

'55-'57 Chevy LS Engine Mounts

1. Remove existing engine and transmission.
2. Locate the (2) rivets on the vertical surface of the inner right frame rail where it contacts the back of the main chassis cross member in the engine bay. (Illustration 1) These rivets will be removed and the holes used to locate the bolt in engine stands. These can be removed by grinding the head flush with the frame rail surface, center punching and drilling through with a $\frac{1}{4}$ " drill bit. The remaining rivet stem can be driven through the frame rail using a punch and hammer. Repeat this procedure on the left hand rail. Ream existing holes to $\frac{25}{64}$ ".
3. Bolt the right hand engine mount stand in place using the existing frame holes and the front holes in the engine mount stand plate using the included $\frac{3}{8}$ -16 x 1" bolts and $\frac{3}{8}$ -16 nylon lock nuts. Do not torque at this time.
4. Using the holes on the engine mount stand plate as a guide, mark the (2) rear holes.
5. Remove engine mount stand and drill the marked holes to $\frac{25}{64}$ ". Repeat for left hand side.
6. Reinstall the engine mount stands and torque to 23 ft-lbs. (Illustration 2)
7. Bolt the right hand engine mount adapter plate to the block using (3) M10-1.50 x 30mm flat head cap screws in the (2) rear and (1) lower front holes. (Illustration 3)
8. Bolt the urethane engine mount to the adapter plate using (2) $\frac{3}{8}$ -16 x $\frac{5}{8}$ hex head cap screws in the middle upper and lower tapped holes.
9. Install the M10-1.50 x 35mm socket head cap screw in the front upper hole. Torque all to 23 ft-lbs.
10. Repeat these steps for the left hand adapter plate and engine mount.
11. Install engine in chassis and locate the engine mounts over the engine mount stands. Install the (2) $\frac{7}{16}$ -20 x 3- $\frac{3}{4}$ " hex cap screws, washers and $\frac{7}{16}$ -20 nylon lock nuts. Torque to 35 ft-lbs.



