

Split Line Leaks

Models Affected

All Hi-Performance 2.5 L EFI and 2.0 L engines

Problem

Split line on cylinder blocks can leak due to excessive adhesive material on the mating surfaces of the cylinder block and crankcase cover.

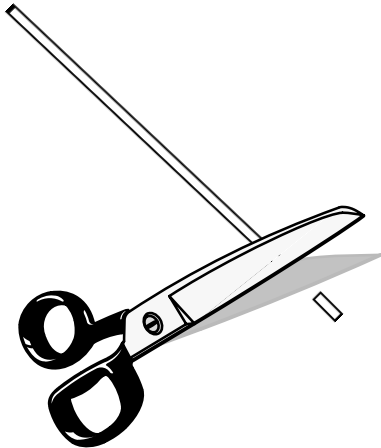
Corrective Procedure

1. Remove crankcase cover from cylinder block.

Crankcase Cover Removal

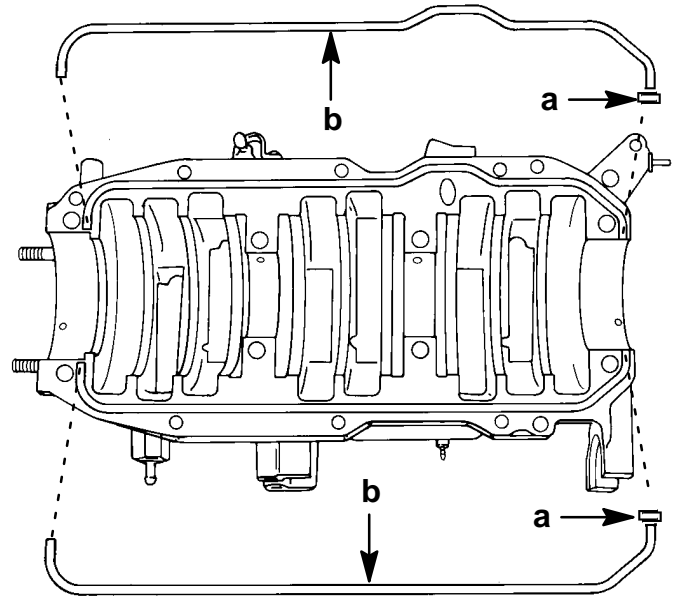
Refer to Service Manual 90-849240 for powerhead disassembly. Follow instructions in section 4A.

1. Thoroughly remove all mating surface adhesive from the crankcase cover and block with Quicksilver Power Tune P/N (92-15104A12) or a commercial cleaning solvent.
2. Using supplied Cork gasket strips, cut a small 1/4" piece of excess gasket strip to fit tightly across the end of the gasket channel.



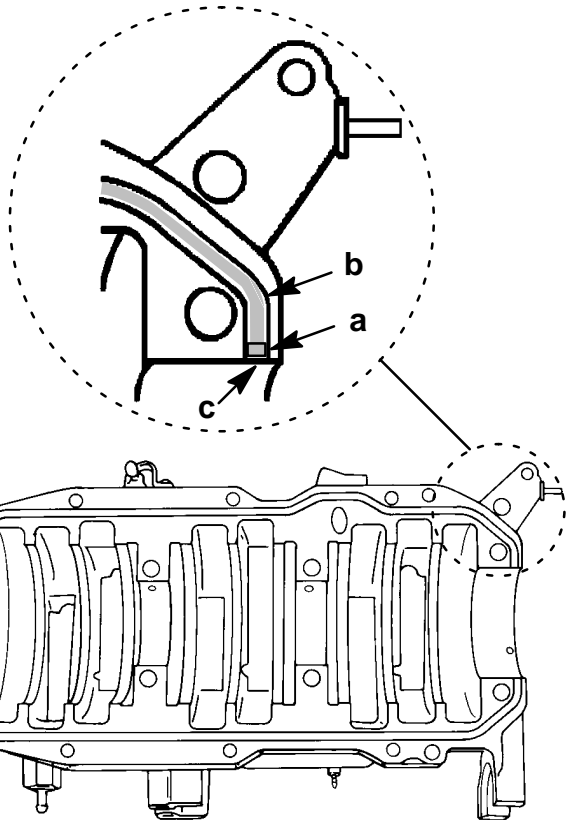
a - 1/4" Gasket Strip

3. Cut the remainder of the gasket strip to fit in the crankcase half gasket channel. Form a T with the gaskets as shown below on the upper bearing end of crankcase cover.



