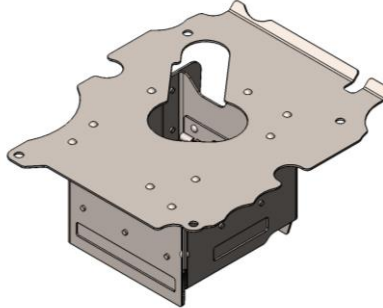




OFF-ROAD BAFFLE for LT OIL PANS (302-24 or 302-24BK) P/N 302-34



Instruction Sheet 199R12452

NOTE: This instruction sheet is intended for installation after a Holley LT oil pan (302-24 or 302-24BK) has previously been installed. If installing this baffle and a new oil pan, refer to the oil pan instructions for direction.

WARNING! These instructions must be read and fully understood before beginning installation. Failure to follow these instructions may result in poor performance, vehicle damage, personal injury, or death. If these instructions are not fully understood, installation should not be attempted.

INTRODUCTION:

Holley® Performance Products has written this instruction sheet for the installation of the **LT Off-Road Oil Pan**. This instruction sheet contains all the information needed to install the oil pan. Please read all the **WARNINGS** and **NOTES**, as they contain valuable information that can save you time and money. Holley® Performance Products cannot and will not be responsible for any alleged or actual engine or other damage, or other conditions resulting from misapplication of the oil pan described herein. However, it is our intent to provide the best possible products for our customer; products that perform properly and satisfy your expectations.

APPLICATIONS:

The 302-34 baffle works as an upgrade with P/N 302-24 or 302-24BK oil pans. It is already included with P/N 302-26, 302-26BK premium oil pans.

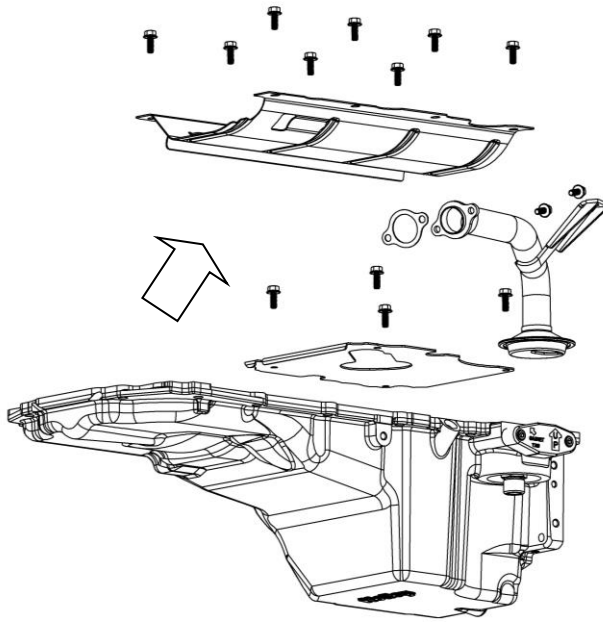
PARTS NEEDED:

- High Quality Gray RTV sealer (GM P/N 12378521 or equivalent)
- Thread locking compound (blue Loctite® or equivalent)
- Oil Filter (AC Delco® PF64 or equivalent)
- Oil
- Replacement gasket for pickup tube Holley P/N 108-210 (recommended)

REMOVAL:

1. Remove the oil level indicator tube.
2. Remove the bolt and the left rear transmission cover.
3. Remove the starter motor assembly.
4. Remove the engine oil cooler adapter.
5. Remove the bolt and right transmission cover.
6. Remove the bolts from the bell housing to the oil pan.

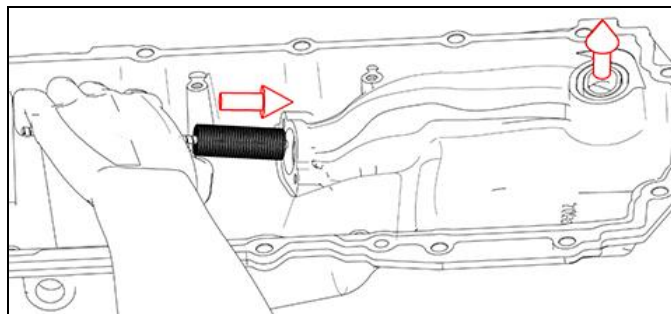
7. Remove the oil pan bolts.
8. Remove the Holley oil pan from the engine block.
9. Disassemble the Holley oil pan as shown. Use care when removing pickup tube gasket, if reusing.



