



## BILLET/FABRICATED VALVE COVER INSTRUCTIONS

Gasket Rail notches should be checked against your particular head prior to running the engine. These notches may be modified easily with a die grinder.

Clean the gasket surface of both the cylinder head and the valve cover rail. Many petroleum cleaning products leave a residue that can prevent a good seal. Valve covers using 1/4 to 5/16 hardware should be torqued 80 to 100 inch/pound respectively, and tightened in a crisscross pattern.

### If you are going to install positive locking breathers or fittings:

**First protect the top of the valve covers by placing a protective material on your work surface. Note you will be working inside the valve cover so the top will be against your table.**

1. Decide where the accessory will be attached. Mark the center of the hole with a center punch.
2. Use a hole saw (the size will be called out in the instructions of the product you are attaching to your valve cover) next use a round file to clean the edges of and if needed, enlarge the hole slightly.
3. To install grommets cut a 1-3/16IN. hole through the valve cover. Then use a round file to open the hole to approximately 1.22IN.

**NOTE: Grommets for fabricated valve covers have a .090IN. groove. A standard valve cover grommet will not only be a loose fit causing leaks but has a tendency to fall out (with your breather).**

Check the Moroso catalog for a selection of accessories to complement your new Moroso Valve Covers, such as Breathers for street and positive locking breathers for race applications.

Wing Nuts and Hold Down Tabs,

Stud Kits, PCV Grommets and Breather/Oil Separator Grommets.

Crankcase Evacuation Systems

Vacuum relief Valves

Positive seal fittings for vacuum pump connection, requires no welding.

Vacuum gauge fitting

Valve Cover Gaskets: See Chart Below

### Cylinder Head

### Moroso Gasket Part#

SB CHEVROLET (Including 18 deg.)	93020
SB CHEVROLET (Clearanced Rail)	93021
GM LS Series	93025
BB CHEVROLET	93040
BIG CHIEF	93045
SB CHRYSLER	93050
BB CHRYSLER	93055
SB FORD	93060
BB FORD	93065

*For Technical Assistance, Call Moroso's Tech Line at*  
**(203) 458-0542, 8:30am – 5:00pm Eastern Time**

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