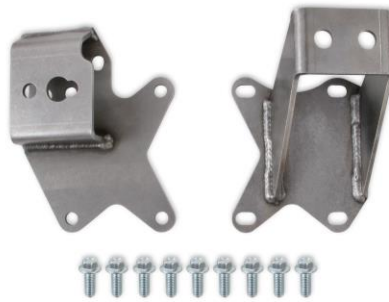


GEN3 Hemi Swap Engine Mount Brackets
1970-1974 E-Body Mopar with Stock (Non-Hemi) V8 K- Member
5.7-6.1-6.2-6.4L Engines
WB130037



Installation Instructions

Thank you for choosing to use White Box™ engine swap mounting brackets as part of your GEN3 HEMI 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.

IMPORTANT: Low mount A/C Compressors will only work with engines using VVT front accessory drive.

*** These Engine mounting plates will not work with **NON-VVT** - low mount A/C compressor configurations.

PRE-INSTALLATION CONSIDERATIONS:

- Installation of these brackets requires the use of new OE style Mopar V8 engine B/E-Body rubber engine mounts. These are available at Holley.com **PN: 24096LKW** or your local parts store (Example: POWER TORQUE PN: 2250). These mounts will need to be modified for clearance at the engine block **See Figure 5** on page 3 of these instructions for details.
- K-Member clearance will need to be performed to accommodate low mount A/ C compressors (**VVT engines only**). See **Figure 7** on page 4 of these instructions.
- Mopar Performance 45 Degree Oil Filter Adapter Kits **PN: 77072447** or remote oil filter location will be required.
- Use of a Mid Sump oil pan and pick up tube required (**Holley PN: 302-61 VVT or PN: 302-60 NON-VVT** - See www.holley.com for a complete selection of Hemi Swap oil pans and pickup tubes).
- 6.2L Hellcat engine installations may require supercharger water manifold (**PN: HEMI0005ERL**).
- Only Hooker Blackheart Headers **PN: BH2358** have been tested for correct fitment with these engine mounting plates.

Visit www.holley.com for a complete selection of Transmission Crossmember, Headers, Exhaust, and more GEN3 HEMI support products to complete your E-Body Hemi Swap.

COMPATIBILITY INFORMATION:

PN: WB130037 Mounting plates WILL NOT work with the following combinations

- Low mount A/C Compressors on **NON VVT ENGINES** - (VVT timing cover and accessory drive is required to use low mount A/C)
- OEM Hemi K-Members
- 6 Cylinder K-Members
- Late K-Members using Barrel style Engine mounts

PARTS LIST:

Qty.	Description
1	Left Engine Mounting Plate
1	Right Engine Mounting Plate

ACCESSORY PACK CONTENTS:

9		M10 x 1.50 x 25mm Flange Bolts
1	199R12185	Instruction Sheet

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

TOOLS NEEDED:

3/8" Metric Socket Set
6' Extension
3/4" Wrench
13mm wrench

INSTALLATION:

Installation of Blackheart WB130037 GEN 3 Hemi Swap Engine Mount Plates

Driver's Side Mounting Plate

- The bottom corner of the motor mount must be profiled to clear the engine block and oil pan rail on both the left and right side mounts. This is easily accomplished with a grinder or band saw (**Figure 5**).
- With the engine out of the vehicle, install the driver's side (Left) mounting plate to the engine block using (x4) M10 x 25mm flange bolts provided. Install the mounting bracket with the engine mount pad toward the front of the engine using the OEM engine mount locations. **NOTE:** The 5th mounting hole provided may be used in place of the 4th bolt under the motor mount pad, if the block is threaded. Always use at least (x4) mounting bolts (**Figures 1 & 2**).

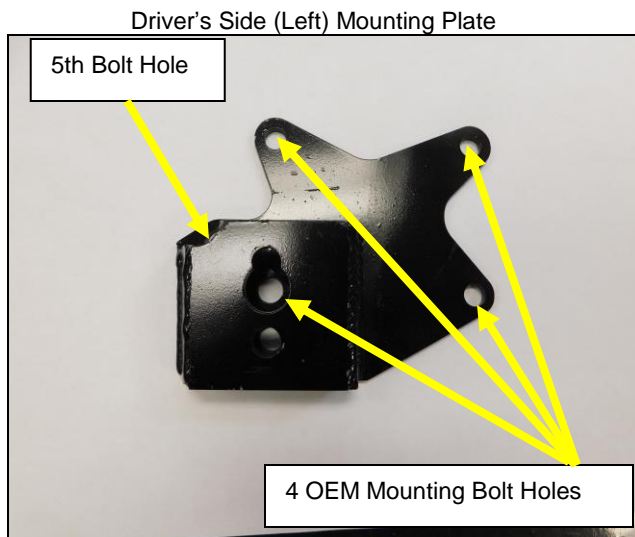


Figure 1



Figure 2

INSTALLATION:

