

## Installation Instructions for 50220-23, 50225-26, 50230-32, 50235-36 & 50290-91 Oil Pans

**Caution:** Before installing your JEGS oil pan the following steps **must** be taken to insure the proper fit and a leak free seal.

1. Unpack and inspect the pan and pickup tube to make sure the proper part number has been ordered and received for your application.
2. Before cleaning, the oil pan and pickup tube should be trial fit onto the block (with a full rotating assembly). Check for proper bolt hole alignment. Rotate the engine by hand to ensure that all of the internal components (crank, etc) do not make contact with the pan.
3. Measure the depth of the installed pickup tube and screen assembly vs. the depth of the pan including the gasket thickness. The pickup screen should be 1/4" to 3/8" off of the floor of the pan.
4. Also check for external interference (headers, chassis, starter, steering linkage etc).
5. Remove the pan from the block and check the baffle door for a full and free range of motion (if so equipped).
6. Remove the pickup tube from the oil pump and the oil pump from the block.
7. The oil pump pickup tube is a press fit design however it **must** be welded to the pump. Some oil pumps depending on design may need to be drilled out for the pickup tube. SB-Chevy tubes are 5/8" and BB-Chevy tubes are 3/4". Always use a high-nickel rod and a Tig welder for this portion of the installation. We recommend that this process be done off of the motor to minimize any potential fire hazard in the proximity of oil or other flammables.
8. Clean the oil pan, pickup and oil pump thoroughly inside and out. **Do not** just wipe off the outside of the pan. All internal components must be free from manufacturing residue and other contaminants to ensure a debris free installation.
9. Install the oil pump and pickup assembly following the manufacturers recommended torque specifications.
10. Final assembly of the pan should always include a quality silicone sealant applied to the gasket surface such JEGS Blue RTV Silicone 555-28030 or JEGS Premium Black RTV Silicone 555-28035 applied to both sides of the gasket surface and to the front and rear main seals. Extra care must be taken to insure that an adequate amount of sealant is applied to the corner/mating surfaces of the side rails and end seals. A dab applied to each oil pan bolt is also helpful in minimizing any potential leaks.
11. Install the gasket, seals, pan and bolts finger tight. Snug the bolts from the center of the oil pan outward while alternating from side to side. Tighten the bolts using the same method to 9-11 lb.ft. Repeat tightening and torque sequence. **Caution:** over tightening may cause the gasket to 'push-out' thus creating a leak rather than preventing one.

	Standard Volume	High Volume	
Oil Pan	Pickup Tube	Pickup Tube	Pan Gasket
555-50220	555-50240	555-50241	555-210091
555-50221	555-50240	555-50241	555-210091
555-50222	555-50240	555-50241	555-210091
555-50223	555-50240	555-50241	555-210094
555-50225	555-50242	555-50243	555-210091
555-50226	555-50242	555-50243	555-210094
555-50230	555-50245	555-50246	555-210192
555-50231	555-50245	555-50246	555-210192
555-50232	555-50245	555-50246	555-210193
555-50235	555-50245	555-50246	555-210192
555-50236	555-50245	555-50246	555-210193
555-50290	555-50295	555-50295	555-210290
555-50291	555-50296	555-50296	555-210291



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