



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).

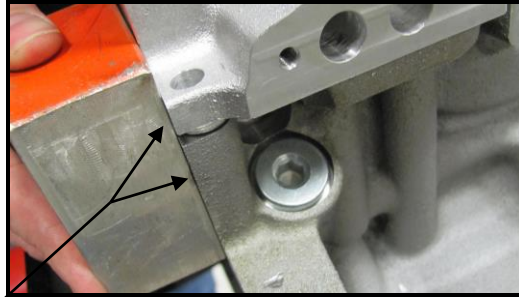


Figure 2

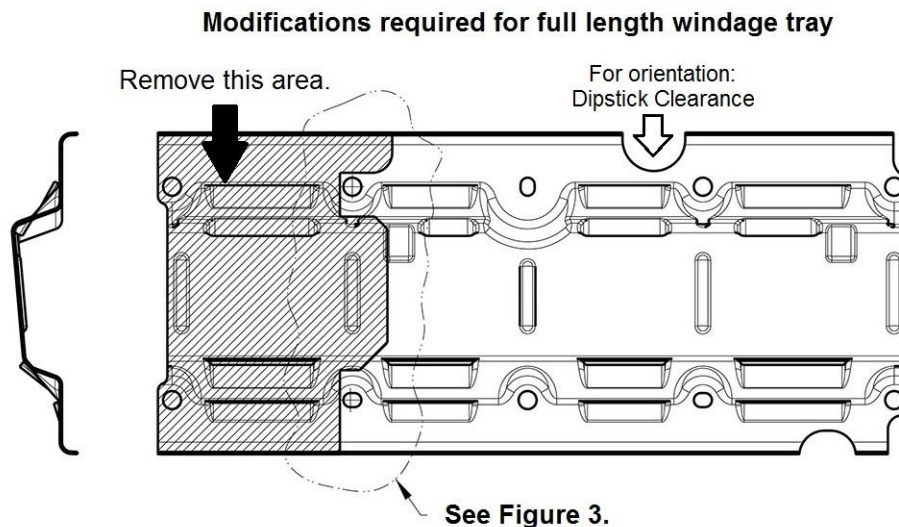
IMPORTANT: It is advisable to wash all of the new parts well before installing to remove any dirt or debris from the packing and shipping process.

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

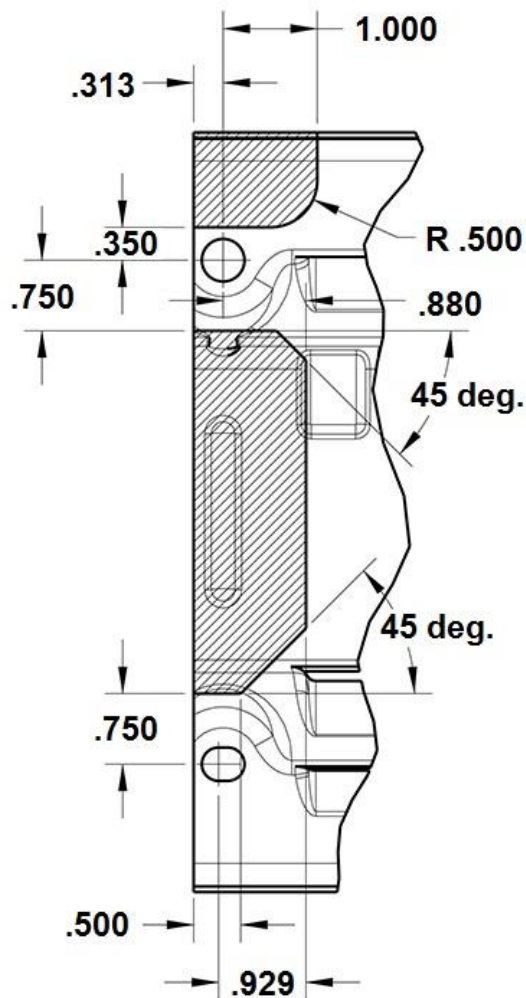
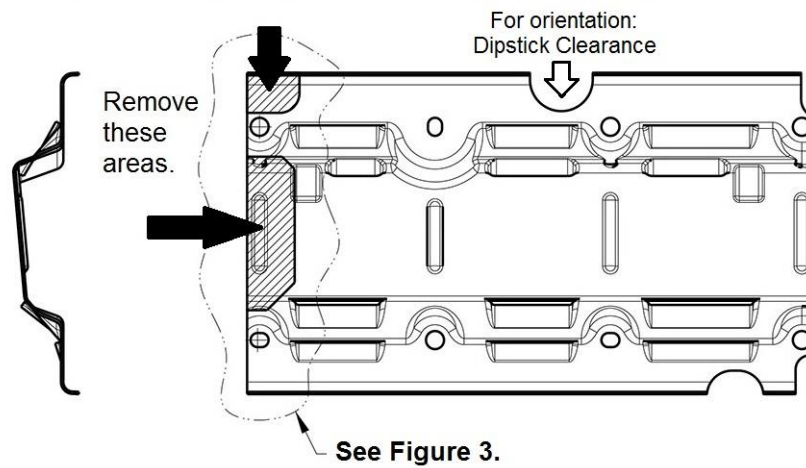


