. Remove the starter motor.
3. Disconnect the oil level sensor electrical connector (if equipped).
4. Remove the oil level sensor from the oil pan and set aside. The sensor will not be utilized in the Holley® pan.
5. Remove the RH transmission cover and bolt.
6. Remove the LH transmission cover and bolt.
7. Remove the bottom two transmission bellhousing bolts.
8. Remove the oil pan bolts.
9. Rotate the oil pan until it can be removed from around the oil pump pickup screen. Removal of the oil pan may not be possible with the engine in the vehicle).

**NOTE:** Holley® does not recommend or condone the use of the old pan gasket. A new gasket is highly recommended.

**WARNING!** Use extreme care when drilling the oil pan rivets to not gouge, score or damage the oil pan gasket.

10. If reusing the oil pan gasket, carefully drill out the oil pan gasket rivets (x2) if necessary (**Figure 1**).



**Figure 1**

11. Remove oil pan gasket.
12. Remove the oil pump pickup screen retaining bolt and nut.
13. Remove the oil pump pickup screen and O-ring, discard O-ring and set the pickup aside as it will not be re-used.
14. While the oil pan is removed, check the dipstick hole on the right side of the engine below cylinder #6 to assure that there is no plug installed and that the dipstick tube will fit in the hole.

**IMPORTANT:** Ensure that a helicoil has been installed in your pan by installing the drain plug.

**IMPORTANT:** All gasket surfaces should be free of oil or other foreign material during assembly. Inspect the engine block oil gallery passages to make sure they are free from any debris or restrictions.

**IMPORTANT:** The oil pan on LS engines is a structural member. The alignment of the pan is critical to provide the proper mounting points for the transmission bellhousing. The rear of the oil pan must never protrude from the rear of the block. The rear of the block and oil pan are to be flush (Figure 2).

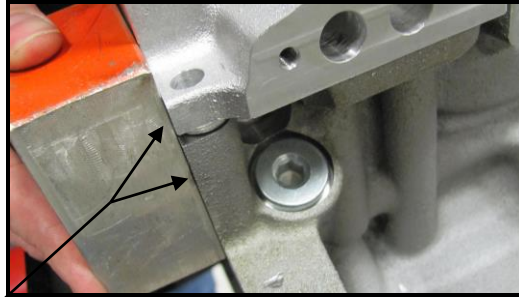


Figure 2

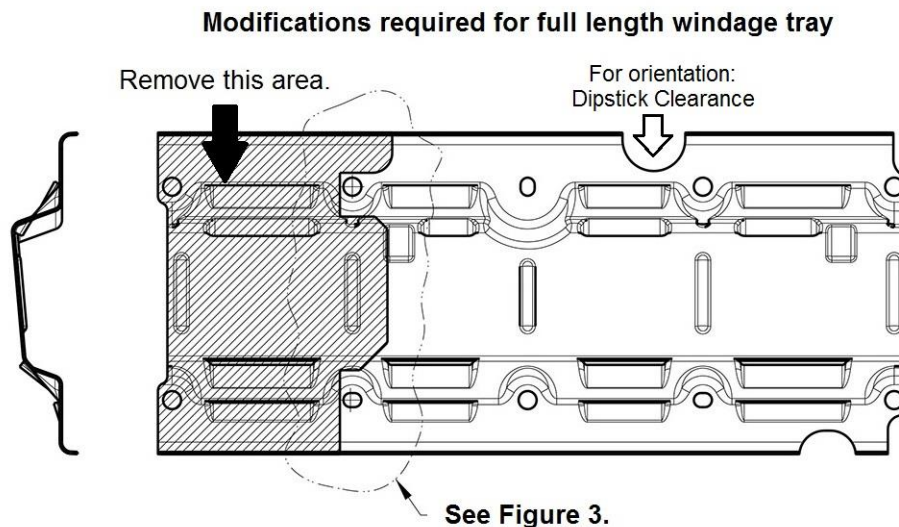
**IMPORTANT:** It is advisable to wash all of the new parts well before installing to remove any dirt or debris from the packing and shipping process.

**IMPORTANT:** It is advisable to test-fit the oil pan to the engine before installation to ensure that the crankshaft and connecting rods clear the windage tray, oil pump pick-up screen, and the oil pan, making a full revolution of the rotating assembly by hand.

**IMPORTANT:** It is advisable to mock up the engine and oil pan in the intended vehicle to ensure there is no contact of the pan to the frame or cross-members.

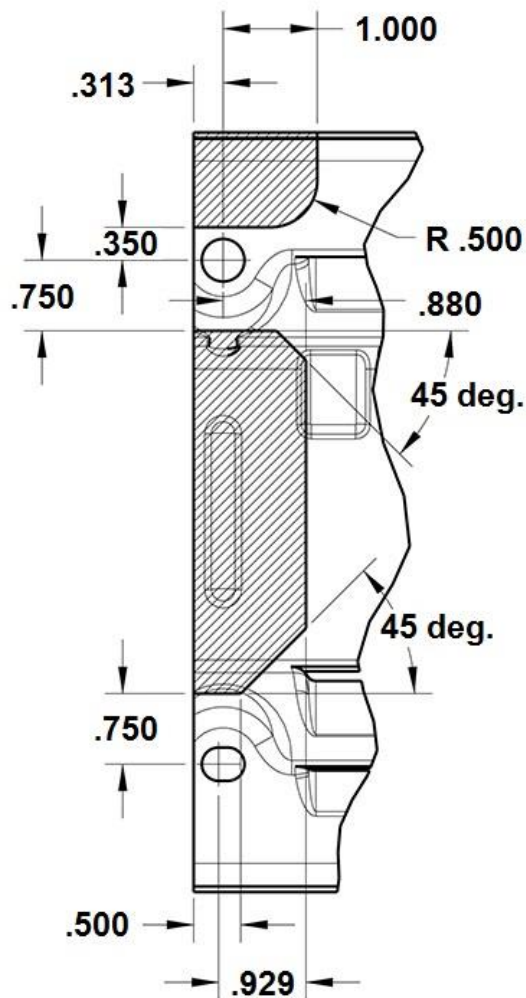
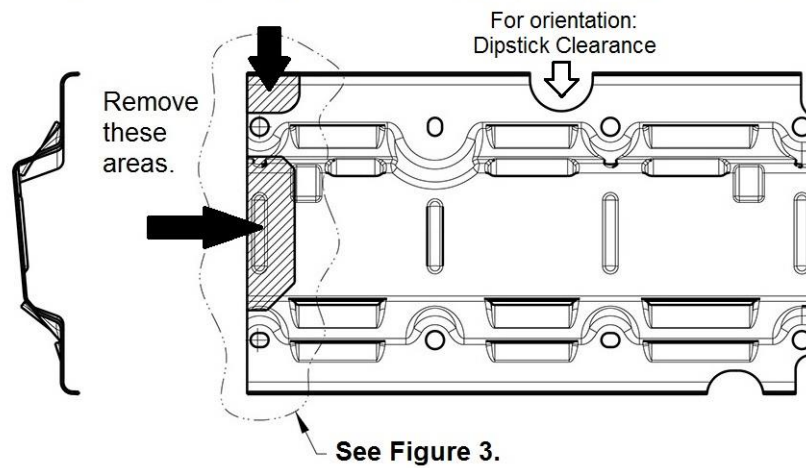
#### **WINDAGE TRAY MODIFICATIONS AND INSTALLATION:**

**IMPORTANT:** A modification to the windage tray must be made to provide clearance for both the oil pickup tube and a portion of the oil pan. The following drawings show how to modify the tray depending on which type you have. After modifications are made thoroughly clean, dry and reinstall the windage tray to the engine.





**Modifications required for F-body windage tray - GM P/N 12558253**



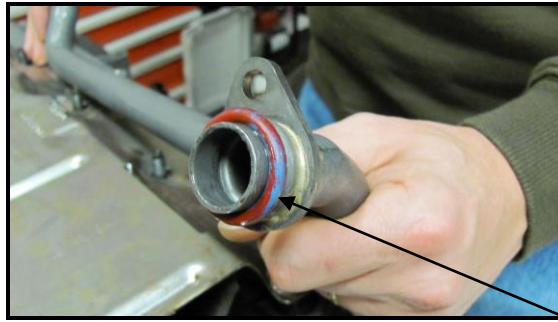
**Figure 3**

**INSTALLATION:**

1. Remove the new Holley® oil pan, parts kit, pickup screen and baffle from the box.

**IMPORTANT:** Ensure that a helicoil has been installed in your pan by installing the drain plug.

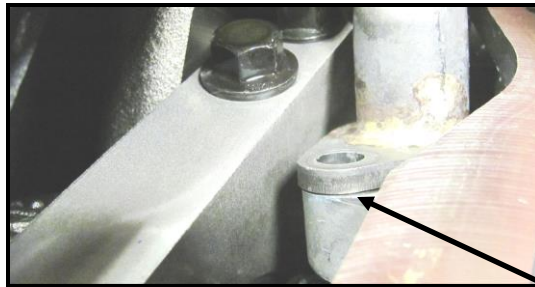
2. Install the supplied O-ring onto the oil pump pickup screen assembly and lubricate with clean engine oil (**Figure 4**).