- IMPORTANT:** All gasket surfaces should be free of oil or other foreign material during assembly. Inspect the engine block oil gallery passages to make sure they are free from any debris or restrictions.
- IMPORTANT:** It is advisable to wash all of the new parts well before installing to remove any dirt or debris from the packing and shipping process.

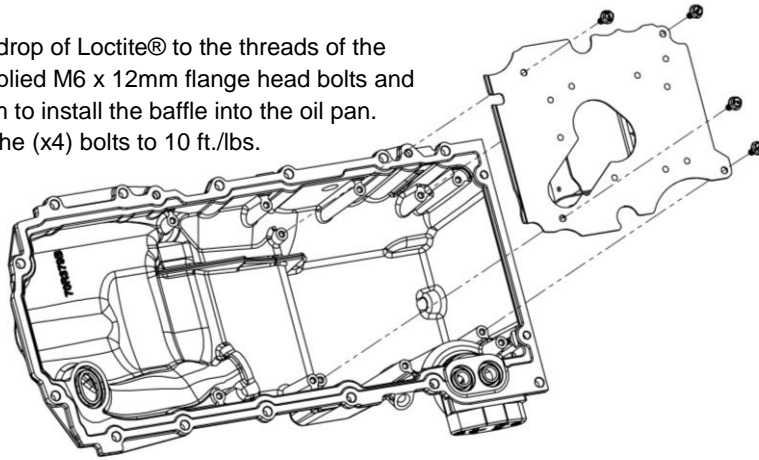
INSTALLATION:

WARNING! Push a flexible brush all the way through the pan's internal passage to ensure it is clean and unobstructed. Any obstruction can affect oil pressure and damage the engine. See photo below.



1. Pre-assemble pan.

Apply a drop of Loctite® to the threads of the (x4) supplied M6 x 12mm flange head bolts and use them to install the baffle into the oil pan. Torque the (x4) bolts to 10 ft./lbs.

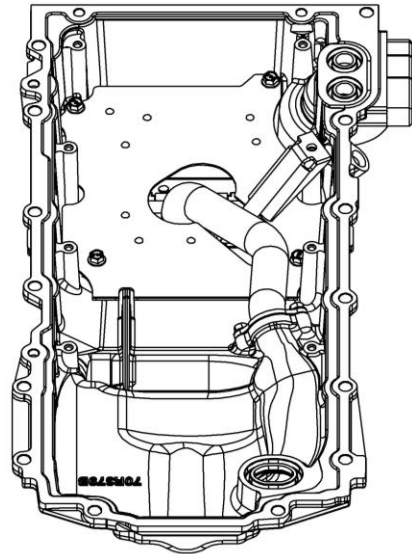
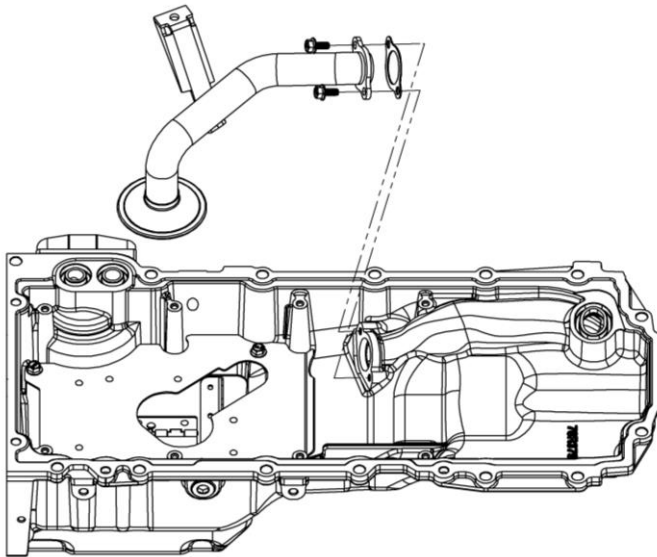


