



Thank you for purchasing your SBF-to-OM617 adapter from Doomsday Diesel LLC! Please read this entire page **BEFORE** installation. Please be aware of potentially sharp edges!

Adapter Plate to Engine:

- (7) M10-1.5x30 10.9 SHCS

Use medium-strength-thread locker and torque to 40 lb*ft.

The adapter plate must first be mated to the engine block. The back of the block should be bare. Make sure both 12mm dowel pins are in the engine block. Install the plate over the dowels and tap it tight against the block with a dead-blow hammer. You may choose to mock everything up and make the modifications to the upper oil pan before final torquing of the M10 bolts.

Starter:

This kit uses the OEM SBF starter. Using an angle grinder with an aluminum grinding disc or other suitable method, remove *just enough* of the upper oil pan to allow the SBF starter to be installed. Do not leave any sharp or jagged edges. Feather out the grind marks to make smooth transitions, as to prevent stress cracks from forming in the upper oil pan during service.





Crankshaft adapter:

- (6) M10x1.0X20 ARP Flywheel Bolts
Use medium strength thread locker and torque to 70 lb*ft.

Install your pilot bearing into the crankshaft adapter. Make sure the crankshaft mating surface and outside diameter are clean and smooth. Mount the crankshaft adapter and install the supplied ARP flywheel bolts, applying lube under the heads and medium-strength thread-locker to the threads. Torque in a star pattern.

Flywheel/flexplate to crankshaft:

- Use Factory hardware and torque specs to mate your flexplate or flywheel to the crank adapter

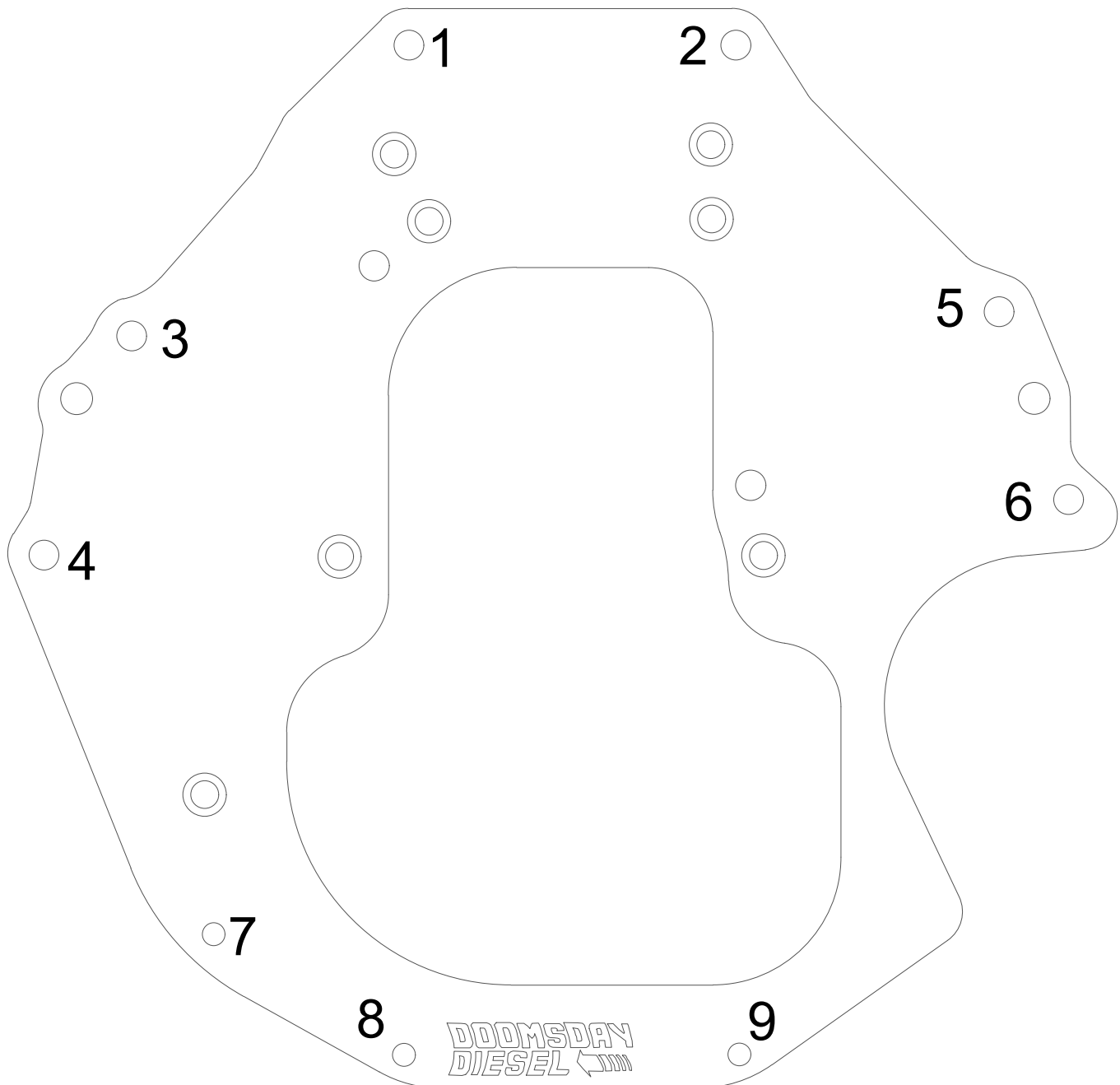
Bellhousing to Adapter Plate:

Start by installing the dowel pins into the adapter plate. You may want to dimple/chisel the dowel pin holes on the front side of the adapter plate to prevent the dowel pins from every coming out.

Holes may have to be drilled out on bellhousing for hardware to fit thru.

- (2) 7/16-20 x 2-1/2 HCS, Washers, Lock Nut – Positions 1 & 2
Torque to 60lb*ft.
- (4) 7/16-20 x 3-1/4 HCS, Washers, Lock Nut – Positions 3, 4, 5, 6
Torque to 60 lb*ft.
- (3) 5/16-18 x 1-1/2 FHCS – Positions 7, 8, 9

Use medium-strength thread locker and tighten firmly. Your bellhousing may not have these holes.



All torque values were attained from Fastenal. This product is for off road use only. This kit carries no warranty.