

REMOVAL/INSTALL INSTRUCTIONS: ENGINE REAR MAIN SEAL COVER

ATTENTION: Refer to the appropriate shop manual for your vehicle to obtain specific service procedures for this part. If you do not have a service manual or lack the skill to install this part, it is recommended that you seek the services of a qualified technician. Pay special attention to all cautions and warnings included in the shop manual. Read and follow all instructions carefully. This product is only designed to function properly on specific vehicle applications. Please verify that the vehicle requirements match the product specifications and application notes for this part.

REMOVAL/INSTALL OF ENGINE REAR MAIN SEAL COVER (635-518) General Motors 2017–1997, Isuzu 2016–03, Saab 2009–05, Workhorse 2012–04

GENERAL TECH TIPS:

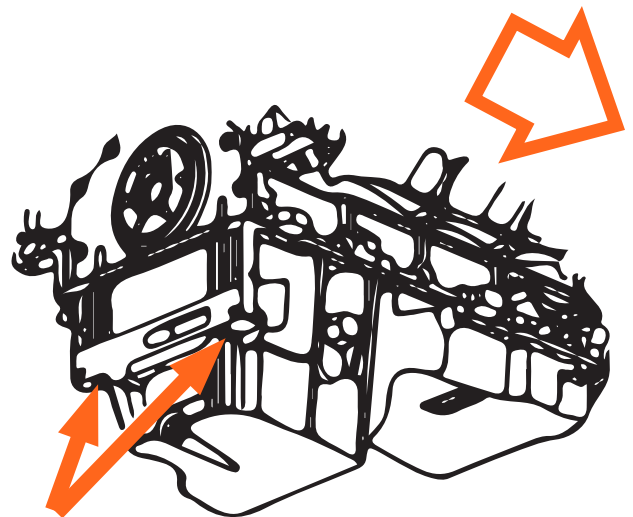
- Do not reuse the crankshaft oil seal or rear cover gasket.
- Do not apply any type of sealant to the rear cover gasket, unless specified.
- The special tool in this procedure is used to properly center the crankshaft rear oil seal.
- All gasket surfaces should be free of oil or other foreign material during assembly.
- The crankshaft rear oil seal **MUST** be centered in relation to the crankshaft.
- An improperly aligned rear cover may cause premature rear oil seal wear and/or engine assembly oil leaks.

**PLEASE WEAR
SAFETY GLASSES!**

Removal Instructions

STEP 1: Remove the automatic transmission flexplate.

STEP 2: Remove the oil pan-to-rear oil seal housing bolts.



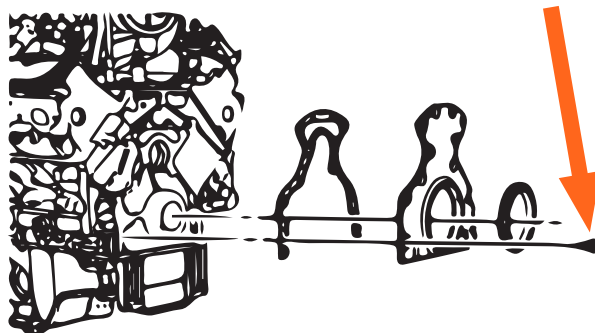
Disclaimer:

Even though every attempt is made to ensure this information is complete and accurate, it is impossible to account for all possible circumstances or situations. Please consult with a qualified auto technician before attempting to perform any work you are not qualified to do. Automobiles can be hazardous to work on; be sure to take all necessary safety precautions. Failure to do so may result in property damage or personal injury. Certain motor vehicle standards and performance requirements may apply to your motor vehicle (such as Federal Motor Vehicle Safety Standards by the National Highway Traffic Safety Administration). Be sure that your work is performed in accordance with such standards and that you do not disable any motor vehicle safety feature.