**Figure 4**

3. Install the new Holley® oil pump pickup screen assembly ensuring that oil pump pickup screen tube is pushed completely into the oil pump before tightening the bolts (**Figure 5**). Do not allow the bolts to pull the tube into the pump. Attach using the two M6 x 16mm long flanged socket head capscrews included in the installation parts kit.

**NOTE:** Ensure the O-ring has not been pinched during installation.



**Figure 5**

4. Install the oil pump screen nut and bolt(s). You may need to slightly bend the tab to provide precise alignment of the hole in the tab to the mounting stud.
5. Rotate the crankshaft by hand to ensure there is adequate clearance between the pickup tube brace, oil deflector, and the crankshaft counterweights.
6. Tighten the oil pump pickup screen bolt(s) to 106 in./lbs. and the nut to 18 ft./lbs.
7. Pre-assemble the oil pan.
8. Apply a drop of blue Loctite® to the threads of the (x4) supplied 1/4-20 x 1/2 long cap screws and use them to install the baffle into the oil pan. Torque the (x4) baffle bolts to 8-10 ft./lbs.
9. Install the supplied oil passage cover, gasket and M6 x 1.0 x 30mm long bolts to the oil pan just above the oil filter. Tighten the oil passage cover bolts to 106 in./lbs.
10. Install the new oil pan gasket to the oil pan and install the oil pan bolts to the pan through the gasket. The gasket is designed to hold the bolts in place.
11. Apply a 5mm bead of RTV sealant 20mm long to the engine block (**Figure 6**) directly onto the tabs of the front cover gasket that protrude into the oil pan surface.



**Figure 6**



**Figure 7**

12. Apply a 5mm bead of RTV sealant 20mm long to the engine block (**Figure 7**) directly onto the tabs of the rear cover gasket that protrude into the oil pan surface.
13. Install the oil pan assembly to the engine block.
14. Snug all the oil pan bolts by hand (do not overtighten).
15. Install the two lower transmission bellhousing bolts until snug (do not overtighten).
16. Tighten the oil pan to block and oil pan to front cover bolts to 18 ft./lbs. (work from the center out).
17. Tighten the oil pan to rear cover bolts to 106 in./lbs.
18. Tighten the two transmission bellhousing-to-oil pan bolts to 37 ft./lbs. for either a manual or an automatic transmission.
19. Install the LH side transmission cover and bolt. Torque to 106 in./lbs. Install the RH side transmission cover and bolt. Torque to 106 in./lbs.
20. Install the supplied oil pan drain plug and tighten to 18 ft./lbs.
21. Install the supplied oil filter adapter and tighten to 40 ft./lbs.
22. Before installing the new oil filter, apply a thin film of oil to the filter gasket. Install the new engine oil filter and follow the manufacturer's recommendation for tightening procedures.
23. Fill the crankcase with the proper quantity and grade of oil.
24. Be careful not to overfill with oil.
25. Start the vehicle and check for leaks and adequate oil pressure. Use the original dipstick to verify the oil level. This should read full after 6 quarts of oil with a new filter.

**Holley® Technical Support**  
**866-464-6553**  
**www.holley.com**

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**199R11351**

**Revision Date: 10-11-21**





**P/N 12628HKR**

**GM 1967-69 F-Body/1968-72 X-Body LS Swap Powerglide\*/TH350\*/7004R\* Transmission Adapter Kit**

\*Requires the use of a Hooker 12625HKR 4L60-4L75 transmission crossmember

**P/N 12650HKR**

**TH400 / 2004R Transmission Mount Adapter Kit**

**Installation Instructions 199R10685**

Thank you for choosing to use Hooker Blackheart products as part of your engine/transmission swap project. These products are designed as part of the most comprehensively engineered systems of mounting components, headers, and exhaust systems available for LS engine swaps. Hooker Blackheart LS swap systems are designed to decrease your total swap installation effort and cost while increasing the engineered quality of your vehicle and compatibility of these components with other popular aftermarket components.

**IMPORTANT DESIGN AND PRE-INSTALLATION INFORMATION:**

These components have been designed for use in multiple Hooker Blackheart LS engine swap system applications. They have been CAD designed and FEA validated to provide optimized strength and fitment geometry for each application they are called out to be used with.

Installation of these products requires the use of a **Prothane™ 7-1604** poly mount, or an **Anchor™ 2268** rubber transmission mount for as-designed installation geometry to be achieved.

Use of the 12628HKR adapter kit with a 12625HKR 4L60-4L70 crossmember to install a Powerglide, TH350 or 700R4 transmission into an LS swapped GM 1<sup>st</sup>-gen F-body/3<sup>rd</sup>-gen F-body (using Hooker Blackheart 12618HKR LS swap engine brackets only) requires modifications (cutting and welding) be performed on the 12625HKR crossmember to complete the installation. The increased exhaust passage and ground clearance gained by using the 12625HKR crossmember as part of your LS swap project will more than justify the extra effort required for this operation.

Use of the 12650HKR spacer block kit with a 12626HKR T56 crossmember to install a 2004R transmission into an LS swapped GM 1<sup>st</sup>-gen F-body/3<sup>rd</sup>-gen X-body (using Hooker Blackheart 12618HKR LS swap engine brackets only) requires slight modification/welding to be done to the 12626HKR crossmember to fit around the case and pan of a 2004R transmission. The steel gusset bracket included within the 12650HKR kit is intended for this purpose and its use is outlined in these instructions. The increased exhaust passage and ground clearance gained by using the 12626HKR crossmember as part of your LS swap project will more than justify the extra effort required for this operation.

Use of the 12650HKR spacer block kit with any other Hooker Blackheart transmission crossmember to install a 2004R or TH400 transmission will not require any modifications to be done to the crossmember, or the use of the steel gusset bracket included in the 12650HKR adapter kit. Discard the gusset bracket in such cases.

These instructions are intended to supplement the basic installation steps outlined in various Hooker Blackheart transmission crossmember instruction sheets that call out the use of these parts. The drawings below can be seen in color by going to [www.holley.com](http://www.holley.com) and searching for either 12628HKR or 12650HKR.

**INSTALLATION OF 12628HKR**

1. Check that the hardware package includes the following:

| Qty. | Description              | Qty. | Description |
|------|--------------------------|------|-------------|
| 1    | Adapter Bracket Assembly | 2    | 7/16" Nuts  |
| 2    | 7/16" Bolts              |      |             |

If any are missing, please contact Technical Service at 1-866-464-6553 or 270-781-9741.

2. Cut a notch as wide as the 12628HKR bracket into the front of the 12625HKR crossmember. Place the notch in the center of the crossmember and cut it back 1-1/8" from the face of the crossbeam front flange (**Figure 1**).
3. Attach the bracket to the crossmember placing the supplied bolts and nuts in the holes that pass through both the bracket and crossmember (**Figure 2**).
4. If you are using this kit to install a 700R4 transmission, trim the front of the bracket off so that it is even with the front edge of the bracket gusset plate (**Figure 2**) and slightly notch the top edges of the upright crossmember gussets to clear the isolator mount base plate (**Figure 3**). If you are using this kit to install a Powerglide or TH350, leave the bracket length as-is, as you will be attaching the transmission mount to the forward set of holes in the bracket.
5. Once notching/clearancing is complete, clean parts and weld them together using either a MIG or TIG welder (**Figure 2**) and spot-paint as desired to match.

6. Install the crossmember per the instructions contained in its packaging.

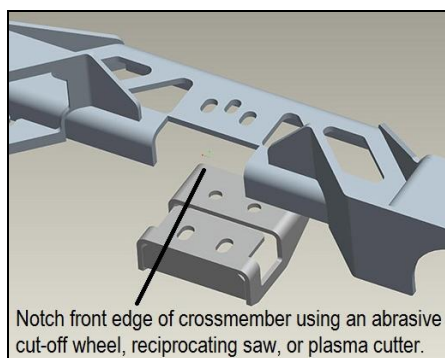


Figure 1

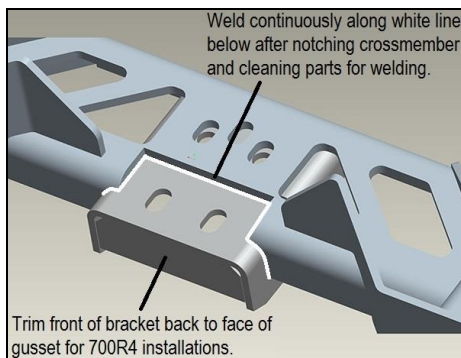


Figure 2

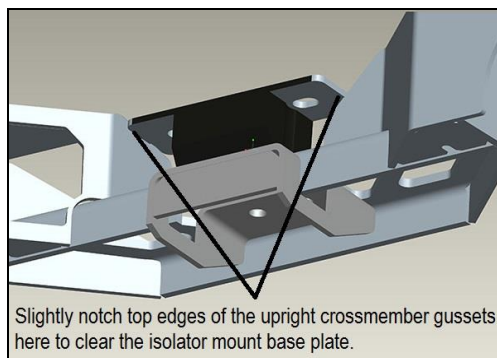


Figure 3

## INSTALLATION OF 12650HKR

1. Check that the hardware package includes the following:

| Qty. | Description           | Qty. | Description   |
|------|-----------------------|------|---------------|
| 1    | Aluminum Spacer Block | 2    | 7/16" Bolts   |
| 1    | Steel Gusset Bracket  | 2    | 7/16" Washers |

If any are missing, please contact Technical Service at 1-866-464-6553 or 270-781-9741.

