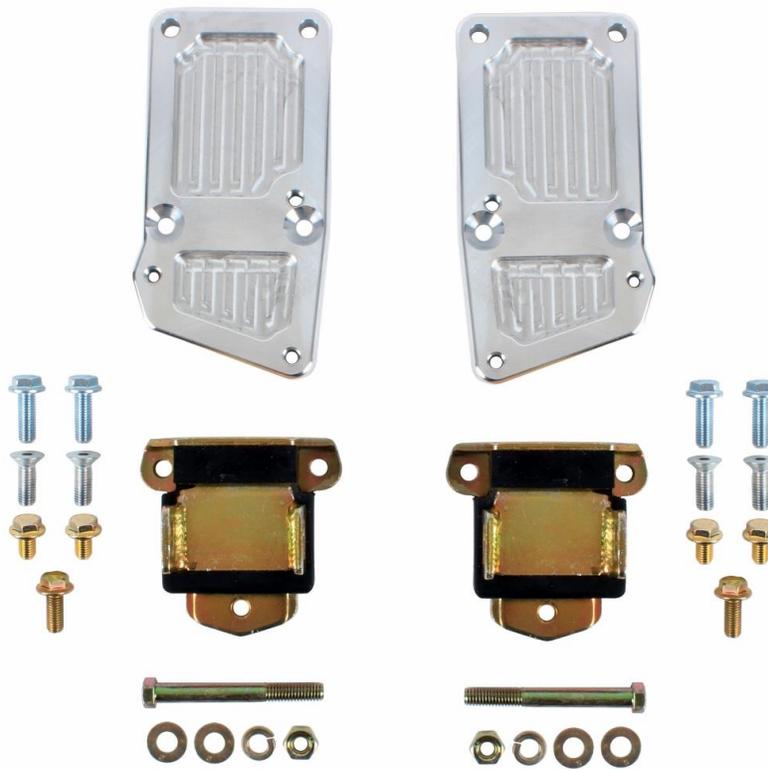




Detroit Speed
LS Engine Mount Kit
1963-82 Corvette
P/N: 060409DS

The Detroit Speed LS Engine Mount Kit will provide you with an ideal mounting solution for the LSx conversion into the Detroit Speed SpeedRay front suspension for a 1963-82 Corvette. This LS engine mount kit will also work for stock front suspension vehicles.



Item #	Description	Quantity
1	Engine Mount Adapter Plate, LH & RH	2
2	Polyurethane Engine Mounts	2
3	M10-1.5 x 30mm Countersunk Bolt	4
4	M10-1.5 x 30mm Flange Head Bolt	4
5	M10-1.5 x 25mm Flange Head Bolt	2
6	M10-1.5 x 16mm Flange Head Bolt	4
7	7/16"-14 x 3.75" L Hex Head Bolt	2
8	7/16"-14 Hex Nut	2
9	7/16" Flat Washer	4
10	7/16" Lock Washer	2
11	Instructions	1

Fastener Torque Specifications	
Application	Torque (ft. /lbs.)
Adapter Plate to Engine Block (Aluminum Block)	25
Adapter Plate to Engine Block (Cast Iron Block)	35
Engine Mount to Adapter Plate	25
Frame Stand to Engine Mount	30

1. To begin installation, locate the engine mount adapter plates in the kit. The milled side of the mount will face away from the engine with the smooth side going to the block. The end of the adapter plate with the angle cut will go to the front of the vehicle.
2. To mount the engine mount adapter plate to the engine, use two M10-1.5 x 30mm flange head bolts (#4) and two M10-1.5 x 30mm countersunk bolt (#3) per side. Use anti-seize on these bolts. On aluminum engine blocks, torque the bolts to 25 ft.-lbs. and on cast iron blocks, torque to 35 ft.-lbs. (Figure 1).



Figure 1 - Install Adapter Plate

3. The polyurethane engine mount will install next. **NOTE:** There may be some excess weld on the back of the engine mount that may need to be filed down to allow the mount to sit flat against the adapter plates.
4. Install the engine mounts to the adapter plates by using two M10-1.5 x 16mm flange head (#6) bolts in the top of the mount and one M10-1.5 x 25mm flange head bolt (#5) in the bottom of the mount. Use anti-seize on these bolts. Torque the upper bolts into the adapter plate to 25 ft.-lbs. For the lower bolt, torque to 25 ft.-lbs. on an aluminum block and 35 ft.-lbs. on a cast iron block (Figure 2 on the next page).