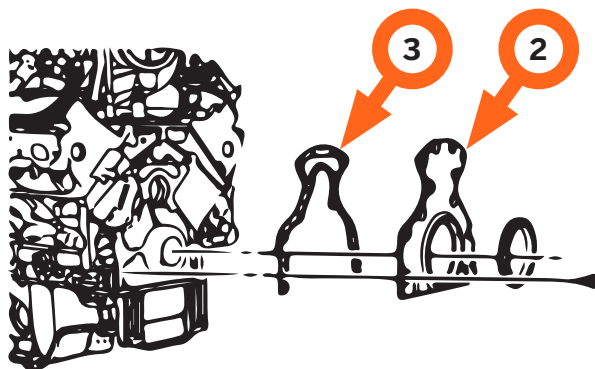
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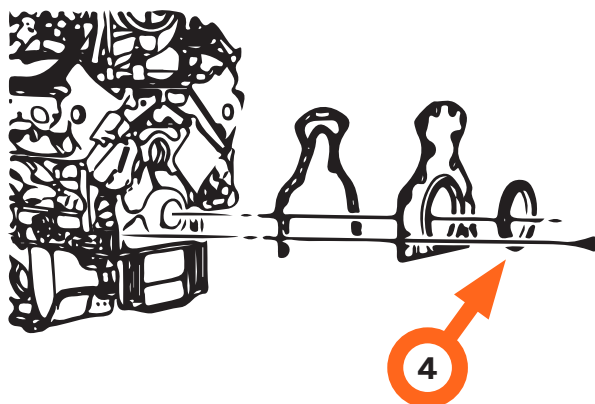
STEP 3: Remove the rear oil seal housing bolts.



STEP 4: Remove the rear oil seal housing (2) and gasket (3). Discard the gasket.



STEP 5: Remove and discard the rear oil seal.



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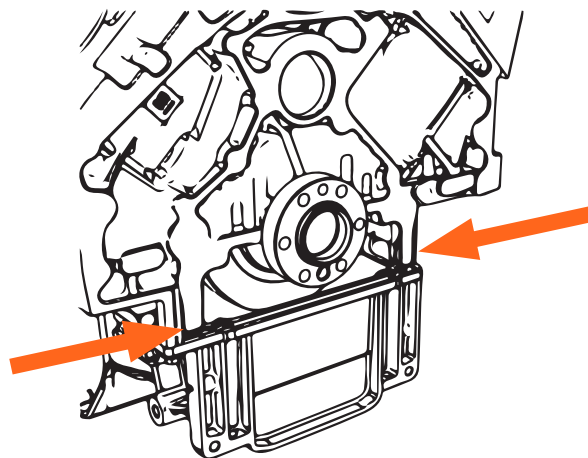
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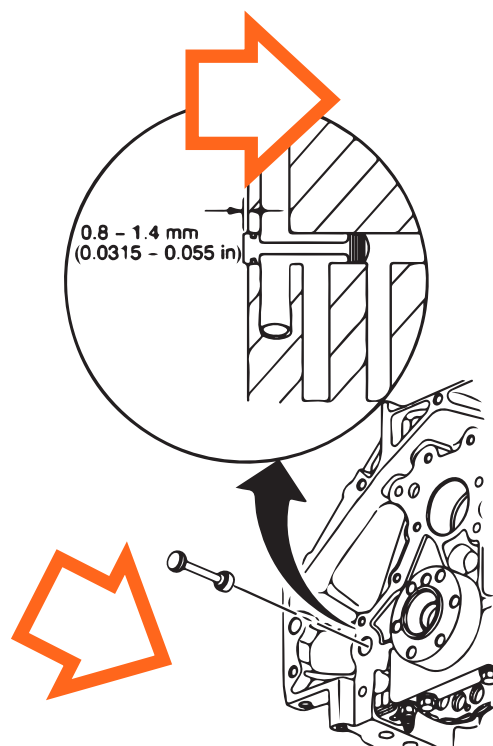
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Installation Instructions

STEP 1: Apply a 5 mm (0.2 in) bead of sealant, 20 mm (0.8 in) to the 2 joints at the rear of the block/pan.



STEP 2: Inspect the rear oil gallery plug for proper installation.