Standard baffle
not used when
installing 302-34

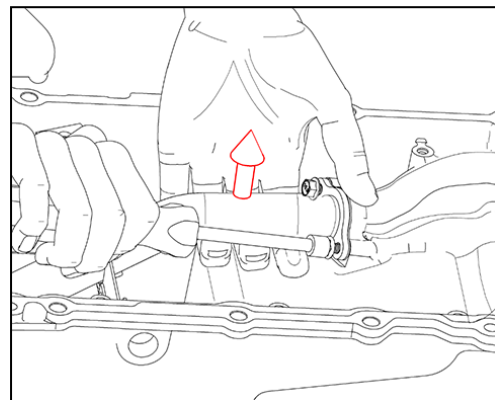


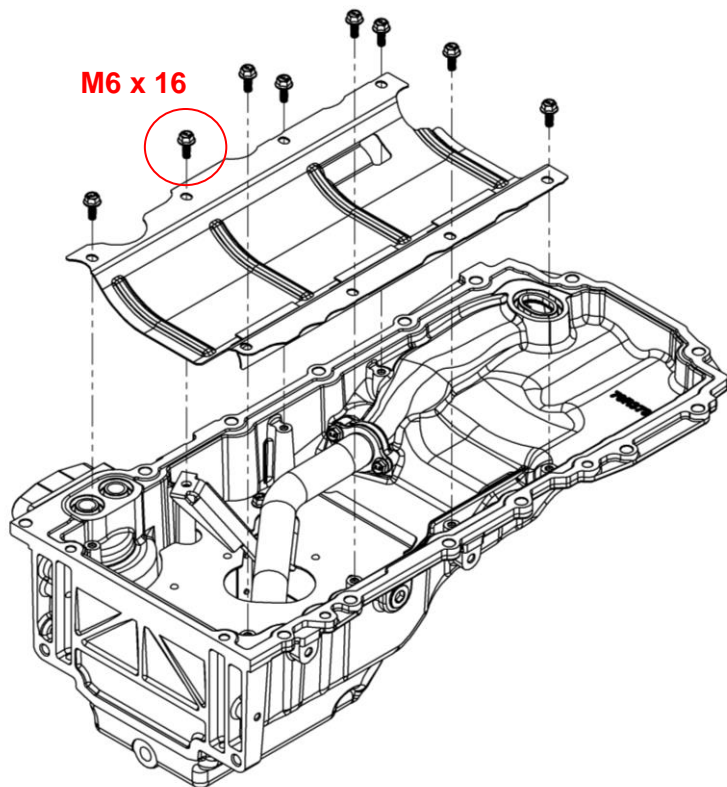
Reinstall the oil screen/pickup tube and **gasket** with supplied (x2) M6 x 16 flange head bolts. Apply a drop of blue Loctite® to the threads before installing. You may need to slightly adjust the bracket to provide precise alignment of the hole. Torque the bolts to 10 ft./lbs.

NOTE: Holley recommends replacing the pickup gasket with P/N 108-210.



IMPORTANT: While the bolts are started, but still loose, lift the pickup tube. Tighten the two bolts while maintaining the lifted position. This process ensures proper clearance between the pickup inlet and the pan floor.





M6 x 16

Reinstall the windage tray. Apply a drop of blue Loctite® to the threads of the supplied (x7) M6 x 12 flange head bolts. Install the (x1) M6 x 16 flange head bolt in the location that also goes through the pickup tube bracket. Torque the bolts to 10 ft./lbs.

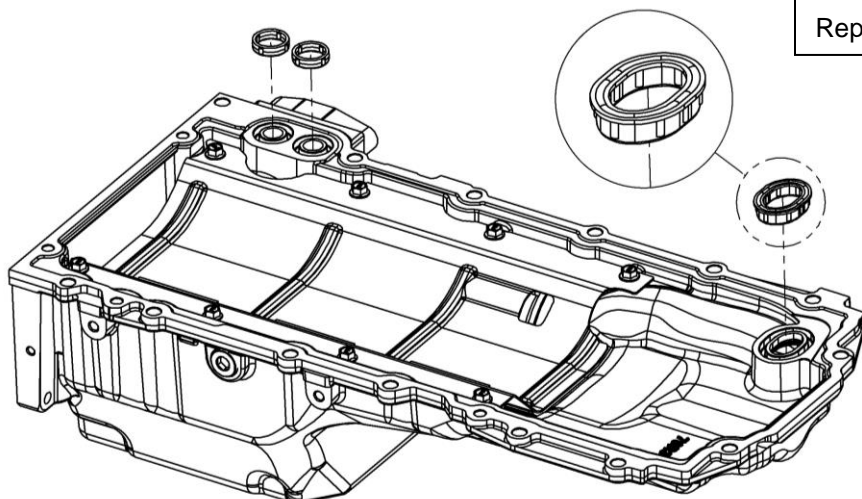
Confirm the two oil filter passage seals are still in place.