Figure 3

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**).

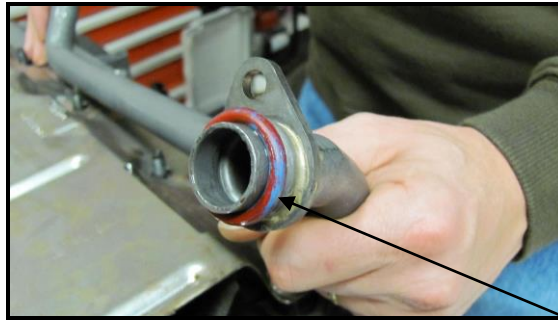


Figure 4

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.

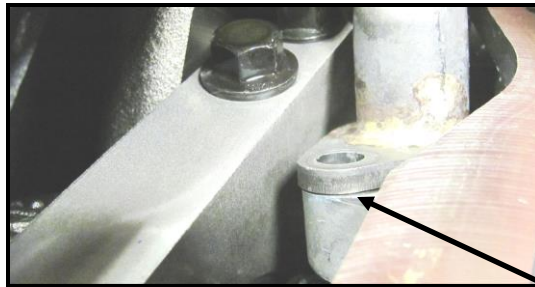


Figure 5

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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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).

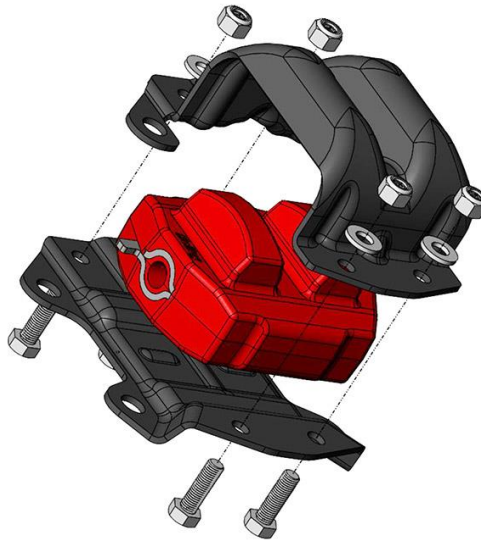


Figure 1

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**.

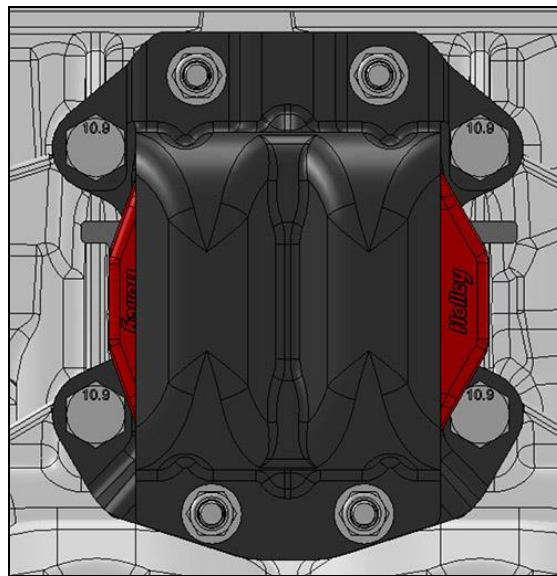


Figure 2

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



**GM 1963-1972 C10 Crossmember
Installation Instructions
71222024HKR**



Thank you for choosing to use this Hooker™ 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 application. The entire Hooker™ 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.

COMPATIBILITY INFORMATION:

This transmission crossmember was specifically designed for bolt-in compatibility with the HOOKER™ LS swap engine mounting bracket kit, cast iron LS exhaust manifolds, headers and exhaust systems also developed for this application. Various other Holley® 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 for compatibility with the Holley® 302-2 and Holley 302-3 LS oil pans. Compatibility with other aftermarket/OE engine oil pans is unknown.