2. If you are using this spacer block kit to install a 2004R into a GM 1<sup>st</sup>-gen F-body or 3<sup>rd</sup>-gen X-body using the Hooker Blackheart 12626HKR T56 crossmember, modify/cut the inside left upright wall of the crossmember to match what is shown in **Figures 4 and 5** below. Once modifications are complete, clean parts and weld them together using either a MIG or TIG welder, as indicated in **Figure 6** below and spot-paint as desired to match. Install the crossmember per the instructions contained in its packaging while installing the spacer block included in this kit between the crossmember and transmission isolator. Use the included long fasteners to attach the transmission mount to the crossmember.

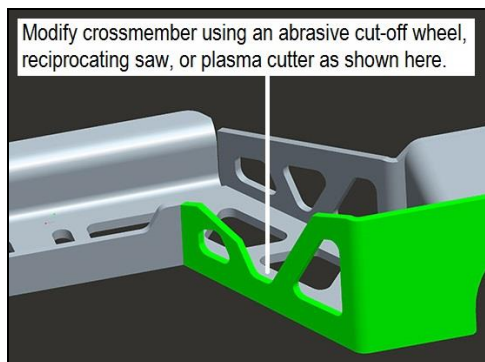


Figure 4

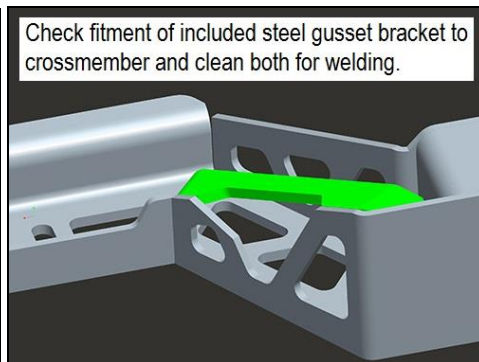


Figure 5

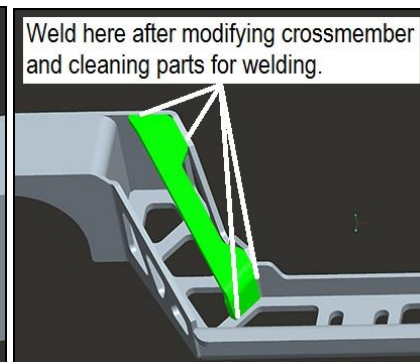


Figure 6

3. If you are using this spacer block kit and a Hooker Blackheart transmission crossmember to install a 2004R or TH400 transmission into any other vehicle besides a GM 1<sup>st</sup>-gen F-body or 3<sup>rd</sup>-gen X-body, do not modify the crossmember in any way. Install the crossmember per the instructions contained in its packaging while installing the spacer block included in this kit between the crossmember and transmission mount. Use the included long fasteners to attach the transmission mount to the crossmember. Discard the included gusset bracket as it is not needed in these applications.

Any questions? Please contact Technical Service: 1-866-464-6553 or 270-781-9741. For online help, please refer to: [www.holley.com](http://www.holley.com).

### LIMITATION OF LIABILITY – DISCLAIMER:

HOOKER™ makes no warranties of merchantability, of fitness for particular purpose, or that its products are approved for general use, or that its products comply with laws, regulations, or ordinances in the state where they may be sold to the ultimate purchaser, the consumer. Unless expressly stated to the contrary in the catalog, instruction sheet; or price list, the entire risk as to the conformity of any company product in any such state and as to repair should the product prove to be defective or non-conforming, is on the retail purchaser, the buyer, the ultimate consumer, of such product and it is not upon the seller, distributor, or manufacturer. In this connection, the retail purchaser, the buyer, the ultimate consumer assumes the burden of the entire cost of any and all necessary service, alterations, or repair.

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199R10685

Revision Date: 8-22-18



**Hooker Transmission Crossmember Spacer Block Kit  
12657HKR  
Installation Instructions**



Thank you for choosing to use this Hooker product as part of your LS swap project. This component has been designed specifically for use with multiple Hooker LS swap transmission crossmembers, as referenced on Holley's website, and within various Hooker transmission crossmember instruction sheets.

Installation of these products requires the use of an **Energy Suspension™ 3-1158** poly mount, a **Prothane™ 7-1604** poly mount, or an **Anchor™ 2268** rubber transmission mount for as-designed installation geometry to be achieved.

**PRE-INSTALLATION CONSIDERATIONS:**

Attachment bolts needed to connect the transmission mount to the crossmember are not included and are to be user sourced.

**CAUTION! WORK ONLY ON A LEVEL SURFACE. USE JACKS /JACK STANDS OF SUFFICIENT CAPACITY TO LIFT AND SUPPORT YOUR VEHICLE. NEVER WORK UNDER A VEHICLE SUPPORTED BY A FLOOR OR BUMPER JACK.**

**INSTALLATION:**

**NOTE:** These instructions have been written with the assumption that your transmission and Hooker transmission crossmember has been installed into the vehicle.

1. Check that the hardware package includes the following:

(1) Machined aluminum spacer

If any are missing, please contact Technical Service at 1-866-464-6553 or 270-781-9741.

2. Raise the rear of your transmission and install this spacer block, and any other supplemental spacer(s) called out for in specific Hooker transmission crossmember instruction sheets, between the transmission crossmember and the transmission isolator mount.
3. Attach the transmission mount, spacer, and crossmember together with user-supplied hardware of your choice (Grade 8 recommended).

**LIMITATION OF LIABILITY – DISCLAIMER:**

The regulation of emissions production, noise levels, and safety standards is undertaken by the federal government, each of the fifty state legislatures, and by many local municipalities, towns, and counties.

HOOKER™ makes no warranties of merchantability, of fitness for particular purpose, or that its products are approved for general use, or that its products comply with laws, regulations, or ordinances in the state where they may be sold to the ultimate purchaser, the consumer.

Unless expressly stated to the contrary in the catalog, instruction sheet; or price list, the entire risk as to the conformity of any company product in any such state and as to repair should the product prove to be defective or non-conforming, is on the retail purchaser, the buyer, the ultimate consumer, of such product and it is not upon the seller, distributor, or manufacturer.

In this connection, the retail purchaser, the buyer, the ultimate consumer assumes the burden of the entire cost of any and all necessary service, alterations, or repair.

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**199R11211**

**Revision Date: 1-18-18**



**1968-1972 GM A-BODY LS ENGINE SWAP HEADERS  
70101318-RHKR (1-7/8") & 70101319-RHKR (1-3/4")  
Installation Instructions**



Thank you for purchasing/using a Hooker Blackheart brand product. These headers are part of the complete Hooker Blackheart LS engine swap solution for 1968-72 GM A-body vehicles. These instructions have been written with the assumption that you have already installed an LS engine and transmission into your A-body vehicle using associated Hooker Blackheart engine mounting brackets.

Automotive work can be dangerous. Work only on a clean, dry and level surface and use lifting/supporting equipment specifically designed for automotive work. If you are unsure of your capability, or that of your equipment, seek professional assistance to install these components.

These headers are designed for off-road/competition use only and carry no CARB E.O. exemption to permit legal installation/use on pollution controlled motor vehicles.

**NOTE:** An O2 bung is included on each header collector for providing O2 sensor compatibility/operation. The beyond-horizontal clocked position of the bungs will provide reliable use of wide-band O2 sensors, if desired. Trimming the 4L80/4L85 transmission case bell housing inspection cover mounting flanges, and the cover itself, flush with the sides of the LS engine will reduce the effort required to R&R these transmissions from the vehicle in the future. At a minimum, the tip of the left side ears of the bellhousing and inspection cover of 4L80/4L85 transmissions will need to be trimmed off (approximately 3/4") to provide compatibility with these headers.

## **BEFORE BEGINNING...**

Check that the hardware package includes the following:

| Qty. | Description            |
|------|------------------------|
| 12   | M8 x 1.25 Header Bolts |

If you are missing any hardware, please contact Technical Support at 1-866-464-6553 or 270-781-9741.

