

INSTRUCTIONS

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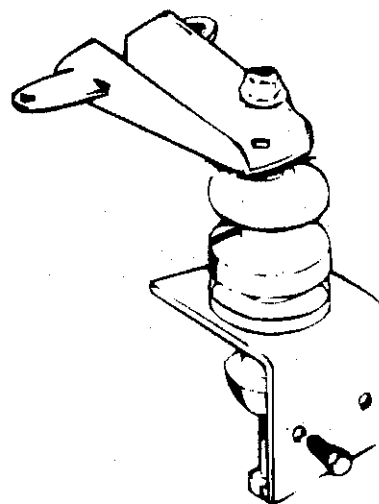
Small Block Ford to 1953-1964 Ford Pickup Mount

**PLEASE READ INSTRUCTIONS COMPLETELY
BEFORE STARTING YOUR INSTALLATION**

This bolt in motor mount conversion kit will install the Ford 221-351W V-8's into the 1952-1964 Ford pickups and panel trucks.

Parts List	
Description	Quantity
Frame mount bracket	2
Engine mount bracket	2
Rubber engine cushion	2
1/2"-13 x 1 1/2" GR 8 Hex head cap screw	4
1/2"-13 Hex nut	4
1/2" Lock washer	4
7/16"-14 x 1-1/4" GR 8 Hex head cap screw	4
7/16" lock washer	4
7/16"-14 x 3" GR 8 Hex head cap screw	2
7/16"-14 Nylon lock nut	2

1. Determine your vehicle's original engine centerline before removing engine.
2. Position the engine so the crankshaft centerline is in approximately the same position as the original engine. Make certain the new engine clears the firewall, steering box, brake master cylinder and radiator.



3. Bolt the engine mount brackets to the block using the four $\frac{7}{8}$ " x $1\frac{1}{4}$ " GR 8 bolts and the $\frac{7}{8}$ " lock washers using thread locker on the threads. Torque the bolts to 60 ft. lbs.
4. Bolt the frame mounts, rubber cushions and engine mounts together by installing the small rubber cushions over the $\frac{7}{8}$ " -14 x 3" GR 8 bolts with the step in the bushing pointing up. Slide the bolt and bushing up through the bottom of frame mounts through the rubber bushings and the engine mounts securing it with the $\frac{7}{8}$ " nylon lock nut. Torque them to 20 ft. lbs.
5. Make sure the engine is level side to side and mark the four engine mounting holes on the inside of the frame rails.
6. Remove the frame mounts and engine. Drill the four mounting holes through the frame rails using a $\frac{3}{4}$ " drill.
7. Bolt the frame mounts to the frame using the four $\frac{1}{2}$ "-13 x $1\frac{1}{2}$ " bolts, lock washers and nuts. Torque them to 90 ft. lbs. using thread locker on the threads. Install the rubber cushion on the top of the frame mounts and install the engine lining up the engine mounts with the frame mounts. Install the $\frac{7}{8}$ "-14 x 3" GR 8 bolts and nylock nuts, torque them to 20 ft. lbs.

IMPORTANT

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**Some items are not legal for sale or use in California on pollution controlled motor vehicles. These items are legal in California for racing vehicles only which may never be used upon a highway.



Speedway Motors Inc., P.O. Box 81906 Lincoln, NE 68501
800.979.0122 SpeedwayMotors.com

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