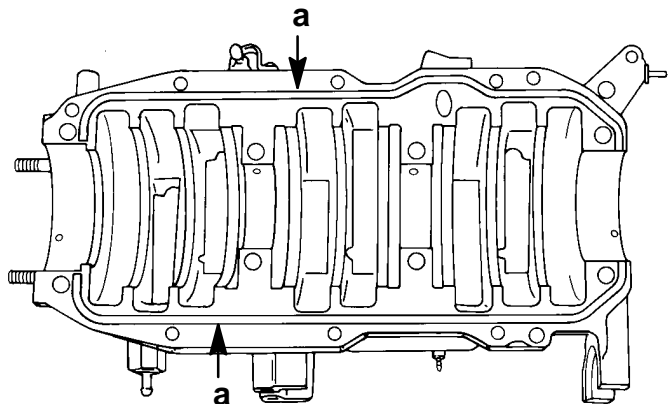
a - 1/4" Gasket Strip (2)
b - Gasket Strip (2)

- Position 1/4" piece of gasket strip horizontally and flush with the end of the gasket channel.
- Install remaining gasket strip into gasket channel firmly against small gasket strip already in place. Trim opposite end of gasket strip to be flush with end of channel.
- Perform the same procedure as above for the opposite side of the crankcase cover.



- a - 1/4" Gasket Strip
- b - Gasket Strip
- c - End of Gasket Channel

- Apply a thin, even coat of Quicksilver Perfect Seal P/N (92-34227-1) to the cork gasket strips only; **NOT** on the block surfaces.

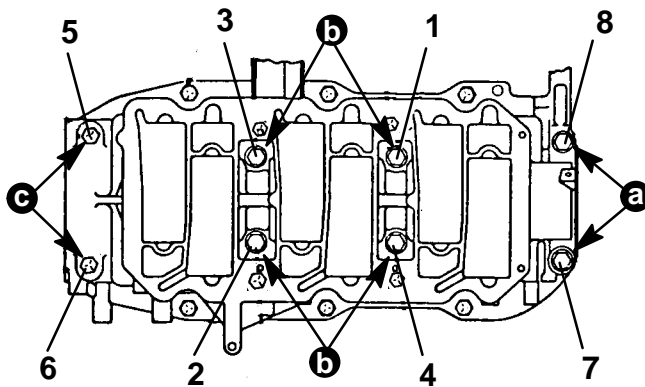


- a - Cork Gasket Strips

IMPORTANT: Ignore previous assembly instructions in service manuals of using light oil on the threads of bolts.

- Apply Loctite # 271 to threads and a light oil to the bolt face of all crankcase cover bolts.

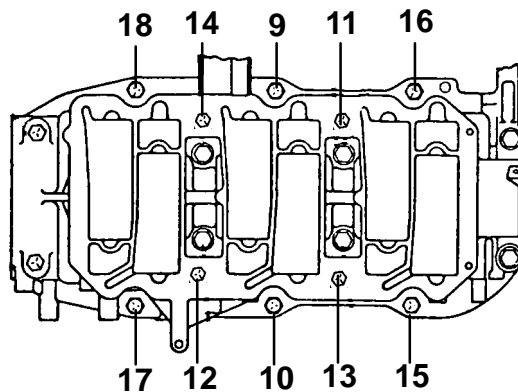
NOTE: Follow torque sequence and tighten the (8) center main bolts starting with 20lb. ft. and using 5 lb. increments until reaching specified torque.



- a - Top 2 bolts (#7&8) 45 lb. ft. (61 N·m)
- b - Middle 4 bolts (#1, 2, 3, &4) 40 lb. ft. (54 N·m)
- c - Bottom 2 bolts (#5&6) 35 lb. ft. (47 N·m)

- Install outer crankcase cover flange bolts and tighten in sequence shown.

NOTE: Older style crankcase covers may not have bolts #11, 12, 13, 14, below. Omit these from tightening sequence.



- a - Outer cover bolts 25 lb. ft. (34 N·m) sequence 9-18

- Tighten end cap bolts to specified torque.