## **INSTALLATION:**

1. Disconnect the negative terminal on the battery, if connected.
2. Remove the spark plug wires, spark plugs, and engine oil dipstick/tube from the engine.
3. Working from the bottom of the car, place a stock (new or used) GM multi-layer steel manifold gasket between the left side header assembly and the cylinder head. Attach the header assembly to the cylinder head with (x6) supplied header bolts. Tighten the bolts to approximately 15 ft./lbs.



4. Place a stock (new or used) GM multi-layer steel manifold gasket between the right side header assembly and the cylinder head. Attach the header assembly to the cylinder head with the remaining (x6) supplied header bolts. Tighten the bolts to approximately 15 ft./lbs.
5. Reinstall/re-connect the spark plugs, plug wires, engine oil dipstick/tube, and negative battery cable.

### **COMPATIBILITY INFORMATION:**

These headers are installable/compatible with all GM TH350, TH400, 700R4, 2004R, 4L60E-4L70E and 4L80E/4L85E automatic or Tremec OE LS 4<sup>th</sup>-gen F-body T56 and aftermarket T56 Magnum manual transmissions.

These headers are designed for installation with Hooker Blackheart LS engine swap brackets and 2.5" and 3" dual exhaust system co-developed for this vehicle application. Factory column shift linkage may require modifications to enable compatibility with these headers; an aftermarket column shift linkage rod, such as those available from Lokar, may be preferable/required for use in column-shift applications.

### **LIMITATION OF LIABILITY – DISCLAIMER:**

The regulation of emissions production, noise levels, and safety standards is undertaken by the federal government, each of the fifty state legislatures, and by many local municipalities, towns, and counties.

HOOKER™ makes no warranties of merchantability, of fitness for particular purpose, or that its products are approved for general use, or that its products are approved for general use, or that its products comply with laws, regulations, or ordinances in the state where they may be sold to the ultimate purchaser, the consumer.

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In this connection, the retail purchaser, the buyer, the ultimate consumer assumes the burden of the entire cost of any and all necessary service, alterations, or repair.

### **THE FOREGOING STATEMENT LIMITS THE LIABILITY OF THE MANUFACTURER.**

California vehicle code, sections 27156 and 38391, prohibits the advertising, offering for sale, or installation of any device, which modifies a vehicle's emission control system, unless exempted, unless otherwise noted. HOOKER™ Headers that have not received an Executive Order (E.O.) exemption from these code sections are not legal for sale or use in California on vehicles originally equipped with catalytic converters, except for racing vehicles, which may never be driven upon a highway. Check with your local authorities to determine if these headers are legal for use in your particular area.

**Technical Service: 1-866-464-6553**

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**199R10920**

**Revision Date: 4-24-20**



## 1968-1972 GM A-BODY 2-DOOR\* EXHAUST SYSTEMS

\*Excluding El Camino: fits 112" wheelbase 2 door hardtop, 2-door post and convertible models only  
70501353-RHKR (2.5") & 70501354-RHKR (3")

### Installation Instructions



Left Right  
Front over-axle hangers



Rear tailpipe hangers (left & right)

Thank you for choosing to install a Hooker Blackheart exhaust system on your 1968-72 GM A-body vehicle. Although these systems have been specifically developed for direct fitment with Hooker Blackheart LS swap components for these applications, they will provide equally beneficial fitment, function, and service life with other non-Hooker Blackheart LS swap headers or non-LS engine equipped A-bodies through modification of the system inlet tubes, or construction of new ones, by a competent fabricator.

### PRE-INSTALLATION CONSIDERATIONS:

Check that the hardware package includes the following:

| 70501353-RHKR |                              |
|---------------|------------------------------|
| Qty.          | Description                  |
| 2             | Tailpipe Hanger Brackets     |
| 1             | Left Muffler Hanger Bracket  |
| 1             | Right Muffler Hanger Bracket |
| 2*            | 5/16 x 1.25" Body Bolts      |
| 2*            | 3/8 Thick Spacers            |
| 4*            | 1/4-20 x .75" Bolt           |
| 4*            | 1/4-20 Flanged Head Nut      |
| 4*            | 1/2-13 x 1.75" Cap Screw     |
| 4*            | 1/2-13 Locking Nut           |
| 4*            | Rubber Isolators             |
| 10*           | 2.5" Band Clamps             |

| 70501354-RHKR |                              |
|---------------|------------------------------|
| Qty.          | Description                  |
| 2             | Tailpipe Hanger Brackets     |
| 1             | Left Muffler Hanger Bracket  |
| 1             | Right Muffler Hanger Bracket |
| 2*            | 5/16 x 1.25" Body Bolts      |
| 2*            | 3/8 Thick Spacers            |
| 4*            | 1/4-20 x .75" Bolt           |
| 4*            | 1/4-20 Flanged Head Nut      |
| 4*            | 1/2-13 x 1.75" Cap Screw     |
| 4*            | 1/2-13 Locking Nut           |
| 4*            | Rubber Isolators             |
| 10*           | 3" Band Clamps               |

\*Items not shown in photos above

If any listed hardware is missing, please contact Technical Service at: 1-866-464-6553 or 270-781-9741.

**IMPORTANT!** Position and support your vehicle on a suitable surface. **USE CAUTION AND WORK ONLY ON A LEVEL SURFACE USING JACKS AND JACK STANDS OF SUFFICIENT CAPACITY TO LIFT AND SUPPORT YOUR VEHICLE. NEVER WORK UNDER A VEHICLE SUPPORTED BY A FLOOR OR BUMPER JACK.** Use of a two-post under arm lift or four-post drive-on lift will considerably reduce the time and effort required to complete the installation. **MAKE SURE LIFT LOCKS ARE ENGAGED BEFORE WORKING UNDER THE VEHICLE.**

## **INSTALLATION:**

**NOTE:** The following steps assume that you are installing the system using Hooker Blackheart LS swap mounting components and long-tube headers or mid-length headers and adapters already in place on the vehicle. If you are performing an installation of this system without utilizing these products, install all system components from the “X” crossover rearward. Then, adjust them for best fitment with the bottom of the floor panels and sufficient clearances around all suspension, fuel, and brake components. Do all this before modifying the included Hooker Blackheart inlet tubes, or fabricating new inlet tubes to be compatible with the geometry of your headers and transmission crossmember.

1. Remove all existing exhaust system components from the vehicle, including any stock or previously added hangers along the entire length of the exhaust system.
2. Raise and support the vehicle in a manner that allows full drop of the rear axle/suspension.
3. Place a supplied band clamp over each inlet of the crossover assembly and insert the supplied inlet tubes (right side tube has a single bend in it) into the crossover assembly.
4. Now, position a supplied clamp over the open end of each inlet tube and install the entire assembly onto the collectors of a previously installed set of Hooker Blackheart LS swap full-length headers, or the outlets of Hooker Blackheart adapter tubes already attached to a set of Hooker Blackheart mid-length headers or Hooker LS swap cast iron exhaust manifolds.
5. Place a supplied clamp over one end of each muffler and install the mufflers onto the outlets of the crossover assembly. To ensure proper final adjustment, tighten the clamps only enough to maintain the general position of the mufflers at this time.
6. Using the included 5/16" body bolts and 3/8 thick spacers, attach the included left and right front over-axle hanger brackets to the bottom flange of the vehicle frame crossmember in front of the rear axle. Use two factory hanger holes located along the bottom edge of the crossmember for attachment. Install the spacers between the brackets and the bottom of the crossmember. See **Figures 1 & 2** for proper bracket orientation.



**Figure 1 – Left over-axle hanger bracket**



**Figure 2 – Right over-axle hanger bracket**

7. Feed the supplied over-axle tubes over the front side of the axle and place a supplied clamp over the inlet of each before engaging them into the muffler outlets. To ensure correct adjustment later, do not tighten the clamps more than what is required to hold basic component positions at this time.
8. Install one supplied rubber isolator onto the barbed hanger rods of each over-axle tube and connect the other end of the isolators to the installed hanger brackets using one each of the supplied 1/2 bolts and nuts for each bracket. See **Figures 3 & 4**.
9. Using the supplied 1/4" bolts and nuts, attach the supplied tailpipe hanger brackets to the outside of the frame rails at the location of the two small vertically stacked 1/4" factory holes on the outside of each frame rail behind the rear tires.. See **Figures 5 & 6** for proper bracket orientation (images shown depict right side frame rail and hanger bracket orientation – left side bracket orientation/ installation is mirrored in a similar fashion).



