

PART # 4686 INSTRUCTION SHEET FRONT & REAR MOTOR KIT

For SB Chevy V8 Engine & TH350 Transmission
(not powerglide) Into Chevy Vega (not for Monza Chassis)

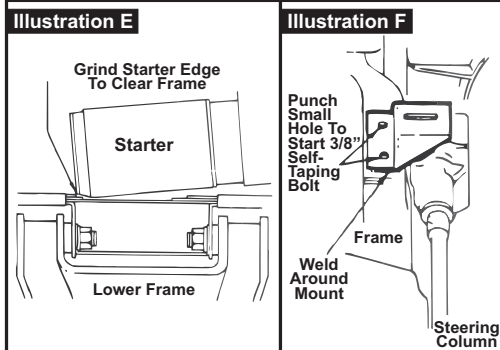
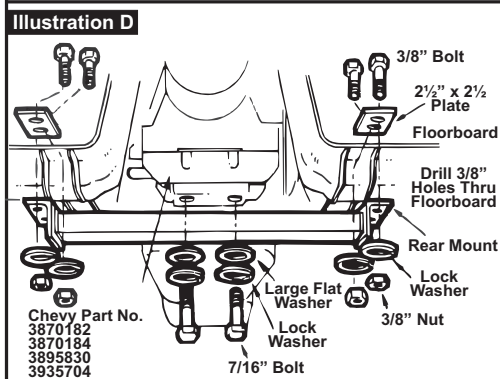
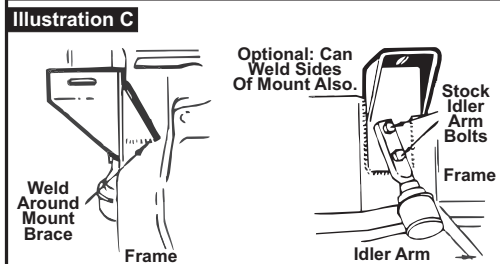
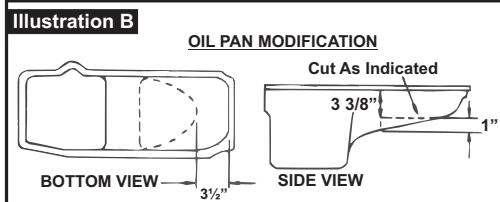
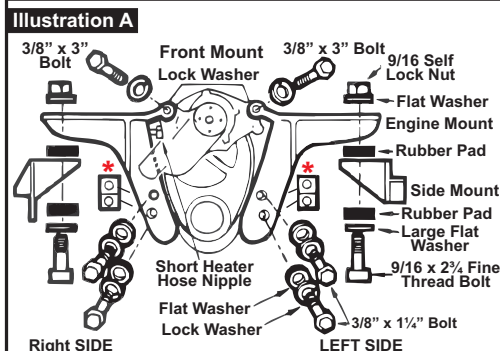
INSTALLATION INSTRUCTIONS:

NOTE: Please read carefully before starting installation.

1. Engine hoist should be used for this conversion. If hoist is not available, we strongly suggest the use of axle or jack stands for safety. Do not use bumper jack.
2. Remove stock engine and transmission.
3. Install front mounts to V-8 engine, using the top water pump holes, the original front mount holes and the 3/8" x 3" bolts included (**Tap 3/8"-16 if necessary - See illustration A**). You must use the "SHORT" water pump found on 1955-68 models.
4. Remove V-8 oil pan from engine and modify, so that it will clear steering. (See illustration B.)
5. Remove the idler arm and install the right-side mount, using the stock bolts and nuts to tighten. Weld along rear gusset. (See illustration C.)
6. Assemble engine and transmission. (Do not include starter at this time.)
7. Lower engine and transmission into place. Mark transmission tunnel and firewall for proper clearance around transmission. Remove engine and transmission. Modify transmission tunnel and firewall as necessary.
8. Again position engine and transmission. Make sure transmission is centered on chassis. Next, install the transmission mount, using stock Chevrolet transmission mount, either #3870182, #3870184, #3895830 or #3935704, any of which are acceptable as only difference is in the rubber compound. (See illustration D.)
9. Remove engine and transmission, modify and install starter. (See illustration E.) **NOTE: Make certain to use short starter (late model) such as Chevrolet #1108381, which bolts to the block. Or a starter which bolts directly to Ansen or Lakewood style bellhousing.**
10. Lower engine into position. Make sure everything is again centered. Install the transmission.
11. Install right-side motor mount assembly. Do not tighten at this time.
12. Check to be sure everything has remained centered. Install the left-side motor mount. (See illustration F.) **NOTE: Left side must be welded after engine is installed. Right-side mount weld (down sides) is optional.**
13. Install header system. We suggest a set of Hedman #68340 or 68346 heddres.
14. Check for sufficient clearance on headers. Engine may be relocated slightly, if necessary. Tighten all bolts.
15. You must use a floor shift or similar unit which uses a cable. Column shift can not be used.
16. If the heater is to be used, a short water pump heater hose nipple will be required to properly clear the front engine mount.

NOTE: This kit is offered only as an aid to making this conversion. It should be remembered that the Vega was designed to use a 4 cylinder engine and the installation of a V-8 can place unintended strain on other parts of the vehicle. Therefore, you should consider a late model narrowed rear end, heavy-duty springs or air cond. spacers in front to support the added weight, a larger fan or radiator (but check fan-blade clearance) and anything else which might take into consideration this modification.

ILLUSTRATIONS



*These spacers are inserted on the backside of the bracket and allow the 3/8" flat washers to install flush against the brackets.