

## INSTRUCTIONS FOR INSTALLING GASKETS

### PLACEMENT of GASKETS:

Bolt patterns, cutouts, etc will dictate the proper placement of the gaskets. No gaskets have any "up-side" or "down-side" requirements.

### SEALING REQUIREMENTS:

The following gaskets should be sealed as indicated. Permatex Aviation brand sealer seems to work well. Except where noted, gaskets should be installed dry (without sealer) including the head gaskets.

(MM-002) Water jacket side plate gasket - coat both sides of gasket, as well as plate and block surfaces generously to prevent leakage. Threads of the 8 bolts should also be coated, making sure to reuse brass flat washers. Lock washers allow leakage through their slots.

(MM-003) Late model thermostat housing gasket - lower side only, so that the housing can be removed for servicing without damaging the gasket later.

(MM-004) Fuel pump gasket - use sealer on both sides.

(MM-007) Valve cover gasket - gaskets on early model engines can usually be sealed by coating only the valve cover side, so that the cover can be removed later for servicing without damaging the gasket. On late model engines, coat both sides generously. Valve covers on late model engines are constructed from 3/16" plate steel which does not fit quite as tightly along the side of the block as do the early style cast iron plates.

(MM-010) Flywheel housing gasket - coat both sides of the lower half of the gasket.

(MM-011) Oil pan - coat the top of each gasket in the area where the block and aft housing meet. **An inch or so of sealer on the top of the oil pan gasket on either side of the three-way intersection formed by the aft housing, block, and oil pan is usually sufficient. The sealer will extrude up around the bottom of the aft housing gasket which is normally installed dry.**

(MM-014) & (MM-017) Reversing gear cover - coat the cover side of the gasket so that the cover (and gasket) can be removed later for servicing.

(MM-015) Water pump flange gasket - coat the pump side of gasket only so that the pump can be removed later for servicing.

(MM-018) & (MM-019) Early model cross-over tube gaskets - coat both sides of both gaskets.

(MM-021) Early model Dole thermostat housing - coat one side of gasket only, so that the housing can be separated later for servicing.

(MM-020) & (MM-022) Water pump back plate gaskets - use sealer very sparingly, making sure that sealer does not get into the impeller or gear chambers.