**Figure 3 – Left tailpipe hanger bracket**



**Figure 4 – Right tailpipe hanger bracket**



**Figure 5 – Right side frame attachment holes**



**Figure 6 – Right tailpipe hanger bracket orientation**

10. Install the remaining two rubber isolators onto the hanger rods welded to each tailpipe. Place the remaining two supplied band clamps over the slip-connector inlets of the tailpipes.
11. Install the tailpipes onto the outlets of the over-axle pipes and engage the rubber isolators on the hanger rods into the U-channel of the tailpipe hanger brackets just attached to the frame rails. Connect the isolators and brackets together using one each of the included 1/2" bolts/nuts for each hanger bracket.
12. Tighten the band clamps enough to hold them in place on the slip-connectors, but not so tight as to prevent component adjustment.
13. Align all system components for best fit and fully tighten all clamps. The rear tailpipe hanger attachment holes are slotted specifically to allow fine adjustment of the tailpipe tip exit heights. Pay particularly close attention to the clearances between the over-axle tubes and the rear suspension upper control arms and coil springs. This is especially important when installing the 3" system to prevent component interference and unwanted noises.

**NOTE:** These exhaust systems are designed for use with two different sets of Hooker Blackheart LS swap engine brackets. If you are using the **71221006HKR** engine mounting brackets, the inlet pipes of these exhaust systems are to be engaged no more than two inches onto the outlets of Hooker Blackheart LS swap long-tube headers or Hooker Blackheart mid-length header or cast iron manifold adapter tubes. Using more than two inches of engagement at these connection points will cause other slip-connection points in the system to not have sufficient engagement for proper sealing and/or mechanical strength.

Any questions? Please contact Technical Service: 1-866-464-6553 or 270-781-9741. For online help, please refer to: [www.holley.com](http://www.holley.com).



## **COMPATIBILITY INFORMATION:**

These exhaust systems were designed for direct installation with compatible Hooker Blackheart LS swaps headers and engine and transmission mounting components listed for this vehicle application. If needed, additional compatible LS engine swap components, such as EFI fuel control systems, fuel filters, fuel pumps, plumbing hose/fittings, valve covers and accessory drive brackets can be found at [www.holley.com](http://www.holley.com).

As shipped, the bend geometry of this system's inlet tubes (forward of the crossover) is compatible with the stock 68-72 Chevelle and Hooker Blackheart LS swap transmission crossmembers and Hooker Blackheart headers for this application only. As such, interference with other aftermarket transmission crossmembers and/or poor line-up characteristics with other brands of headers should be expected. Such issues can be remedied through modification of the supplied Hooker Blackheart inlet tubes, or the fabrication of new inlet pipes, to provide compatibility with the components installed on your vehicle.

These Hooker Blackheart exhaust systems are compatible with driveshafts up to 3.5" in diameter and have been verified to be compatible with factory OE, Hotchkis, Hellwig, and Detroit Speed rear anti-sway bar kits.

## **LIMITATION OF LIABILITY – DISCLAIMER:**

The regulation of emissions production, noise levels, and safety standards is undertaken by the federal government, each of the fifty state legislatures, and by many local municipalities, towns, and counties.

HOOKER™ makes no warranties of merchantability, of fitness for particular purpose, or that its products are approved for general use, or that its products comply with laws, regulations, or ordinances in the state where they may be sold to the ultimate purchaser, the consumer.

Unless expressly stated to the contrary in the catalog, instruction sheet; or price list, the entire risk as to the conformity of any company product in any such state and as to repair should the product prove to be defective or non-conforming, is on the retail purchaser, the buyer, the ultimate consumer, of such product and it is not upon the seller, distributor, or manufacturer.

In this connection, the retail purchaser, the buyer, the ultimate consumer assumes the burden of the entire cost of any and all necessary service, alterations, or repair.

## **THE FOREGOING STATEMENT LIMITS THE LIABILITY OF THE MANUFACTURER.**

California vehicle code, sections 27156 and 38391, prohibits the advertising, offering for sale, or installation of any device, which modifies a vehicle's emission control system, unless exempted, unless otherwise noted. HOOKER™ Headers that have not received an Executive Order (E.O.) exemption from these code sections are not legal for sale or use in California on vehicles originally equipped with catalytic converters, except for racing vehicles, which may never be driven upon a highway. Check with your local authorities to determine if these headers are legal for use in your particular area.

**Technical Service: 1-866-464-6553**

**Phone: 1-270-781-9741**

**For online help, please refer to the Tech Service section of our website: [www.holley.com](http://www.holley.com)**

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**199R10966**

**Revision Date: 4-24-20**



## 1968-1972 GM A-Body LS Swap Engine Mounting Brackets 71221006HKR & 71221007HKR Installation Instructions



Thank you for choosing to use Hooker Blackheart engine swap mounting brackets as part of your LS swap project. These mounting brackets are part of the most comprehensively engineered system of mounting components, headers and exhaust systems available for this application. Please read these instructions thoroughly before attempting installation.

### **PRE-INSTALLATION CONSIDERATIONS:**

**Successful installation of an LS engine using these components is more highly ensured by installing new body bushings prior to installation of these components.**

Installation of these engine mounting brackets requires the use of 1998-2002 GM Camaro/Firebird LS1 engine motor mounts. GM replacement rubber mounts (part number 22179268) or Hooker Blackheart polyurethane motor mounts – 71221018HKR clamshell housings and 71221016HKR (black) or 71221017HKR (red) inserts are recommended. Aftermarket poly motor mount inserts from other sources have been found to deviate from factory design specifications and will cause installation issues.

The long horizontally installed through bolts/nuts that couple the engine mounts to the Hooker Blackheart engine brackets are to be user supplied. Stock GM bolts/nuts or the Hooker Blackheart 71223015HKR hardware kit are recommended to be used.

### **COMPATIBILITY INFORMATION:**

When used with a stock 68-72 Chevelle transmission crossmember, or the Hooker Blackheart **71222007HKR** transmission crossmember, each of these engine swap mounting bracket sets will provide the most geometrically optimized LS engine/transmission mounting solution available for this vehicle platform.

These engine swap mounting bracket kits are designed for use with a Holley® **302-2** or **302-3** oil pans and have been validated to be compatible with the following engine accessory drive systems and vehicle components:

**71221006HKR Forward-Bias Engine Brackets** – **Holley** or stock **Corvette** (excluding the A/C compressor/bracket, which must be relocated), **Truck** (must use smaller 5" diameter power steering pump pulley and stock Denso A/C compressor without rear pressure sensor), **F-body/GTO** (excluding the alternator, which must be relocated) FEAD systems. These brackets **ARE** compatible for use with the stock vehicle A/C evaporator case.

**71221007HKR Rear-Bias Engine Brackets** – **Holley** or stock **F-body/GTO** (GTO alternator not compatible, must be relocated or replaced with an F-body alternator), **Corvette** (excluding the A/C compressor/bracket, which must be relocated), or **Truck** (must use smaller 5" diameter power steering pump pulley and stock Denso A/C compressor without rear pressure sensor) FEAD systems. These engine brackets **ARE NOT** compatible for use with the stock vehicle A/C evaporator case.

Additional LS engine swap/performance components, such as accessory drive brackets, EFI fuel control systems, fuel filters, fuel pumps, plumbing hose/fittings, and valve covers can be found at [www.holley.com](http://www.holley.com).

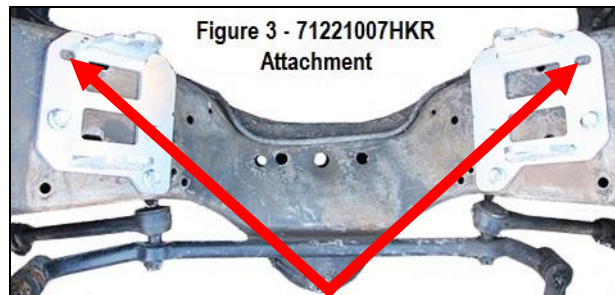
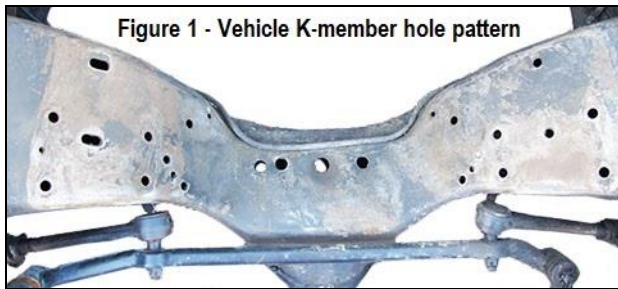
### **BEFORE BEGINNING...**

Check that the hardware package includes the following:

| Qty. | Description            | Qty. | Description             |
|------|------------------------|------|-------------------------|
| 8    | 3/8 x 1" Bolts         | 1    | 3/16 Trans Mount Spacer |
| 8    | M10 x 1.5 x 25mm Bolts | 2    | Crossmember Spacers     |
| 8    | 3/8 Nylon Lock Nuts    |      |                         |

## **INSTALLATION:**

1. Remove the factory engine mounts from the K-member and clean the bracket mounting surfaces.
2. **Loosely** attach the Hooker Blackheart engine mounting brackets to the K-member, as depicted in **Figures 1, 2 and 3**, using the supplied 3/8" bolts/nuts. The driver's side bracket is identifiable by the triangular shaped notch located on its outer profile. The passenger's side bracket has a semi-circle shaped notch located along its outer profile.