Illustration 1

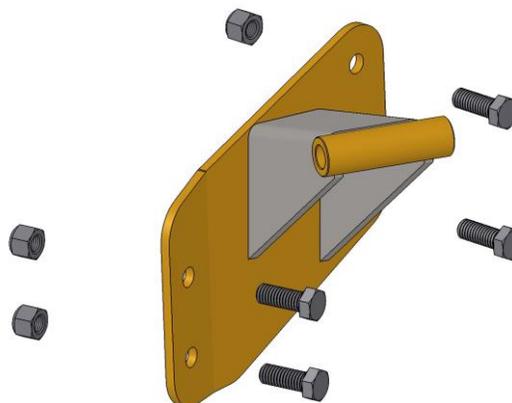


Illustration 2

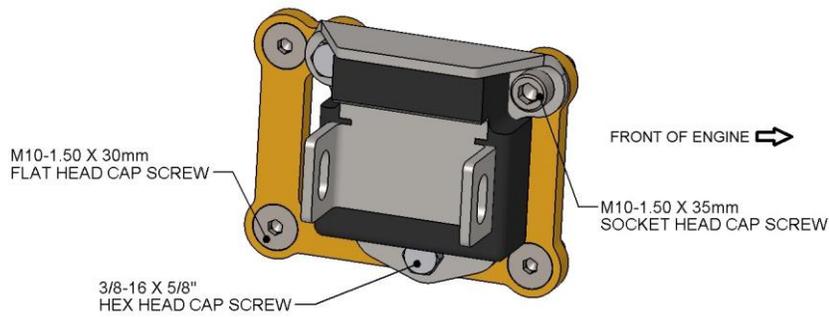


Illustration 3 – Right Side Shown, Left Side is Mirrored

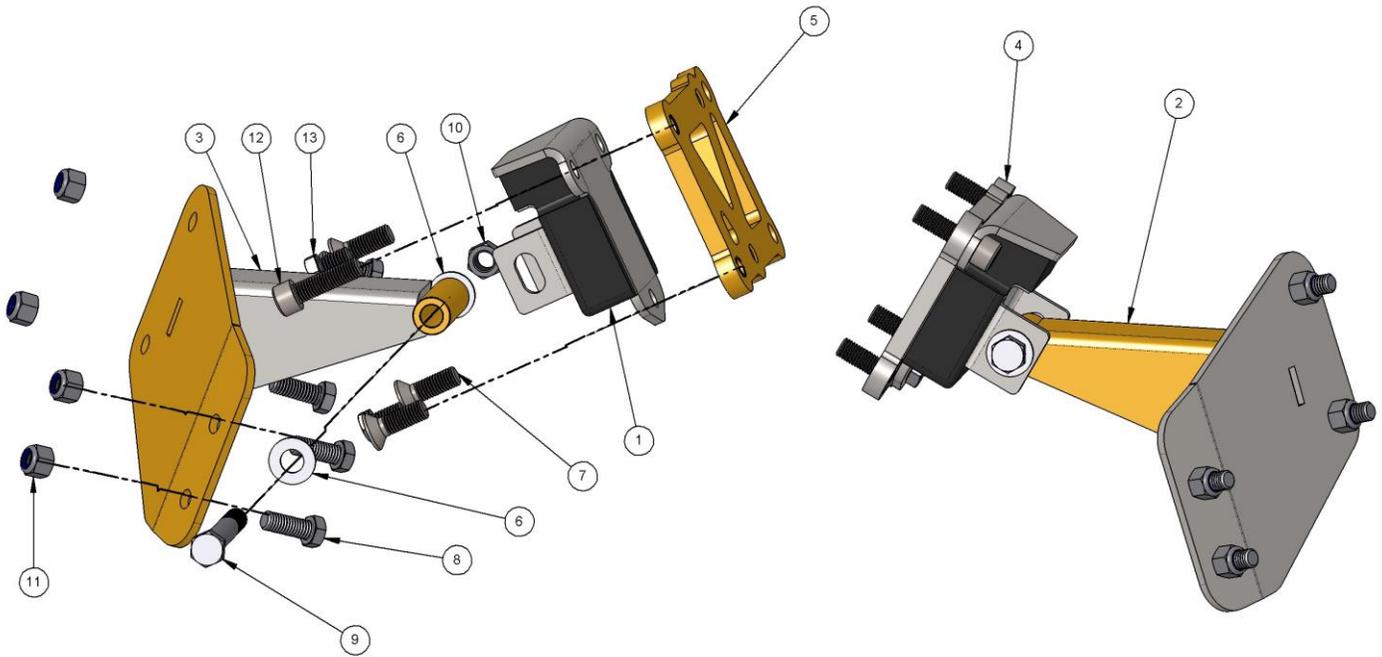


Illustration 4

ITEM NO.	DESCRIPTION	QTY.
1	URETHANE MOTOR MOUNT (PR)	1
2	LEFT HAND MOUNT	1
3	RIGHT HAND MOUNT	1
4	LEFT HAND ADAPTER PLATE	1
5	RIGHT HAND ADAPTER PLATE	1
6	FLAT WASHER, 7/16", SAE, STANDARD, ZINC PLATED	4
7	FLAT HEAD CAP SCREW, 10-1.50 X 30, ZINC PLATED	6
8	HEX CAP SCREW, 3/8-16 X 1, GR-5, ZINC	8
9	HEX CAP SCREW, 7/16-20 X 3 3/4, GR-5, ZINC	2
10	NYLON LOCK NUT, 7/16-20, GR-5, ZINC	2
11	NYLON LOCK NUT, 3/8-16, GR-5, ZINC	8
12	SOCKET HEAD CAP SCREW, 10-1.50 X 35, ZINC PLATED	2
13	HEX CAP SCREW, 3/8-16 X 5/8, GR-8, ZINC	4

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