Passenger's Side Mounting Plate

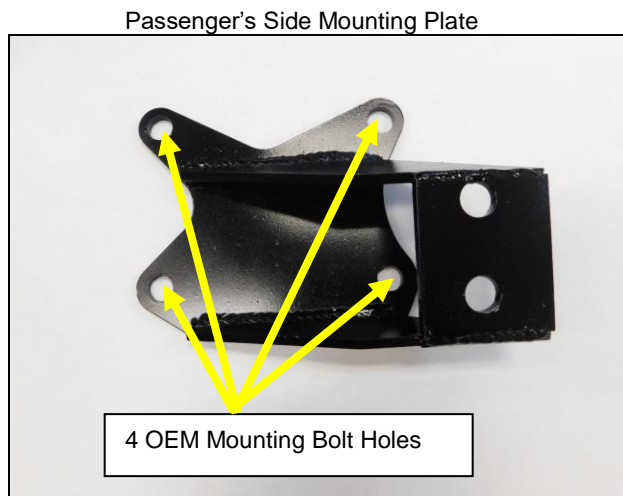


Figure 3



Figure 4

Installing the Rubber Motor Mount

Modification to the rubber mount must be performed before the mount can be installed on to the Mounting Bracket.

1. The bottom corner of the motor mount must be profiled to clear the engine block and oil pan rail on both the left and right side mounts. This is easily accomplished with a grinder or band saw (pre-modified mounts are available on-line) **Figure 5**.
2. Install the rubber mount onto the engine bracket while engine is out of the vehicle using a ½"-13 nut and washer (**Figure 6**).
3. Install the passenger's side (Right) mounting plate to the engine block using (x4) M10 x 25mm flange bolts provided.
4. Install the mounting bracket with the engine mount pad toward the front of the engine using the OEM engine mount locations (**Figures 3 & 4**).

NOTE: The passenger's side engine mounting plate has slotted bolt holes to compensate for manufacturing variances in the K frame and will allow the engine position to be adjusted after installation.

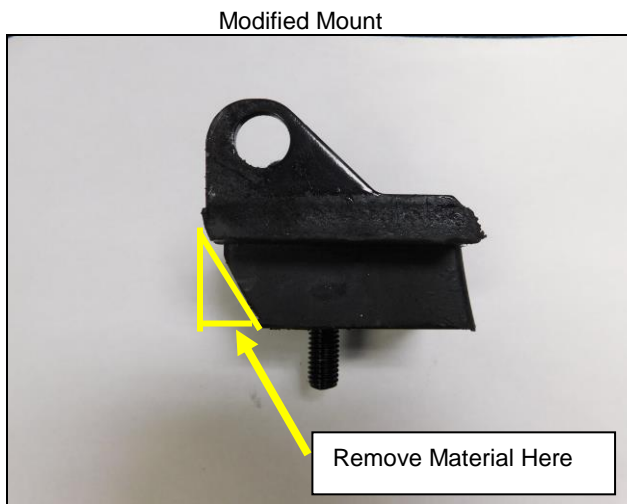


Figure 5

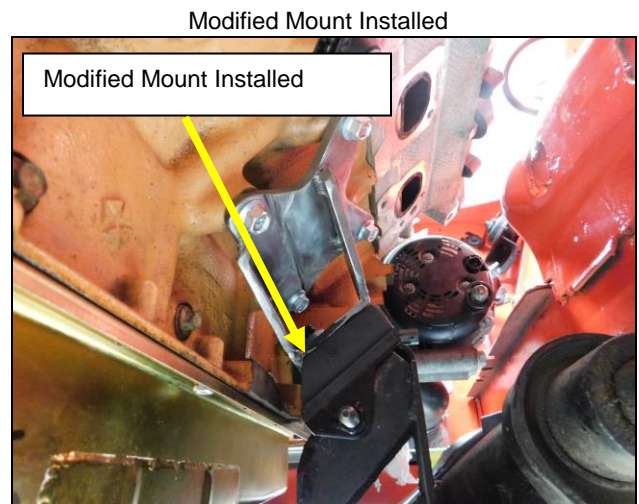


Figure 6

INSTALLATION:

K-Frame Notch for Low Mount A/C Compressor Clearance

1. Mark the driver's (Left) side K-Frame as noted in **Figure 7**.
2. Remove the area marked in yellow, deburr the edges, and apply black paint to keep the metal from rusting (**Figures 7 & 8**).



Figure 7



Figure 8

Install the engine into the vehicle slowly until the engine mounts are positioned on the K-Frame and the engine mount bolts can be installed. Be sure to block or support the engine to prevent damage to the engine mounts while the transmission is being installed



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

199R12185
Date: 2-12-21