**NOTE: Drill two holes here with a 3/8" drill bit. Drill them in-line with the forward top holes so that the brackets maintain the adjustability provided for by the slots.**

3. Install new motor mounts onto the LS engine to be installed.
4. Install the engine/transmission assembly onto the Hooker Blackheart engine brackets and couple the engine mounts to the engine brackets using the user-sourced bolts/nuts.
5. Raise the rear of the transmission as high as it will go and install a stock 1967-72 Chevelle or Hooker Blackheart **71222007HKR** transmission crossmember, depending on your transmission application. If you are using a stock Chevelle crossmember, the supplied 3/8" and 3/16" thick spacers must be installed with the crossmember to maximize exhaust clearance under the crossmember and provide the intended optimized drivetrain geometry designed into the Hooker Blackheart engine brackets.

Each set of Hooker Blackheart A-body engine swap brackets provides the user with unique fitment/compatibility advantages that determine the amount of effort required to install a particular transmission and/ or engine accessory drive system in the swap vehicle. The type and amount of work to be expected when installing either set of engine brackets with a particular transmission is condensed as follows:

### **71221006HKR Forward Bias Engine Brackets:**

#### **4L60-4L70 installations -**

- No floor cutting required, but slight, focused impact clearancing (hammering) of the floor may be required around the upper left bolt boss at the bellhousing/transmission case interface, at the top left corner of the transmission extension housing where it attaches to the transmission case and above the U-joint yoke, depending on the size of the U-joint/yoke used.
- Install using a stock 1968-72 Chevelle transmission crossmember, which will bolt right onto the vehicle frame using pre-existing holes in the frame rails.
- Install the included 3/8" spacers between the ends of the crossmember and vehicle frame. Install the included 3/16" spacer between the crossmember center pad and transmission mount if you are using a stock rubber or Hooker Blackheart **71223029HKR** (black) or **71223030HKR** transmission mount.

#### **TH350, TH400 and 2004R installations -**

- No floor cutting or floor modifications are required to install these transmissions, except for possible U-joint/yoke clearance, which can be accomplished through focused impact (hammer) clearancing of the floor just above the yoke.

- Install using a stock 1968-72 Chevelle transmission crossmember – this will require 2 new **13/32"** holes be drilled in-line with the existing holes in each frame rail to attach the crossmember to the frame. Drill one hole **1/2" REARWARD** from the center of the hole with the arrow pointing to it in **Figure 4** and a second hole **2-1/4" REARWARD** from the first drilled hole.



**Figure 4**

- Install the included 3/8" spacers between the ends of the crossmember and vehicle frame. Install the included 3/16" spacer between the crossmember center pad and transmission mount if you are using a stock rubber or Hooker Blackheart **71223029HKR** (black) or **71223030HKR** transmission mount.

#### **T56/T56 Magnum installations -**

- **Moderate** floor cutting/modification is required. Cut a long slit down the center top of the tunnel and remove all of the tunnel sheet metal directly above the transmission extension housing. After slitting/cutting of the floor, install the transmission per the instructions included with the Hooker Blackheart crossmember and pry open the tunnel on either side of the slit until sufficient clearance above the transmission is obtained. Close up the slit with a narrow patch panel and rebuild the tunnel surrounding the extension housing once the transmission is solidly mounted to the crossmember. Any additional U-joint/yoke clearance needed can be obtained through focused impact clearancing of the floor just above the yoke.
- Install using a Hooker Blackheart **71222007HKR** transmission crossmember, per the instructions included in its packaging.

#### **4L80/4L85 installations -**

- No floor cutting required, but slight, focused impact clearancing (hammering) of the floor may be required around the output speed sensor and electrical plug on the left side of the transmission, around the cooler fittings/lines on the right side of the transmission and above the U-joint yoke, depending on the size of the U-joint/yoke used.
- Install using a stock 1968-72 Chevelle transmission crossmember, or Hooker Blackheart **71222007HKR** transmission crossmember. The use of a stock 1968-72 Chevelle crossmember will require drilling new holes in the frame rails and will not be compatible with bolt-in installation of related Hooker Blackheart 2.5" or 3" A-body exhaust systems.
- Install the included 3/8" spacers between the ends of the crossmember and vehicle frame and Install the included 3/16" spacer between the crossmember center pad and transmission mount if you are using a stock rubber or Hooker Blackheart **71223029HKR** (black) or **71223030HKR** transmission mount.

### **71221007HKR Rear-Bias Engine Brackets:**

#### **4L60-4L70 installations -**

- **Extensive** floor cutting/modification is required. The area of the sheet metal that will need to be removed will extend from the tail end of the transmission all the way up into the base of the firewall. Remove enough sheet metal covering the transmission to enable the installation of a stock Chevelle transmission crossmember.
- Install using a stock 1968-72 Chevelle transmission crossmember attached to the frame using the frame holes indicated in **Figure 5**. Once done, use a rat-tail file or rotary file to elongate the two center slots on the crossmember towards the front of the vehicle, as needed, to be able to attach the transmission mount to the crossmember.





Figure 5

- Install the included 3/8" spacers between the ends of the crossmember and vehicle frame and Install the included 3/16" spacer between the crossmember center pad and transmission mount if you are using a stock rubber or Hooker Blackheart **71223029HKR** (black) or **71223030HKR** transmission mount.
- Rebuild the floor over the transmission as needed to close up the floor.

#### TH350, TH400, & 2004R installations -

- No floor cutting or floor modifications are required to install these transmissions, except for possible U-joint/yoke clearance, which can be accomplished through focused impact (hammer) clearancing of the floor just above the yoke.
- Install using a stock 1968-72 Chevelle transmission crossmember attached to the frame in the stock location for a TH350 or TH400 transmission. Use the TH400 attachment position for 2004R installations.
- Install the included 3/8" spacers between the ends of the crossmember and vehicle frame and Install the included 3/16" spacer between the crossmember center pad and transmission mount if you are using a stock rubber or Hooker Blackheart **71223029HKR** (black) or **71223030HKR** transmission mount.

#### T56/T56 Magnum installations -

- **Extensive** floor cutting/modification is required. The area of the sheet metal that will need to be removed will extend from the tail end of the transmission all the way up into the base of the firewall. Remove enough sheet metal to allow the transmission to be installed using the Hooker Blackheart **71222007HKR** transmission crossmember, per the instructions included in its packaging.
- Rebuild the floor over the transmission as needed to close up the floor.

#### 4L80/4L85 installations -

- **Moderate** floor cutting/modification is required. The section of the tunnel immediately above the transmission case extension housing will have to be removed/rebuilt. Any additional U-joint/yoke clearance needed can be obtained through focused impact clearancing of the floor just above the yoke.
  - Install using a Hooker Blackheart **71222007HKR** transmission crossmember, per the instructions included in its packaging.
6. With the engine and transmission in place on the engine brackets and transmission crossmember, sight across the bottom of the engine K-member and use a pry bar to level the engine oil pan and transmission crossmember with the bottom of the engine K-member. Once level, tighten all eight bolts attaching the engine brackets to the engine K-member.
  7. Your LS swap engine and transmission are now mounted and ready to be outfitted with headers and an exhaust system. Hooker Blackheart 1967-72 A-body LS swap headers and exhaust systems are specifically designed for use with these engine mounting brackets.

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HOOKER™ makes no warranties of merchantability, of fitness for particular purpose, or that its products are approved for general use, or that its products comply with laws, regulations, or ordinances in the state where they may be sold to the ultimate purchaser, the consumer. Unless expressly stated to the contrary in the catalog, instruction sheet; or price list, the entire risk as to the conformity of any company product in any such state and as to repair should the product prove to be defective or non-conforming, is on the retail purchaser, the buyer, the ultimate consumer, of such product and it is not upon the seller, distributor, or manufacturer. In this connection, the retail purchaser, the buyer, the ultimate consumer assumes the burden of the entire cost of any and all necessary service, alterations, or repair.

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**199R10933**

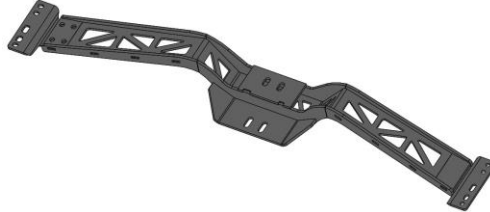
**Revision Date: 4-24-20**



## 1968-1972 GM A-Body Convertible/El Camino LS Swap Transmission Crossmember 71222021HKR

### Installation Instructions – T56/T56 Magnum/4L60-4L70\*/4L80-4L85/TH400\* and 2004R\*

\* Installation requires the use of a separately available Hooker transmission spacer kit.



Thank you for choosing to use this Hooker Blackheart transmission crossmember as part of your LS swap project. This crossmember is part of the most comprehensively engineered system of mounting components, headers and exhaust systems available for this vehicle application. The entire Hooker Blackheart swap system is designed to decrease your total swap installation effort and cost while increasing the engineered quality of your vehicle and compatibility of these components with other popular aftermarket components. Please read these instructions in their entirety before attempting installation.

