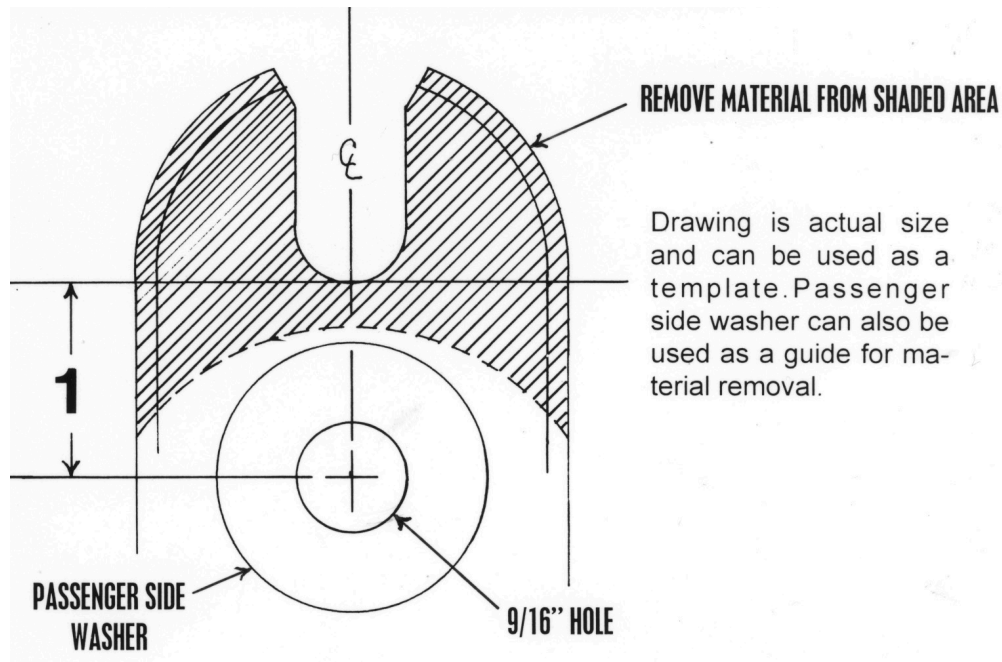


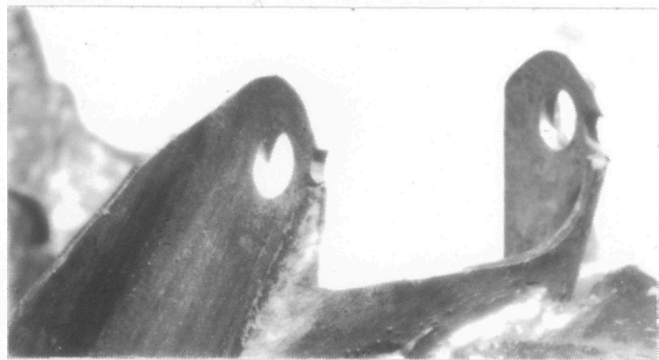
## '73+ A,B,F,M,J Slant 6 to Small Block Conversion Instructions

Thank you for your purchase! We strongly recommend purchasing a Factory Service Manual for your vehicles year and model. This will be an invaluable tool for the success of your project. Please read these instructions fully prior to installation. The K-Member requires modification.

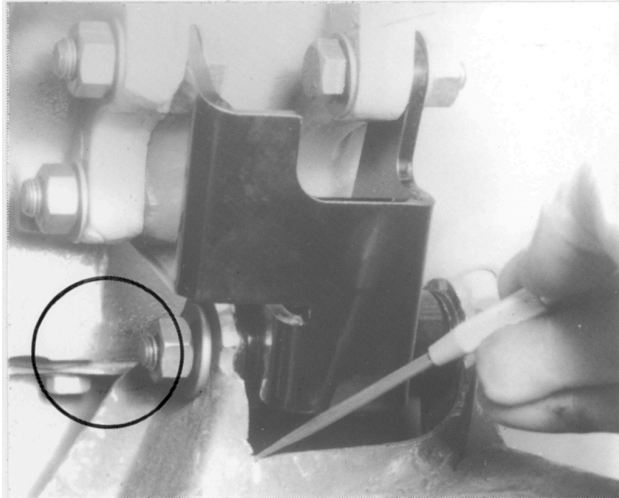
**K-Member Modification:** The left (Driver) side perch must be trimmed and re-drilled for proper engine placement. This can be done with the K-member installed in the vehicle.



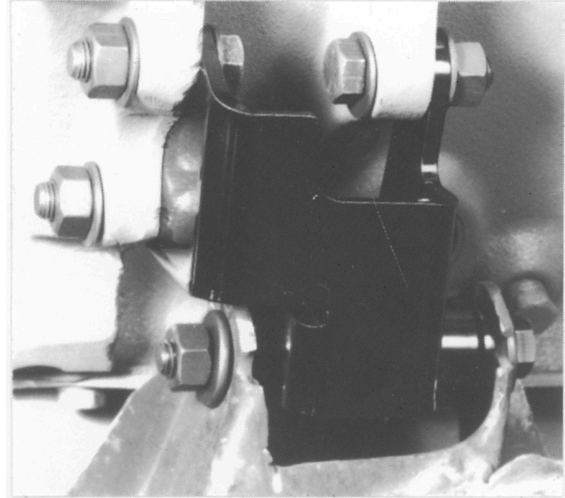
**Measure 1" from the bottom of existing slot and drill a 9/16" hole.** Greater accuracy can be achieved by drilling pilot holes first and then gradually increasing the size, i.e.; 1/8", 1/4", 3/8", 1/2", 9/16".



