



# 8204 & 8206 INTAKE MANIFOLD SPACER PLATE KITS INSTALLATION INSTRUCTIONS

This instruction sheet is for the intake manifold spacer plates used when an intake manifold designed for a standard Chevrolet big block engine is being installed on a Chevrolet big block "Tall Block" engine.

## PARTS AND MATERIALS REQUIRED:

1. Two (2) intake manifold gasket sets
2. Silicone sealer or equivalent
3. 1/2' longer intake manifold bolts
4. Four (4) tapered head screws-only needed if the side spacer plates are to be attached to the cylinder heads.

## INSTALLATION INSTRUCTIONS:

### I. CHECK FIT ALL PIECES, PRIOR TO ACTUAL INSTALLATION.

- A. Check fit the end spacer plates to the engine cylinder block. The three holes in the end spacers must align with the corresponding holes in the cylinder block for the spacers to work properly.

**NOTE:** These holes are normally used for gasket alignment. Material may have to be removed from each end of the spacers for proper alignment to the cylinder block. (See Figure 1). Should material need to be removed, carefully grind or file away, maintaining the correct angle, until the end spacer is the proper length.

- B. On the large, side spacer plates, the two coolant passages have been designed smaller to restrict coolant flow for marine and drag race applications. For application where normal coolant flow is desired, it will be necessary to enlarge and match the coolant passages to the intake manifold gaskets. This is especially important when a thermostat or adjustable water outlet is to be used to regulate coolant flow.
- C. Check fit the side spacer plates to the cylinder heads. Check bolt hole and port alignment and if necessary, make any corrections. Spacer plates may be ported to match reworked cylinder heads.
- D. To maintain consistent spacer alignment, it is advised to screw the plates to the cylinder heads. This can be accomplished by properly positioning the spacer plates on the cylinder heads, and then drilling two (2) holes through each plate and into the cylinder heads. When drilling into the cylinder heads, make sure it is in an area with enough material to tap threads for the attaching screws. The holes in the spacer plates will need to be countersunk and tapered head screws used so that the screw head is flush or below the surface of the spacer plates.

### II. MOUNTING SMALL END SPACER PLATES

- A. Gently tap the supplied roll pins into the cylinder block until they bottom out.
- B. Apply a good quality silicone sealer, or equivalent, to the cylinder block ends.
- C. Gently tap end spacer plates into place, cleaning up any excess sealer.

### III. MOUNTING LARGE SIDE SPACER PLATES

- A. Holes will have to be cut in the intake manifold gaskets if mounting screws are going to be used on the side spacer plates.
- B. Install intake manifold gaskets.
- C. Put silicone sealer, or equivalent, at outer ends of small end spacer plates in sufficient quantity to seal between large, side plates and small, end spacer plates. (See Figure 2).
- D. Place or screw large spacer plates into position.
- E. Install intake manifold gaskets onto large, side spacer plates.
- F. Run bead of silicone sealer, or equivalent, along each of the small, end spacer plates. (See Figure 2).
- G. Lower intake manifold into position making sure intake manifold gaskets are not disturbed. Also, make sure the intake manifold is sealing completely against the small end spacer plates.
- H. Install all intake manifold bolts and hand tight prior to torquing any of the bolts.
- I. Once all intake manifold bolts have been installed, torque bolts in sequence to specifications of intake manifold manufacturer.

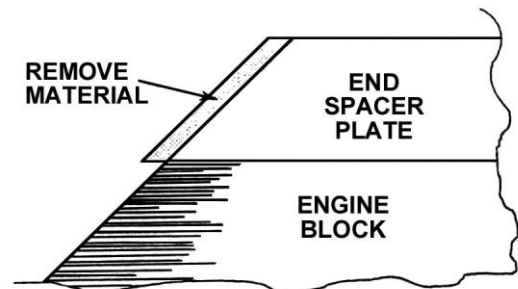


FIGURE 1

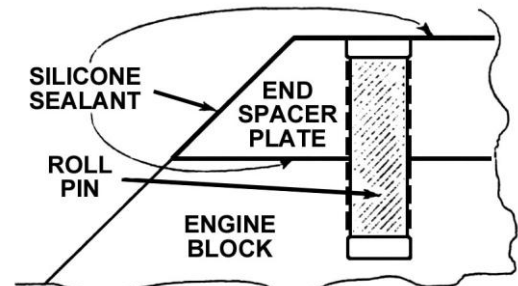


FIGURE 2

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