### PRE-INSTALLATION CONSIDERATIONS:

This crossmember is designed as part of a fully-engineered LS swap mounting system for 1968-72 GM A-body convertible/El Camino vehicles and will also install on any other A-body model that was/has been equipped with a factory boxed frame. It has been CAD designed to provide an optimized balance of weight, stiffness and strength. The dual-arch exhaust passages are provided for installation of available Hooker Blackheart 2.5" and 3" exhaust systems for this application, or any custom system of your choice.

This crossmember provides for direct installation of a 4<sup>th</sup>-gen F-body/GTO T56, aftermarket Tremec T56 Magnum or 4L80/4L85 transmission. Installation of a 4L60-4L70, TH400 or 2004R automatic transmission can also be accomplished using this crossmember and a Hooker Blackheart **12650HKR (TH400/2004R)** or **12657HKR (4L60-4L70)** adapter kit.

Installation of this crossmember, with any of the above mentioned transmissions, requires the use of a stock rubber, or Hooker Blackheart **71223029HKR** (black), or **71223030HKR** (red) transmission mount.

Due to the unique design geometry of this transmission crossmember, attempts to install it with headers and/or engine mounting plates/brackets other than those developed by Hooker Engineering for this LS swap application will more than likely not be successful. When used with the related Hooker Blackheart **71221006HKR** or **71221007HKR** engine mounting bracket kits and Holley **302-2** or **302-3** oil pans, this CAD designed transmission crossmember will provide desirable component clearances and U-joint operation angles.

A suitable lifting jack will be required to install this crossmember with the appropriate transmissions for which it is intended. An automotive lift or a jack and jack stands will be required to safely raise and support the vehicle.

**CAUTION!** WORK ONLY ON A LEVEL SURFACE. USE JACKS /JACK STANDS OF SUFFICIENT CAPACITY TO LIFT AND SUPPORT YOUR VEHICLE. NEVER WORK UNDER A VEHICLE SUPPORTED BY A FLOOR OR BUMPER JACK.

### INSTALLATION:

1. Check that the hardware package includes the following:

| Qty. | Description          | Qty. | Description             | Qty. | Description       |
|------|----------------------|------|-------------------------|------|-------------------|
| 1    | Crossmember Assembly | 1    | Right Side Foot Bracket | 8    | 3/8-16 Nuts       |
| 1    | T56 Magnum Spacer    | 4    | 3/8 Flat Washers        | 8    | 3/8-16 x 1" Bolts |

If any are missing, please contact Technical Service at 1-866-464-6553 or 270-781-9741.

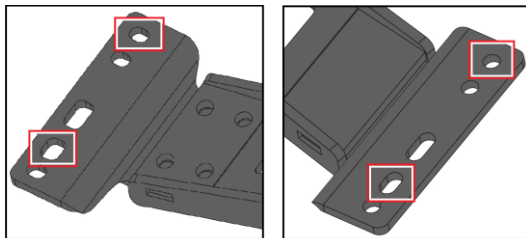
**NOTE:** These instructions have been written with the assumption that you have already installed an LS engine into your vehicle using one of the Hooker Blackheart A-body engine mounting bracket kits.

**NOTE:** If you are installing a T56 Magnum transmission, the included two-hole spacer is to be installed between the crossmember and transmission mount to compensate for the isolator mounting surface of the T56 Magnum being closer to the transmission output shaft centerline than the same surface on an LS 4<sup>th</sup>-gen F-Body/GTO T56. Leaving this spacer out will increase the engine inclination angle beyond that intended by Hooker Engineering and decrease the ground clearance of Hooker Blackheart headers designed for this application.

**NOTE:** 4L80/4L85 transmissions will be installed using the rearward set of holes located behind and above the cantilevered shelf in the center of the crossmember; all other transmissions will be installed using the forward set of holes located in the cantilevered shelf.

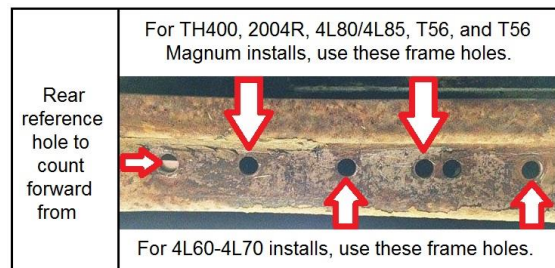
2. Raise the tail of the transmission to its maximum height against the vehicle floor and attach the transmission mount to the transmission (user supplied). If you are using the Hooker Blackheart **71221007HKR** engine brackets and are installing any transmission other than a TH400 or 2004R, or using the **71221006HKR** brackets and are installing a T56 or T56 Magnum transmission, you must modify and/or rebuild the transmission tunnel to provide clearance, as needed, to carry out the remaining installation steps below.
3. Position the left side of the crossmember on top of the lower left side vehicle frame rail followed by raising the right side of the crossmember above the right side vehicle frame rail. Insert the supplied foot bracket between the crossmember and the right side frame rail and attach the bracket to the crossmember using four each of the supplied 3/8" bolts and nuts. Torque to 44 lb./ft.

If using the Hooker Blackheart **71221006HKR** engine mounting brackets, attach the crossmember to the frame using the holes indicated in **Figures 1** and **2** below. As indicated, 4L60-4L70 installations will use the 3<sup>rd</sup> and 6<sup>th</sup> holes along the stock 8-hole frame pattern (counting forward from the rear-most hole in the pattern) and TH400, 2004R, 4L80/4L85 or 4<sup>th</sup>-gen F-body T56/T56 Magnum installations will use the 2<sup>nd</sup> and 4<sup>th</sup> holes along the stock 8-hole pattern (counting forward from the rear-most hole in the pattern).



Crossmember Holes to Use

**Figure 1**



**Figure 2**

4. If using the Hooker Blackheart **71221007HKR** engine mounting brackets, move the crossmember along the frame rails until an aligned, and squared, pattern of holes is revealed that allows attachment of the crossmember to the vehicle frame rails and also to the transmission mount. If a suitable pattern cannot be found, loosely attach the transmission mount to the crossmember using user supplied fasteners and mark and drill new holes in each frame rail after squaring the crossmember across the frame rails.
5. Attach the crossmember to the frame rails with the included 3/8" hardware; torque to 44 lb./ft.
6. Attach the transmission mount to the crossmember. Install a **12650HKR** or **12657HKR** spacer between crossmember and mount for 4L60-4L70, TH400, or 2004R installations.

Any questions? Please contact Technical Service: 1-866-464-6553 or 270-781-9741. For online help, please refer to: [www.holley.com](http://www.holley.com).

### **COMPATIBILITY INFORMATION:**

This transmission crossmember was specifically designed for bolt-in compatibility with the Hooker Blackheart LS swap engine mounting bracket kits, headers and exhaust systems also developed for this application and Hooker LS cast iron manifolds. Various other Holley® and OE LS components have been designed and/or validated for use with this system of components, as follows:

The engine/transmission positioning provided by this crossmember was designed specifically for compatibility with the Holley® **302-2** & **302-3** LS oil pans; compatibility with other aftermarket/OE engine oil pans is unknown. The Holley 302-1 LS engine oil pan is **NOT** bolt-in compatible with this transmission crossmember.

Hooker™ LS swap manifolds (**8501HKR**) and Hooker Blackheart A-body LS swap headers are compatible with the stock A/C evaporator case when installed using this Hooker Blackheart LS engine swap transmission crossmember and the related Hooker Blackheart **71221006HKR** or **71221007HKR** engine mounting bracket kits.

This crossmember is intentionally designed with high-tuck geometry to optimize the ground and dual exhaust routing clearances of this application. As such, installation of new body bushings may be required for successful installation. Worn body bushings have been verified to decrease body-to-frame clearances by as much as 1/2".

More LS swap/engine performance components, such as EFI fuel control systems, fuel filters, fuel pumps, plumbing hose/fittings and valve covers can be found at [www.holley.com](http://www.holley.com).

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**199R11416**

**Revision Date: 4-24-20**



## GM LS/LT Engine Mount Components

### 71221016HKR, 71221017HKR, 71221018HKR, 71221019HKR, 71223015HKR, & 71223016HKR Installation Instructions



71221016HKR



71221019HKR



71223015HKR



71223016HKR

Thank you for choosing to use Hooker Blackheart LS/LT engine mount components as part of your performance vehicle project. These mounts may be used as direct replacement parts on any 1998-02 V8 equipped GM F-body vehicle (with 71221018HKR), or to perform an LT engine swap in a 1998-02 V8 equipped GM F-body vehicle (with 71221019HKR) using the factory frame stands. Additionally, they may be used to mount an LS or LT engine into a GM 1983-93 F-body or 1964-72 A-body vehicle using specific Hooker LS engine swap brackets developed for those applications. Please read these instructions thoroughly before attempting installation.

