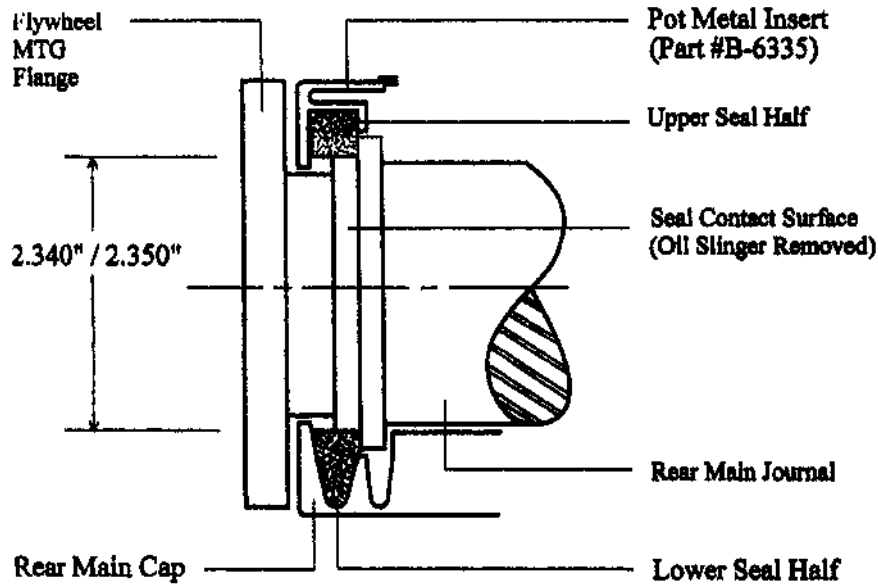


B-6337 Modern Rear Main Seal "B"



1. Remove oil slinger from crankshaft and polish seal contact surface to a bright polished finished dimension of 2.340"–2.350". Crank setup in lathe must be concentric with rear main journal. Some crank grinders can remove oil slinger using a narrow grinding wheel.
2. Fit all three main bearings to crank prior to installing neoprene cork seal. Remove caps and crank when bearings are fit. Apply some ULTRA COPPER RTV /permatex brand to backside of pot metal insert. Use thumb pressure to seat insert in block. Both ends must be flush with machined surface of block. Wipe excess RTV from block and insert. Allow time for sealer to cure.
3. Use thumb pressure to seat upper seal-half in insert that is now in block, making sure both ends extend equally. Coat seal contact surface on crank and I.D. of seal-half with heavy grease. Coat main bearings with assembly lube. Place crank in block.
4. Seat lower seal half in oil collector groove of rear cap, making sure both ends extend equally. Side of seal with taper faces front of block. Coat I.D. of seal-half with heavy grease. Assemble cap to block.

When using shims, push rear of shims in against seal as nuts are tightened evenly. New shims work better. No more than .015 of shims should be used with this seal.

NOTE: Cut tabs at rear of shims for good fit against seal. Remove approx. 1/8 inch from end of short tab and match long tab with short tab. Put a dab of sealer in space between tabs. Outer groove in original pot metal insert must be sealed at both ends.

- This seal can be used with Babbitt bearings and Insert bearings. If mains are pressurized, consider countersinking cap bolt holes in block for "O-Rings" or use sealer to seal space between bolts and bolt holes in block.
- Seal can be made to the dimension of your crank if the seal contact surface is greater than, or less than, dimension specified in # 1.
- On engine startup, do not rev engine. Let engine idle 3 or 4 times for 1 minute at 10 or 15 intervals to set seal and reduce friction.

This seal is designed and manufactured with the intent to improve the performance of the Model B Ford engine.