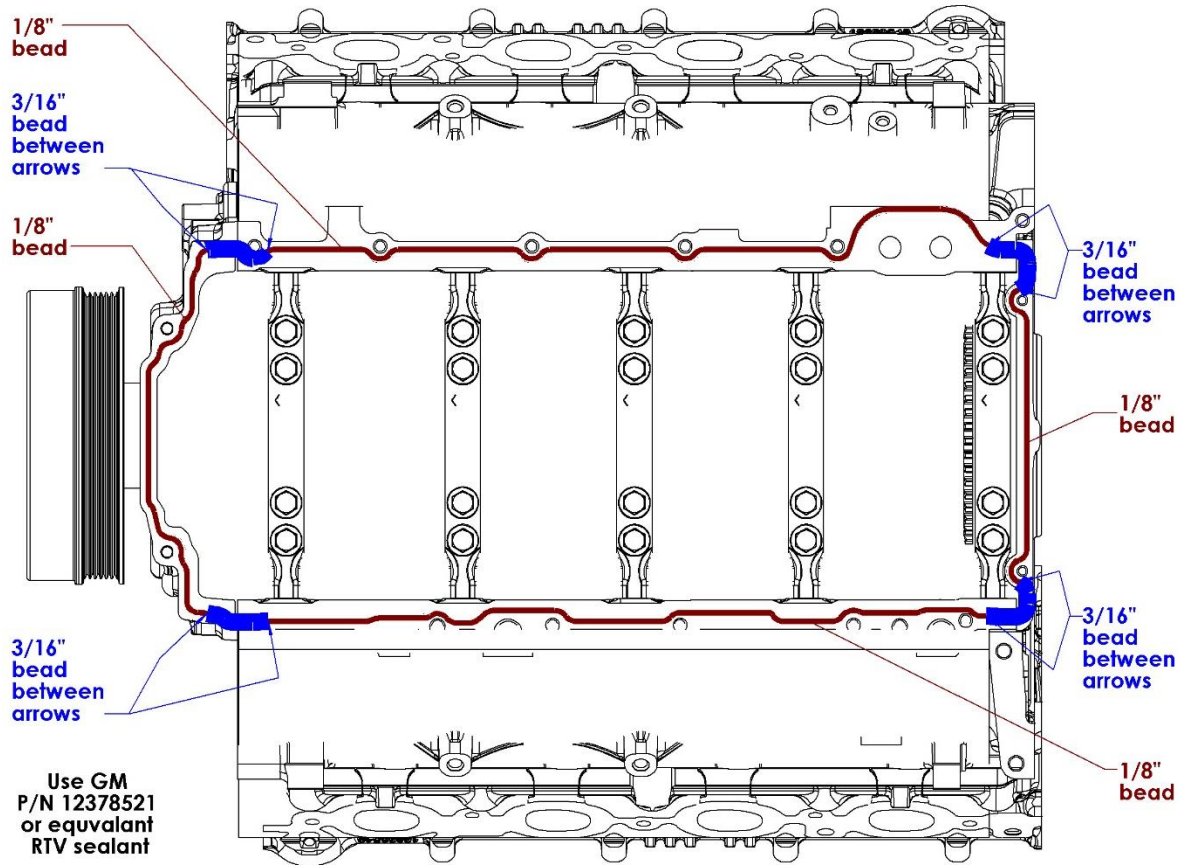
Replace as needed with GM P/N 12621086

Confirm pickup to oil pump seal is still in place.

WARNING: This seal must be oriented as pictured.