#### **PRE-INSTALLATION CONSIDERATIONS:**

These components were designed in conjunction with one another to eliminate the rivet-drilling operation typically required to install polyurethane inserts in 1998-2002 GM F-body vehicles.

Hooker Blackheart LS and LT clamshell housings are both stamped from thicker gauge steel than is typically used to manufacture clamshell housings of stock replacement LS engine mounts, which means they provide a stronger mounting foundation for high horsepower applications.

While easy to install, careful attention should be paid to the installation steps within this document to ensure the insert is not installed into the clamshell upside-down or backwards, which would cause in-car installation issues.

#### **COMPATIBILITY INFORMATION:**

Although Hooker Blackheart clamshell housings (LS and LT versions) were CAD designed specifically for use with Hooker Blackheart polyurethane inserts, they will physically accept GM 1998-02 F-body LS polyurethane inserts from Energy Suspension™ and Prothane™ also.

#### **BEFORE BEGINNING...**

Check that the hardware package includes the following:

**71221016HKR-** (1) **black** LS/LT polyurethane insert

**71221017HKR-** (1) **red** LS/LT polyurethane insert

**71221018HKR-** (1) **LS** engine mount clamshell (upper and lower halves), (4) 5/16 bolts, (4) 5/16 washers and (4) 5/16 lock nuts

**71221019HKR-** (1) **LT** engine mount clamshell (upper and lower halves), (4) 5/16 bolts, (4) 5/16 washers and (4) 5/16 lock nuts

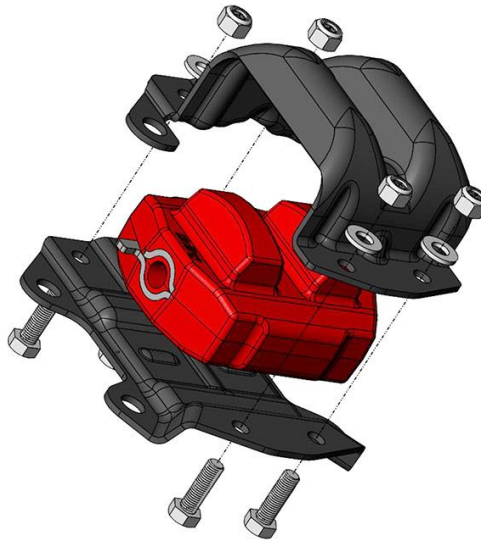
**71223015HKR-** (2) M12 x 150mm flanged head, Grade 10.9, LS/LT engine mount/bracket couple-bolts, (2) M12 flanged nuts

**71223016HKR-** (4) 5/16 bolts, (4) 5/16 washers, and (4) 5/16 lock nuts (this is a replacement hardware kit for the fasteners included with the 71221018HKR and 71221019HKR engine mount clamshell kits).

#### **INSTALLATION:**

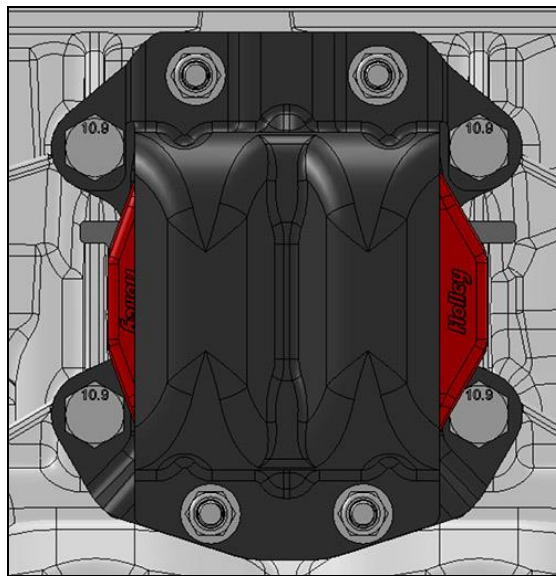
1. Install the insert between the upper and lower clamshell halves while ensuring that the following conditions of orientation are met:
  - A. The metal tangs protruding from the ends of the insert are offset towards the top of the clamshell halves (the side with a straight edge compared to the slight "V" shaped edge of the bottom side).
  - B. The longer end of the insert protrudes from the right side of the clamshell housing. This is the case with both mounts to be installed on an engine, which means when installed on the engine, the longer end of the inserts will point towards the front of the car on the passenger's side of the engine, and towards the rear of the car on the driver's side of the engine.
2. With the above conditions met, fasten the upper and lower clamshell halves together using the 5/16" hardware included with each clamshell housing. Install the fasteners in the orientation shown in **Figure 1** on the next page (LT clamshell shown, LS clamshell similar).





**Figure 1**

3. Ensure the two large holes in the bottom of the upper and lower halves are aligned to allow unobstructed insertion of M10 bolts through each of them and then torque the 5/16 bolt/washer/nut assemblies to approximately 29 ft./lbs.
4. Attach the clamshell/insert assemblies to the intended engine with user-supplied M10 fasteners with the straight edge of the clamshells facing up as depicted in **Figure 2**.



**Figure 2**

5. Lower the engine onto the vehicle engine mounting brackets and couple the engine mounts to the brackets using the M12 bolts and nuts included in the Hooker Blackheart 71223015HKR hardware kit, or with similar fasteners. Tighten bolt/nut assemblies

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**199R11359**

**Revision Date: 8-2-19**



**Transmission Polyurethane Mount - GM**  
**71223029HKR & 71223030HKR**  
**Installation Instructions**



Thank you for choosing to use the Hooker BlackHeart™ transmission mount as part of your performance vehicle project. Please read thoroughly and understand these instructions before attempting installation.

**PRE-INSTALLATION CONSIDERATIONS:**

These polyurethane transmission mounts may be used as a direct replacement for stock GM rubber mounts that measure 1.75" in height. Replacement of mounts with a greater height than 1.75" can be accommodated with the use of shim washers between the crossmember and the mount.

The polyurethane construction is capable of high horsepower applications while preserving vibration dampening and the safety interlock design of the inner components ensures that even if the polyurethane fails the mount will not separate. These polyurethane mounts are capable of fitting either a one or two stud type of crossmember interface.

**BEFORE BEGINNING:**

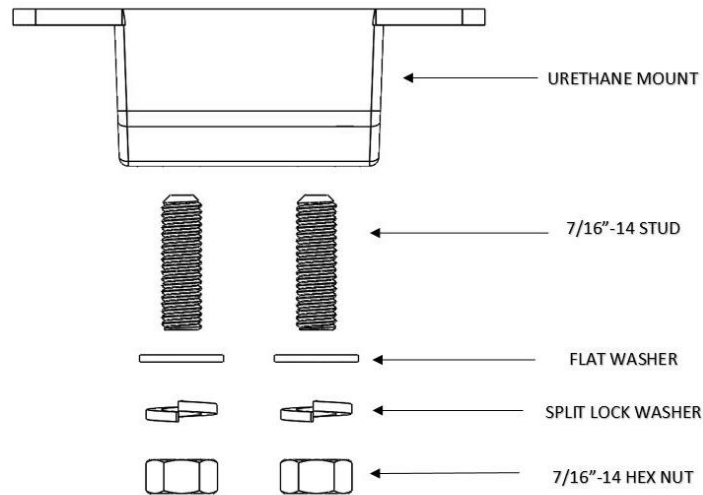
Check that the package contains the following hardware:

| 71223029HKR |                                       |
|-------------|---------------------------------------|
| Qty.        | Description                           |
| 1           | Black Polyurethane Transmission Mount |
| 2           | 7/16"-14 x 1.5" Studs                 |
| 2           | 7/16"-14 Hex Nuts                     |
| 2           | Flat Washers                          |
| 2           | Lock Washers                          |

| 71223030HKR |                                     |
|-------------|-------------------------------------|
| Qty.        | Description                         |
| 1           | Red Polyurethane Transmission Mount |
| 2           | 7/16"-14 x 1.5" Studs               |
| 2           | 7/16"-14 Hex Nuts                   |
| 2           | Flat Washers                        |
| 2           | Lock Washers                        |

## **INSTALLATION:**

1. Determine if your application requires a one or two stud crossmember interface. Install the supplied stud(s) (7/16"-14 x 1.5") into the appropriate threaded holes in the polyurethane mount with a 7/32" hex key. If no hex key is available, the studs can also be installed into the mount by "double nutting" the end of the stud with the supplied hex nuts. Install the stud(s) until firmly seated in place.
2. Install the mount onto the crossmember with hardware provided (shown in **Figure 1**). Do not tighten the hex nuts at this time.
3. Install the factory transmission bolts (user supplied). Do not tighten the bolts at this time.
4. Confirm alignment of the polyurethane mount with the transmission and crossmember. Tighten and torque the transmission bolts to factory torque specifications. Also tighten and torque the crossmember hex nut(s) to 49 ft./lbs.



**Figure 1**

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**199R11754**

**Date: 1-24-19**