**Remove material as shown.** Round edges for bracket and engine boss clearance. In the example shown I used a cut-off wheel and then a die grinder to round corners and deburr. A sawzall can also be used.



Additional material was removed for bracket clearance.  
NOTE: Clearance between engine boss and perch support (circle).



**How it works.** Note: 73-76 A-body shown. Other models, i.e. F/M/J-body, may have additional bracing structures that require removal or notching for clearances.

**Note:** Your brackets should be marked with an “L” sticker for the Left (Driver) side bracket. If not the left side bracket has 3 holes, the right side has 4.

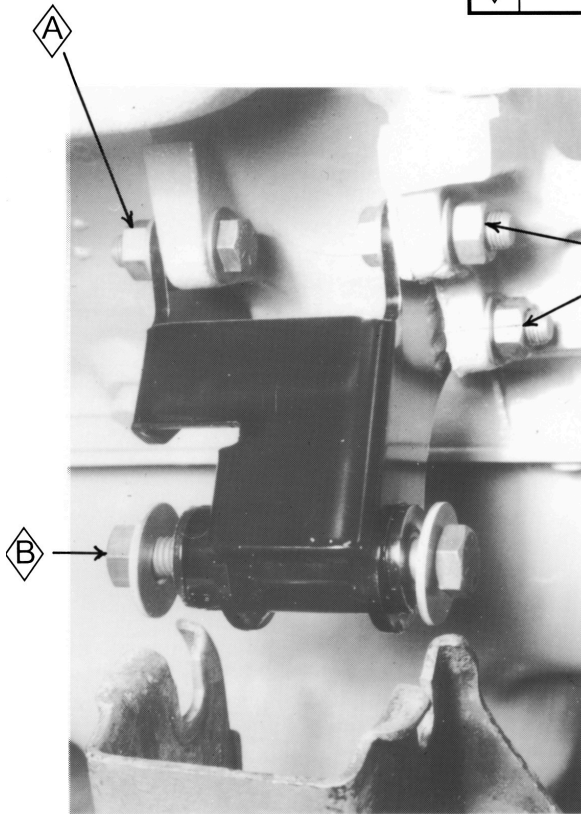
**Installation:** Install bracket to the engine as shown. Tighten fasteners finger tight to allow for greater adjustability later. You will tighten these once the desired engine position is achieved.

Lower the engine and install as per the Factory Service Manual. It may be helpful to secure the right side first, then rock the left side into place. Using a 4 foot level across the valve covers, the engine can now be leveled within the engine compartment. Please Remember; Your vehicle must be on a level surface to get an accurate reading. To insure the engine is in the correct location, it is helpful to have the transmission installed and mounted to the transmission crossmember.

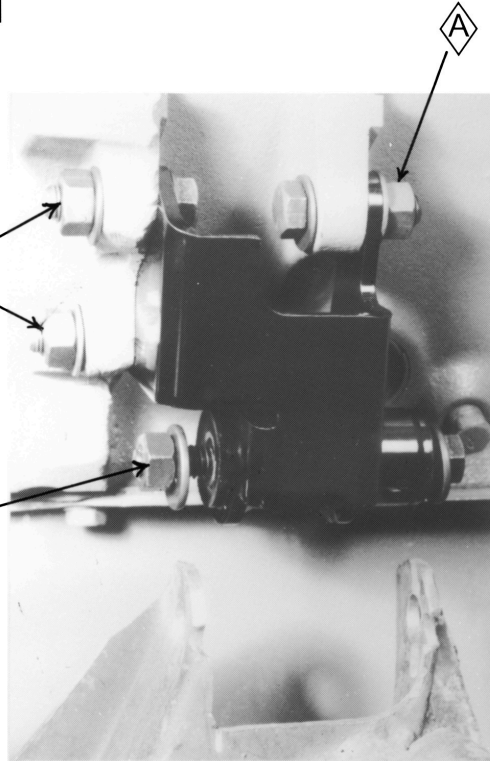
Check your engine level and adjust as needed. Once desired engine placement is achieved, install the 1/2 inch thru bolts into the K-member brackets and tighten to 65-75 Ft/Lbs. Then tighten the engine side hardware to 55 Ft/Lbs.

**TIGHTENING TORQUE**

<b>A</b>	<b>55 FT. LB.</b>
<b>B</b>	<b>75 FT. LB.</b>



**FRONT →**  
**RIGHT HAND (PASSENGER'S) SIDE**



**← FRONT**  
**LEFT HAND (DRIVER'S) SIDE**

**Closing Notes:** Every effort has been made to make this kit as “Bolt-on” as possible. Due to manufacturing tolerances and differences in aftermarket parts some modification may be required to achieve the fit you desire. This is Hot Rodding! Enjoy.

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