

INSTALLATION INSTRUCTIONS
LT1 Aluminum Intake Manifold
For 1991 and Later Gen II Engines; non-EGR
PN 24502592 LT1 or PN 24502574 LT4

- **DESCRIPTION:** This manifold offers a way to use a carburetor and standard distributor on LT1 style engines that are to be used in non-emissions controlled applications only. It will only fit 1991 and later GEN II (RPO LT1) engines.
- **EMISSION SYSTEMS:** This manifold will not accept any EGR (Exhaust Gas Recirculation) equipment or exhaust-heated chokes. This manifold is not legal for use on any emissions controlled vehicle where such equipment is required.
- **THROTTLE BRACKETS:** Due to the increased distance between the two left-rear manifold hold-down bolts (2.68" on LT1 vs. 2.32" on standard Small Blocks) the throttle and kickdown bracket on some vehicles will not fit without modification. A throttle bracket that mounts to the carburetor base bolts is recommended.

INSTALLATION INSTRUCTIONS

- 1) Use either GM 12524653 intake gasket set (or 12367777 for LT4 applications) when installing this intake manifold.
 - 2) Fully clean the cylinder head intake flanges and the engine block end seal surfaces. Attach the intake gaskets to the heads using the locator pins provided with the gaskets.
 - 3) Do not use cork or rubber end seals. They tend to slip and leak. Use RTV silicone sealer instead. Apply a ¼" high bead across each block end seal surface, overlapping the intake gasket at the four corners.
 - 4) Set the manifold down onto the gaskets, taking care to not slide across the silicone. Using Figure 1 as a guide, first torque all of the manifold bolts to 15 ft-lbs in the sequence shown; then repeat the sequence tightening to 25 ft-lbs.
 - 5) Most applications will convert to a standard distributor. If you are retaining your LT1 style front mount distributor (you'll need a special ignition computer to do this), a manifold distributor hole block-off plug is included. Attach it using a standard distributor gasket, clamp, and hold-down bolt arrangement.
- If more information is needed about this engine, GM Service manuals are available from:
 - Helm Incorporated • P.O. Box 07130 • Detroit, MI 48207

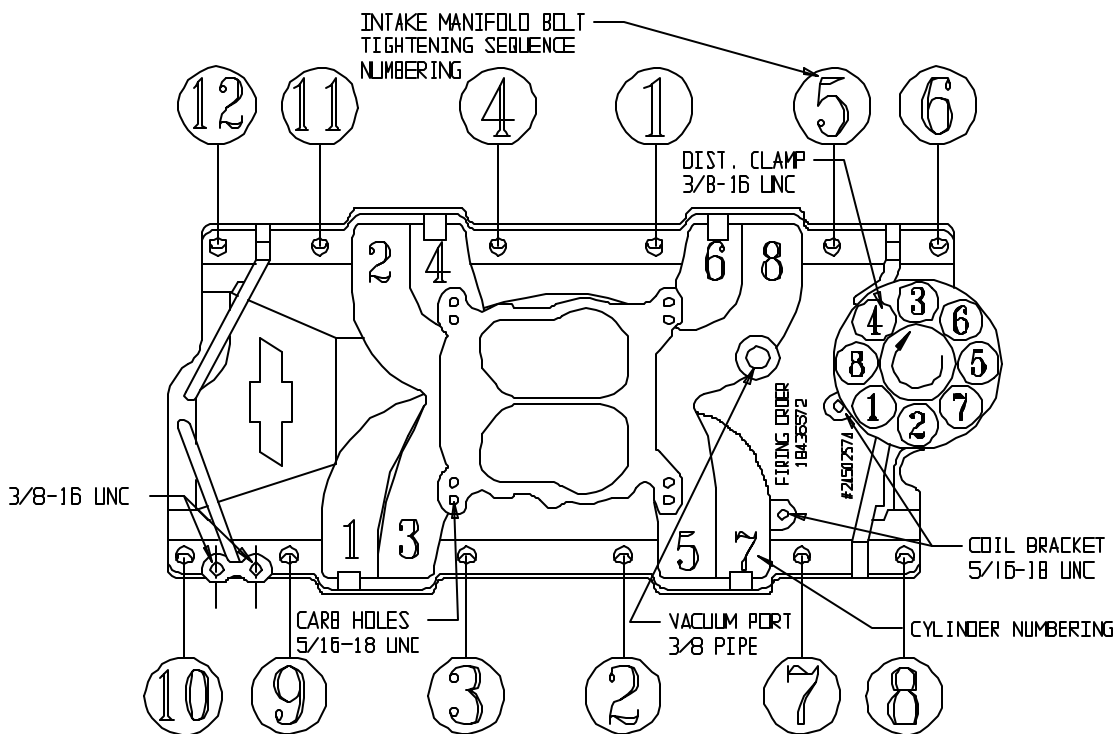


FIG 1 - Intake Manifold Bolt Tightening Sequence,
Small Block Chevy Firing Order 1-8-4-3-5-7-2,
Turn Distributor Counter Clockwise to Advance Ignition Timing



INSTALLATION INSTRUCTION PROOFING FORM

Date: 2/15/01

From: Brent McCarthy

To: Jack Mayberry

Part No./
Description: **24206** -GM SPO LT-1 Dual Plane Manifold. New instruction sheet. None existed before.

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