Hooker™ LS swap manifolds, LS Turbo manifolds, and long tube headers are compatible when installed using this Hooker LS engine swap transmission crossmember and the related Hooker BHS511 engine mounting bracket kit.

This crossmember was intentionally designed with high-tuck geometry to optimize the ground and dual exhaust routing clearances of this application.

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.

Hooker recommends using a Prothane 7-1604 or Anchor 2268 transmission mount.

Designed for use with GM T56, 6L80, 4L80, 4L60, TH400, TH350, 700R4 transmissions

High hump floor pan will be needed when using 4L80, T56, 6L80 transmissions, and a bolt in tunnel is available from many C10 parts suppliers

It is recommended to install new body bushings before installing the new larger case transmissions

BEFORE STARTING:

Your vehicle must be raised a minimum of 36 inches. A floor hoist is ideal. If no hoist is available, we strongly urge the use of axle stands as a safety measure. Please read these instructions in their entirety before attempting installation.

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.

NOTE: These instructions have been written with the assumption that you have already installed an LS engine into your vehicle using the Hooker BHS511 engine swap bracket kit. Satisfactory engine and transmission installation with any other type or brand of engine mounts is not intended with this crossmember.

INCLUDED HARDWARE:

Qty.	Description
1	Center Crossmember
1	Left Side Mounting Bracket
1	Right Side Mounting Bracket

Qty.	Description
12	3/8" x 1" Bolts
12	3/8" Nuts

Depending on which crossmember you order, there will be a supplied spacer for your specific transmission. **Figure 1** shows the stack up of the spacer and transmission mount.

- T56 – no spacer
- 6L80 – 11/16"
- 4L80 – 1"
- 4L60 – 11/16"
- TH400 – 1"
- TH350 – 11/16"
- 700R4 – 11/16"

Check the hardware package. If anything is missing, please contact Technical Service at 1-866-464-6553 or 270-781-9741.

INSTALLATION:

1. Raise the tail shaft of the transmission to its maximum height against the vehicle floor.
2. When looking at the crossmember, the center is at an angle. The upward side goes toward the front of the vehicle.
3. Install the left side bracket to the crossmember while working on the bench using the 4-3/8" bolts and tighten.
4. Install the crossmember into the vehicle. Install the right side bracket with the 4-3/8" bolts and tighten.
5. At this time, square the crossmember up with the frame and transmission and find at least two holes on each side for mounting. Use the 3/8" bolts for mounting and tighten.
6. If your trans uses a spacer, install it now, lower the trans to the spacer, and install the user supplied transmission mount bolts and tighten.
7. Once install is complete, tighten all 3/8" fasteners to 25 ft/lbs.



Figure 1

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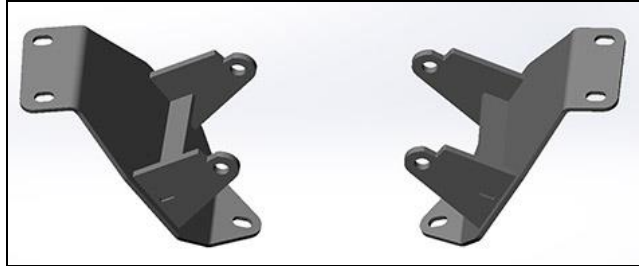
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199R11658

Revision Date: 9-10-20



1967-72 GM C10 LS/LT Swap Engine Mounting Brackets BHS511 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:

Installation of these brackets requires the use of new stock OE 4th-gen F-body LS engine mounts (ex: GM 22179268 or Anchor 3064) or aftermarket polyurethane inserts (Hooker BlackHeart LS/LT Polyurethane Inserts – P/N's 71221016HKR (Black) or 71221017HKR (Red) along with Hooker Blackheart 71221018HKR heavy duty clamshells or Prothane 7-512 or Energy Suspension 3-1151).

In addition, a pair of metric motor mount through-bolts and a pair of locking flange nuts will need to be sourced for connecting the Hooker engine brackets to the motor mounts. Specification requirements are 10.9 M12 x 1.75 x 140mm or Hooker Blackheart 71223015HKR engine mount bolt kit.

COMPATIBILITY INFORMATION:

These LS/LT swap brackets have only been tested on 2-wheel drive applications.

