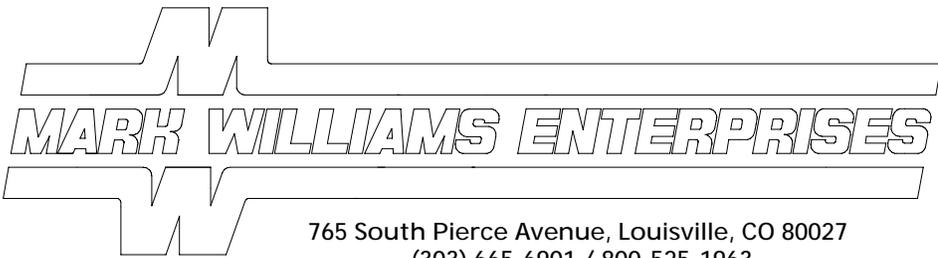


INSTALLATION - SERVICE INSTRUCTIONS



SERVICE BULLETIN

NO. 0054 PAGE 1 OF 1

12 BOLT CHEVROLET MODULAR HOUSING WITH STEEL OR ALUMINUM END BELLS

AUGUST 11, 1997

PART NUMBERS :

DESCRIPTIONS :

95012	12 BOLT MODULAR HOUSING WITH 4130 TUBES AND ALUMINUM END BELLS
95612	COMPLETE 12 BOLT MODULAR HOUSING WITH 4130 TUBES AND ALUMINUM END BELLS
95412	12 BOLT MODULAR HOUSING WITH 4130 TUBES AND STEEL END BELLS
95512	COMPLETE 12 BOLT MODULAR HOUSING WITH 4130 TUBES AND STEEL END BELLS

PARTS INCLUDED :

1-12 BOLT CHEVROLET ALUMINUM MODULAR CENTER SECTION WITH COVER, 1-O-RING FOR COVER, 8-STUDS FOR COVER WITH WASHERS AND 12 POINT NUTS, 1-FILLER CAP, 2-BEARING CUPS, 2-HOUSING ENDS OF CHOICE, 2-END BELLS WITH 4130 3" TUBES (STEEL OR ALUMINUM END BELLS), 2-END BELL O-RINGS, 2-ANTI ROTATION STUDS, 16-END BELL STUDS WITH WASHERS AND 12 POINT NUTS, 1-HOUSING VENT (2-TUBE RETAINERS, 8 EA-TUBE RETAINER STUDS WITH WASHERS AND NUTS WITH ALUMINUM END BELLS ONLY)

PRIMARY APPLICATION :

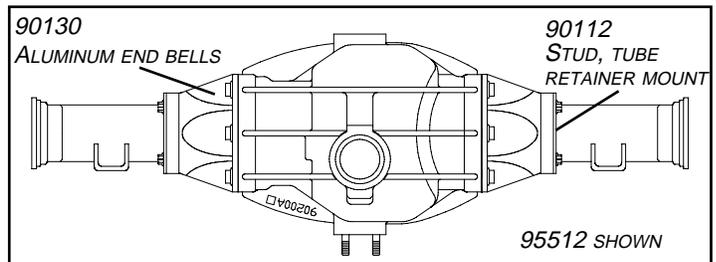
STREET ROD APPLICATION.

INSTALLATION OVERVIEW :

- 1) WHEN ASSEMBLING MODULAR HOUSING AND TUBES WITH END BELLS BE SURE ALL MOUNTING SURFACES ARE SMOOTH (FREE OF NICKS). IF PAINTING HOUSING ALL MOUNTING SURFACES AND STUDS MUST BE KEPT FREE OF PAINT.
- 2) BE SURE END BELL O-RING (2-045) ARE SEATED AND LUBED LIGHTLY.

TORQUE SPECS :

5/16" - 24 COVER ATTACHMENT STUD NUTS	15-20 FT. LBS.
3/8" - 24 TUBE RETAINER STUD NUTS (ALUMINUM END BELLS ONLY)	30-35 FT. LBS.
1/2" - 20 END BELL/MAIN CAP STUD NUTS	70-75 FT. LBS.



MAINTENANCE REQUIREMENTS :

PERIODIC INSPECTION OF TORQUE ON END BELL NUTS. PERIODIC INSPECTION OF WELD BETWEEN TUBE RETAINER AND TUBE. MODULAR HOUSING REQUIRES FOUR (4) QUARTS OF GEAR LUBE. MW RECOMMENDS TORCO SAE 85-140 GEAR OIL. IF REMOVING ANY OF THE STUDS, HEAT AROUND STUD AREA TO SOFTEN LOCTITE® BUILDUP.

