



1. Remove side plate from engine block.
2. Remove old gasket material from all mating surfaces.
3. Place a drop of Red Loctite (provided) on the end of one set screw, the end opposite the Allen socket.
4. With an Allen wrench, screw the set screw into the block to a depth where the end is flush on the inside of the water jacket (making sure to use all available threads).
5. Repeat for the remaining seven set screws. See drawing for placement of the two longer set screws in cases where angle iron is used as an attaching point for the alternator support arm. If an MMI side plate is being installed with a welded attaching lug for the alternator support arm, the longer set screws can be installed deeper so as to have the same amount of threads extending past the nuts.
6. Allow Loctite to cure. Loctite recommends 24 hours cure time to reach full strength.
7. Place a bead of Permatex #2 on both sides of a new side plate gasket including closed ring beads around the mounting holes.
8. Slide side plate and gasket over the set screws, install brass flat washers and hex nuts finger tight.
9. Using an Allen wrench to hold the set screw stationary, tighten the brass nut with an open end or box wrench. Repeat for the remaining seven hex nuts. When using an angle iron bracket to secure the alternator support arm, remember to replace the bracket prior to tightening those particular hex nuts.