This engine swap mounting bracket kit requires the use of a Holley® **302-2** and **302-3** oil pan for installation and provides compatibility with Holley accessory drive system in all spacings.

More LS/LT 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.

BEFORE BEGINNING...

Check that the hardware package includes the following:

Qty.	Description
6	3/8 x 16 x 1 Bolts
6	3/8 x 16 Nuts

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

INSTALLATION:

1. Remove the factory engine mounts from the frame and clean the bracket mounting surfaces.
2. Attach the Hooker engine mounting brackets to the frame using the supplied 3/8" hardware. Leave the hardware loose at this time.

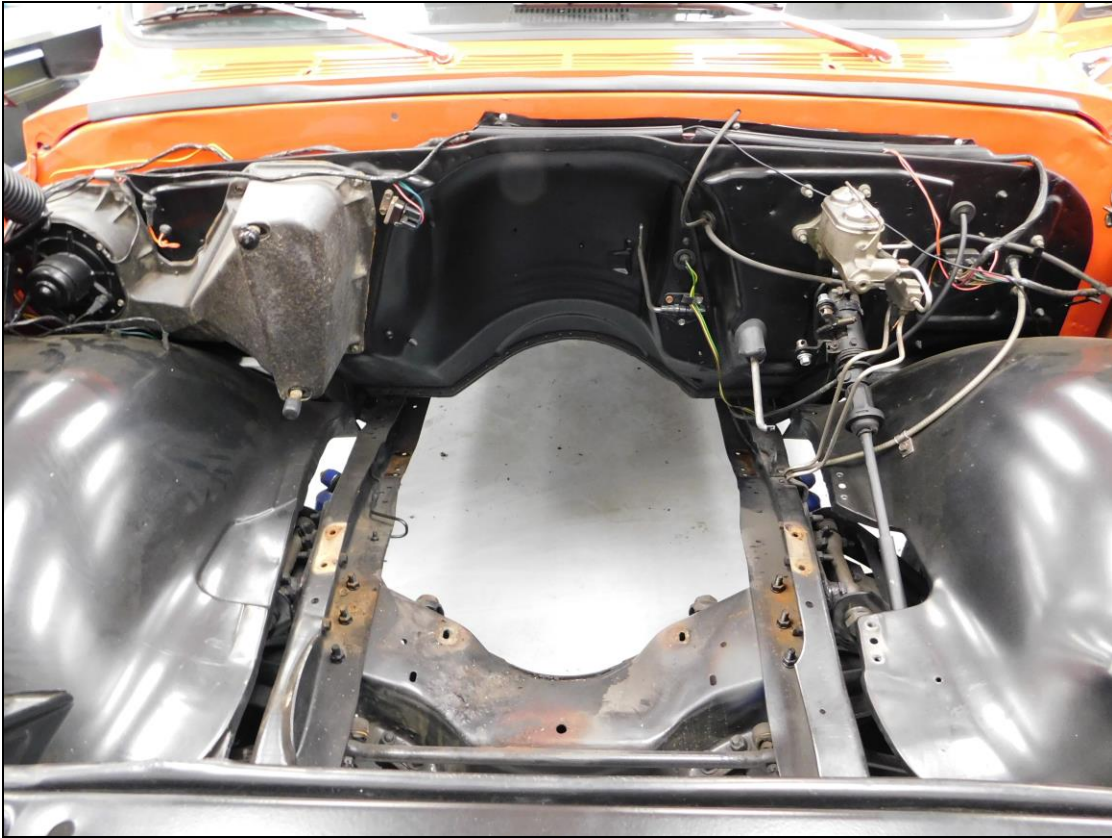


Figure 1

3. Install new OE rubber or aftermarket polyurethane mounts on the LS/LT engine to be installed.
4. Install the engine/transmission assembly onto the Hooker engine brackets and couple the engine mounts to the engine brackets using the Hooker Blackheart 71223015HKB engine mount bolt kit or user-sourced metric cap screws and flanged locking nuts.
5. Once the engine is sitting in the engine bay as it should, use a wrench to tighten the (x6) mounting bolts and through bolt.
6. Raise the rear of the transmission as high as it will go and install the Hooker LS/LT swap transmission crossmember per the instructions included with its packaging.
7. Your LS/LT swap engine and transmission are now mounted and ready to be outfitted with headers and an exhaust system. Hooker Blackheart LS/LT 67-72 C10 swap headers and dual exhaust systems are specifically designed for use with these engine mounting brackets.

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Date: 8-27-19