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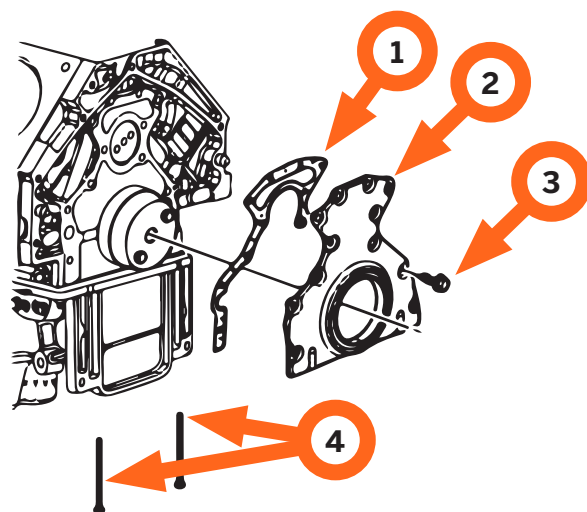
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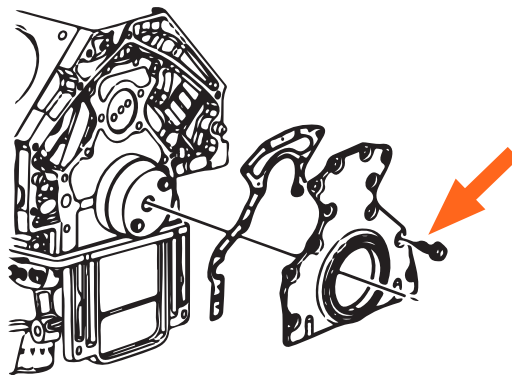
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STEP 3: Install the 635-000 guide cone and bolts onto the rear of the crankshaft.

STEP 4: Install the NEW rear housing gasket (1), rear housing with seal (2), rear housing-to-engine bolts (3) and oil pan-to-rear housing bolts (4).



STEP 5: Tighten the rear housing-to-engine bolts until snug. Do not overtighten. **NOTE:** Refer to shop manual or specific service procedures for fuel tank fastener safety.



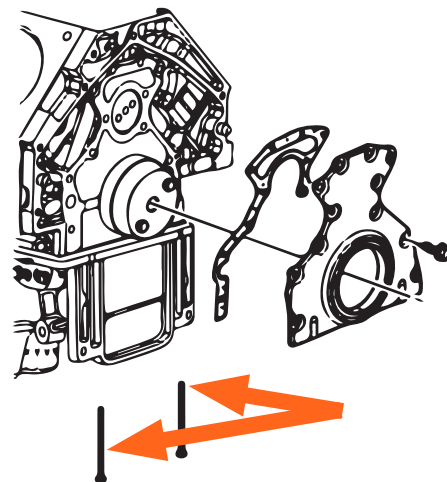
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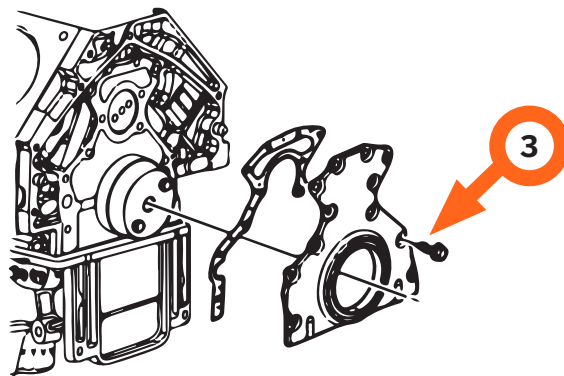
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STEP 6: Tighten the oil pan-to-rear housing bolts to **12 N·m (106 lb-in)**.



STEP 7: Tighten the rear housing-to-engine bolts to **30 N·m (22 lb-ft)**.



STEP 8: Remove the 635-000 guide.

STEP 9: Install the automatic transmission flexplate.

Still need help?
Please call our Technical Support team for assistance
from our team of certified automotive experts.
1-800-523-2492

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