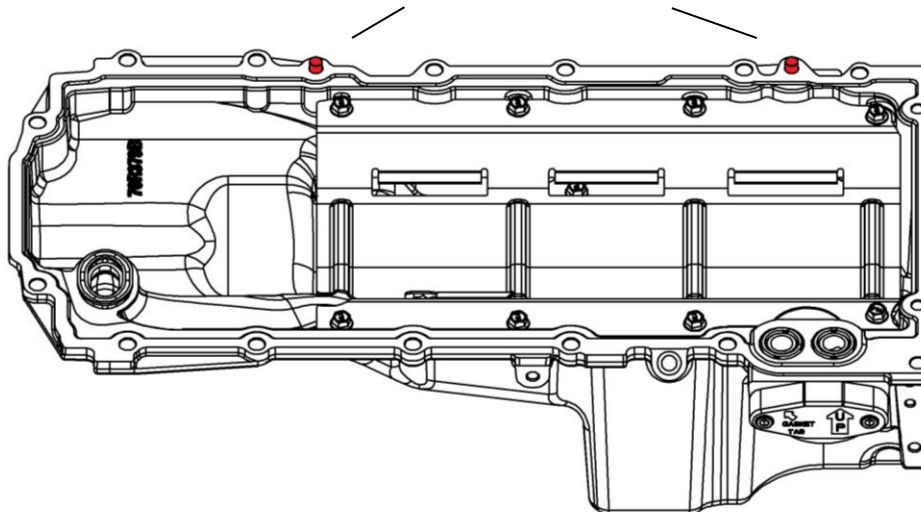
Replace as needed with GM P/N 12622368

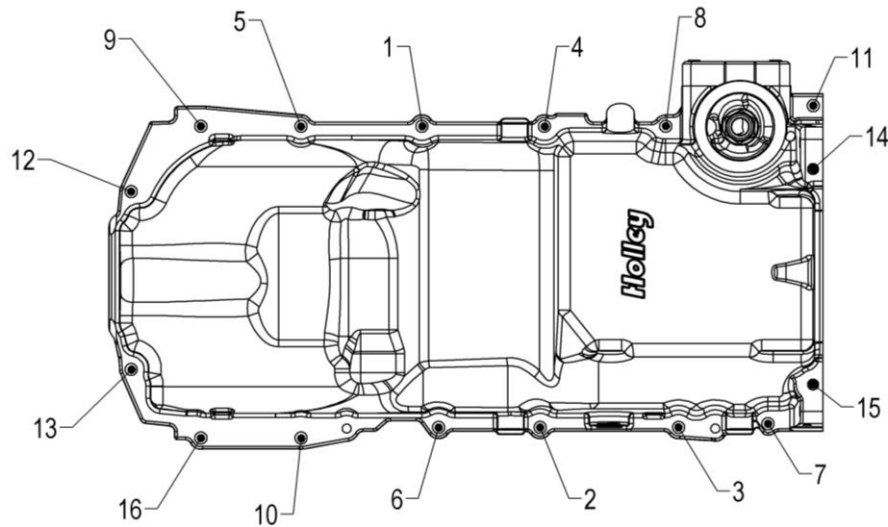




2. Apply a bead of RTV sealant (GM P/N 12378521 or equivalent) in the amount shown above.
3. Position the oil pan in place on the engine block.

NOTE: Pan will locate on pan's two dowel pins.





Torque:

M8 bolts to 18 ft./lbs. (bolts 1 through 13, and 16)

M6 bolts to 106 in./lbs. (bolts 14 and 15)

4. Reinstall the mounting bolts for the oil pan assembly.
5. Tighten the oil pan mounting bolts to 18 ft./lbs.
6. Tighten the oil pan mounting bolts M6 to 106 in./lbs.
7. Reinstall the bell housing to oil pan bolts. Tighten the bolts to 37 ft./lbs.
8. Reinstall the starter assembly.
9. Reinstall left and right rear transmission cover and bolt.

NOTE: Tighten the transmission cover bolt to 106 in./lbs.

10. Reinstall the oil level indicator tube. Confirm O-ring seal is in place. If tube is not new, replace tube seal before installation.

NOTE: Tighten the tube bracket bolt to 88 in./lbs.

11. Fill the crankcase with the proper quantity and grade of oil. Be careful not to overfill with oil.
12. Start the vehicle and check for leaks and adequate oil pressure. Use the dipstick to verify the oil level. This should read full after 6 quarts of oil with a new filter.

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