

# FITTING INSTRUCTIONS

## AH Crankshaft rear oil seal kit

**Partnumber: 013.491**

You can fit this kit when the engine is still in the car, but of course it's easier to work when it's removed.

- First remove the gearbox, clutch, flywheel and backplate.
- Check if the rear of the crankshaft is in good condition, if necessary polish with fine emery cloth.
- Rotate the crankshaft until the nuts form a perfect square and make sure it can't rotate.
- Screw the drilling bush into one of the crankshafts nuts using a 4.2mm drill bit. Drill a hole of 10mm deep and make sure that the drilling bush is well lubricated. Tap the drilled hole with a M5 x 0.8mm pitch tap to a depth of 8mm.
- Repeat the above mentioned operation in each of the 4 positions.
- After removing the spring, grease the oil seal very well before carefully opening to fit over the crankshaft. Make sure that the internal groove faces towards the block.
- Fit the spring by rejoining the needs and rolling into the seal groove. Make sure that the join in the spring is not adjacent to the join in the oil seal. The oil seal join should be facing towards the top of the engine block.
- After lightly coating the inner face of the top housing ( the threaded half ) with silicone instant gasket, locate it around the oil seal and fix loosely to the block with the M5 x 12mm all headed screws.
- Repeat the procedure with the lower housing, after coating the jointing surface with instant gasket.
- Join the 2 holes of the housing together with the two M5 x 40mm screws, using an easy breaking locking compound.
- Tighten the four 12mm screws.
- Use the template provided grind or machine the engine rear back plate to provide clearance around the housing.
- Refit the back plate after trimming the gasket to clear the housing.
- Re-assemble the flywheel, the clutch and the gearbox.