

Thank you for purchasing what we feel is the best rope type rear main seal available.

The elastomer used for these side seals is designed to withstand a wide range of temperatures and is unaffected by currently available oil additives. The rope material is asbestos based. It is designed to withstand extreme temperatures and should improve its sealing properties over time. If you have questions please call our technical assistance line at 740/622-9700.



## **Installation instructions rear main seal kit 292 or 312**

*Note: Some success has been reported by people who did not pull engine and crank. However to increase success rate, remove engine and install seal as below.*

1. See separate directions included.

## **Installation side seals**

1. Coat the side grooves of the seal cap with a small amount of RTV. Coat the contact areas of the seal cap and the block with RTV. (DO NOT USE TOO MUCH ON THE BLOCK) Put a small amount of RTV on the very end of the seals where the splits are.
2. Put the side seals in the grooves and let a little bit of the material stick out of the top of the seal cap.
3. Push the seal cap into place. The side seals should slide out a little bit when the cap is bolted into place.
4. Carefully trim the ends of the side seals even with the bottom of the seal cap with a razor blade. Fill any voids in the cap to block interface with RTV and let dry. Trim as needed.
5. Fill the bolt head holes in the seal retainer cap with RTV.
6. Let RTV cure for 24 hours before firing engine.

Thank you for purchasing what we feel is the best molded elastomer type rear main seal available. The elastomers used in this kit are designed to withstand a wide range of temperatures and is unaffected by currently available oil additives. If you have questions please call our technical assistance line at 740/622-9700.



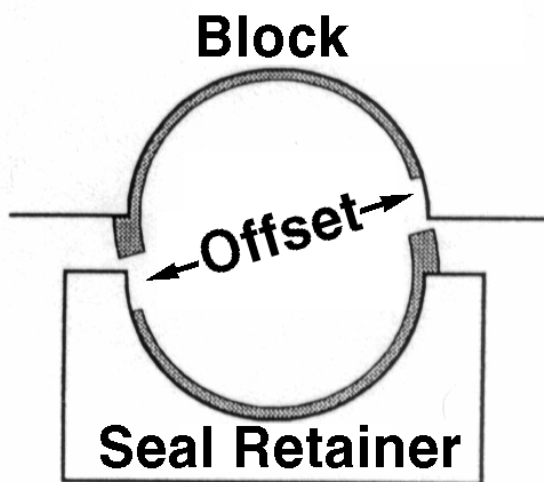
## **Installation instructions rear main seal kit 312**

*Note: It may be possible to install this seal kit without removing the crank. CASCO recommends however to increase success rate, remove engine and install seal as below.*

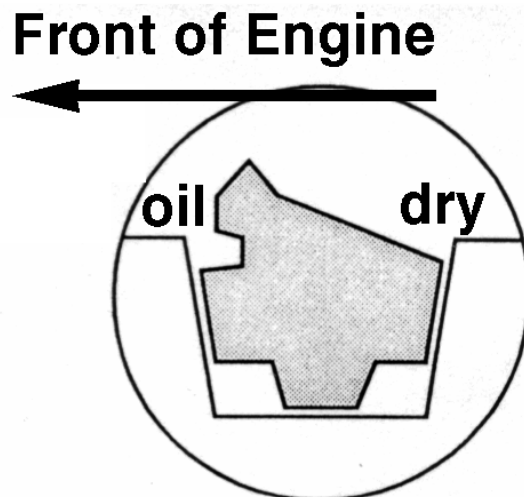
1. With crank removed, remove old seal and clean all seal glands.
2. Put a coat of Slick50 or graphite grease on sliding sealing surface lip. Install seal with one end sticking out of block  $\frac{1}{2}$ ". Make sure that the seal is not backwards. (See to figs. #1 and #2.)
3. Apply lubricant to sliding sealing lip surface as above and install other half of seal in the seal retaining cap. Make sure that a corresponding end is left sticking out of seal cap and that the sealing lip is properly oriented as above.
4. Reinstall crank and tighten all bearing caps and seal retaining cap. Refer to shop manual for proper torque specifications.

## **Installation side seals**

1. Fill side slots with RTV. (silicone sealant)
2. Insert wedged shaped side seal into each side groove
3. Smooth any RTV that escapes from the cracks. Add RTV to cracks if necessary.
4. Smooth RTV over the ends of the installed side seals.
5. Fill the bolt head holes in the seal retainer cap with RTV.



**figure #1**



**figure #2**