

# INSTRUCTIONS

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**917-15121**  
**Small Block Chevy**  
**Claimer Oil Pan**  
**RH Dipstick**

## Oil Pump Pickup Installation

### To install a modified oil pump:

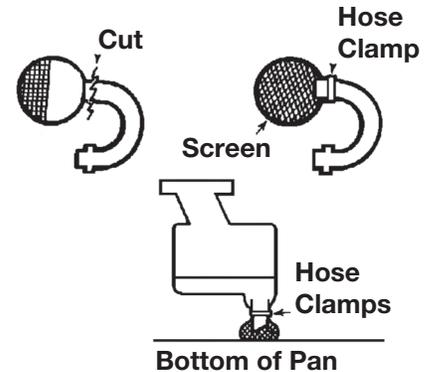
1. Drill and tap a 3/8" NPT hole into the bottom pump plate at center of rise in casting.
2. Screw in pipe. Measure and cut off to allow 1/8" to 3/8" clearance. Cut at angle so if pan is dented, pick up won't be blocked.
3. Install screen with hose clamp.
4. Plug stock pick up location with 5/8" expansion plug.

**NOTE:** We have available a prefabricated oil pump pick up designed to be used with our pan.

917-15135 for use with stock oil pump (OP55)

917-15136 for use with 4-bolt high volume oil pump (OP55HV)

**To install a stock oil pump pick up tube in pan or kit:** Cut off tube. Add screen and clamp as shown below



When using this oil pan with a custom pickup it is **CRITICAL** that you always check the clearance between the bottom of the oil pan and the pickup.

Perform the following to check your clearance:

1. Mount the engine on an engine stand and flip it upside down
2. Install the pickup onto the pump, (do not use any sealants between the pickup and the pump yet).
3. Bolt the pump onto the rear main
4. Use a small lump of modeling clay in a plastic bag and rest it on the pick up screen
5. Press the oil pan in place, with no gasket
6. Remove the pan and measure the clay to determine the clearance between the pan and pickup

**There should be 3/16" - 1/4" inch CLEARANCE**

7. If you have adequate clearance, skip to line 10
8. If you need to change the clearance on a fabricated steel pickup, you can reform (bend) the pick up tube using a vice and a large crescent wrench. You will also need to bend the mounting tab so the hole lines up
9. Re-install the pickup and re-check the clearance
10. Install the pickup into the pump using an oil resistant sealant and lock tight on the bolt
11. Torque the pump installation bolt
12. Make sure everything is clean and install the pan using a new gasket

# IMPORTANT

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