

# M/T VALVE COVER INSTALLATION INSTRUCTIONS

To preserve the warranty, these instructions must be read and followed thoroughly BEFORE and DURING installation.

**CAUTION:** If your engine has non-standard valve train components, such as a high-lift camshaft, roller-tip rocker arm, higher lift ratio rocker arms, stud girdles, etc., there may be insufficient clearance when using the Holley-M/T aluminum valve cover. You must check all internal clearances according to steps 14 -17 below.

**WARNING:** INSUFFICIENT CLEARANCE TO MOVING VALVE TRAIN COMPONENTS COULD LEAD TO PART BREAKAGE AND RESULT IN SERIOUS ENGINE DAMAGE.

SALES #	MAKE	ENGINE	YEAR
241-82 241-83 241-86	Chevrolet	262,283,302,305, 307,327,350,400	1958 and up with perimeter bolt pattern
241-84 241-85 241-87	Chevrolet	396,402,427, 454, 502	1965 and up

## INSTALLATION

1. Remove the oil fill cap, PCV hose, and any wires attached to the stock valve cover.
2. Remove the valve covers and carefully clean any gasket material that adheres to the head surface. Do not allow gasket debris to enter the engine.
3. Determine the most convenient location for the oil fill twist lock cap and PCV valve before the removal of any knock outs.
4. Knock the plugs inward from the cover face with no larger than a 1/4" diameter punch and clean up burrs with a file. The knock out can be fashioned for standard grommets requiring 1" to 1 1/4" holes. The grommet is not included.
5. Install the PCV valve rubber grommets, if required.
6. Fasten the baffle plates to the cover, as shown in illustration, using the furnished self-tapping screws. Add thread locking compound to each screw. Make sure the plate is not able to move when the screws are tightened down. See **Figure 1**.

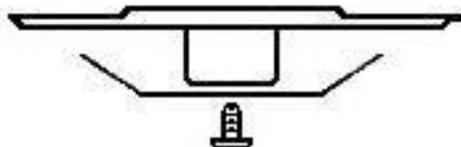


Figure 1

7. Install the new valve cover gaskets in the covers using an adhesive type sealer.
8. If you are using 100% stock valve train components, then install valve covers. If any item of the valve gear is non-stock, see the following steps 12-15.

9. Torque the valve cover bolts to 5-6 ft/lbs, making sure gaskets do not slip out of position.
10. Install the items removed in Step 1.
11. Start the engine and check for oil leaks.
12. Place small pieces of modeling clay on protruding areas of the valve train (both moving and stationary). Include the following: both tips of the rocker arms, the pushrods (closest to the valve cover flange surface), on the rocker arm studs, or on the rocker shaft attachments. In general, check all the points that you are not sure about.
13. Install the valve cover, using the correct gasket and tighten the hold-down bolts 5-6 ft/lbs of torque. Turn the engine over by hand or with a SHORT lever, at least two full revolutions of the flywheel. Removing the spark plugs is advised.

**CAUTION:** Be alert for any signs of unusual binding, as the engine is turned. If binding occurs; stop turning immediately, remove the valve cover, and check the clay pieces. **DO NOT FORCE THE ENGINE TO TURN.**

14. After two complete revolutions, remove the valve cover and check the clay thickness with a depth micrometer, or suitable instrument. Clay should compress to no thinner than .080" at any point for moving parts and no thinner than .040" for stationary parts.

**NOTE:** If the clearance is not acceptable, according to Step 14, Holley recommends that you install a spacer to increase clearance to the valve cover.

15. If clearance is acceptable, remove all the traces of the modeling clay from the engine. Return to step 10 and complete the installation.

**NOTE:** If the vehicle is not equipped with a twist lock oil fill cap, it may be necessary to purchase one to complete this installation. On some installations, it may be necessary to purchase slightly longer mounting bolts.

**PARTS LIST:**

Qty. in box	Description
1	VALVE COVER, M/T
1	VALVE COVER, M/T, HOLE PUNCHED FOR FILL CAP
2	BAFFLE
4	SELF TAPPING SCREWS
1	WARRANTY STATEMENT - 90 DAY
1	INSTRUCTIONS

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