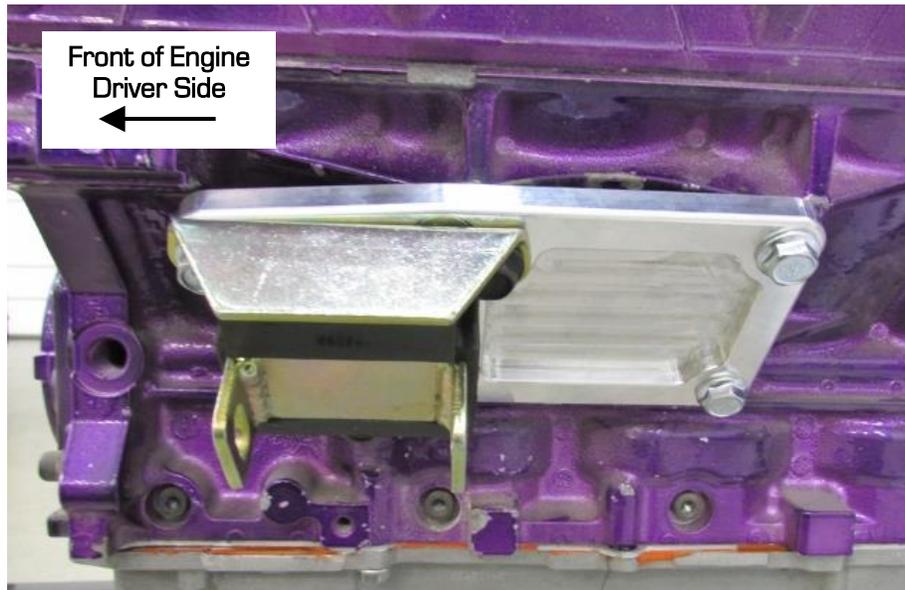


Figure 2 - Install Engine Mount

5. Once everything is positioned correctly on the engine, attach the engine to the frame using two 7/16"-14 x 3.75" L hex head bolts (#7). Use the provided flat washers (#9), lock washer (#10) and the hex nut (#8) to tighten everything in place. Once the engine is level, torque these bolts to 30 ft.-lbs. (Figure 3).

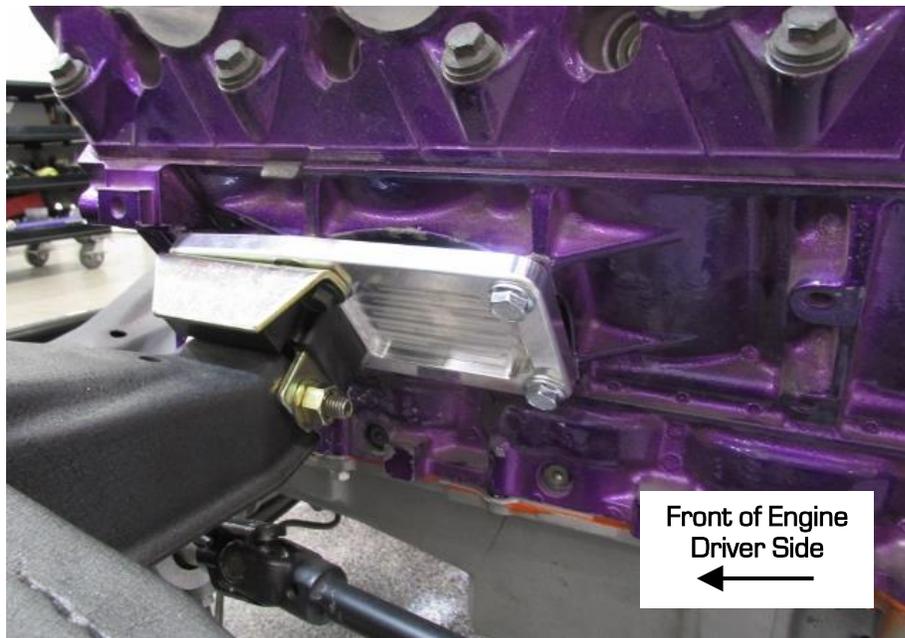


Figure 3 - Assembled View

If you have any questions before or during the installation of this product, please contact Detroit Speed at sales@detroitsspeed.com or 704.662.3272

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