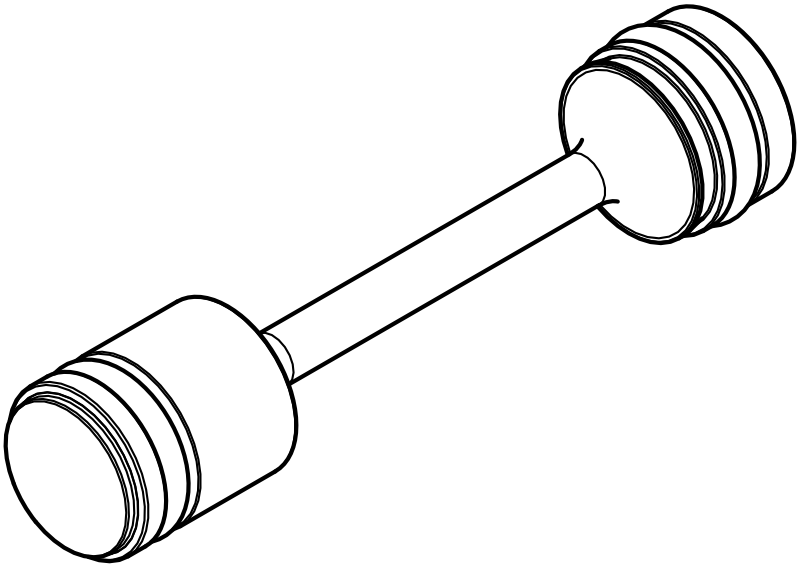


IMPROVED 
R A C I N G

**REAR OIL GALLEY PLUG "BARBELL"
FOR GM LT SERIES ENGINES**

PART NO. EGM-502
MADE IN USA



**Important: Read these instructions in their
entirety prior to installation.**

For contact information, visit www.improvedracing.com
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APPLICATIONS

- All Gen V GM EcoTec / LT / Vortec family engines

SCHEMATIC & PARTS LIST

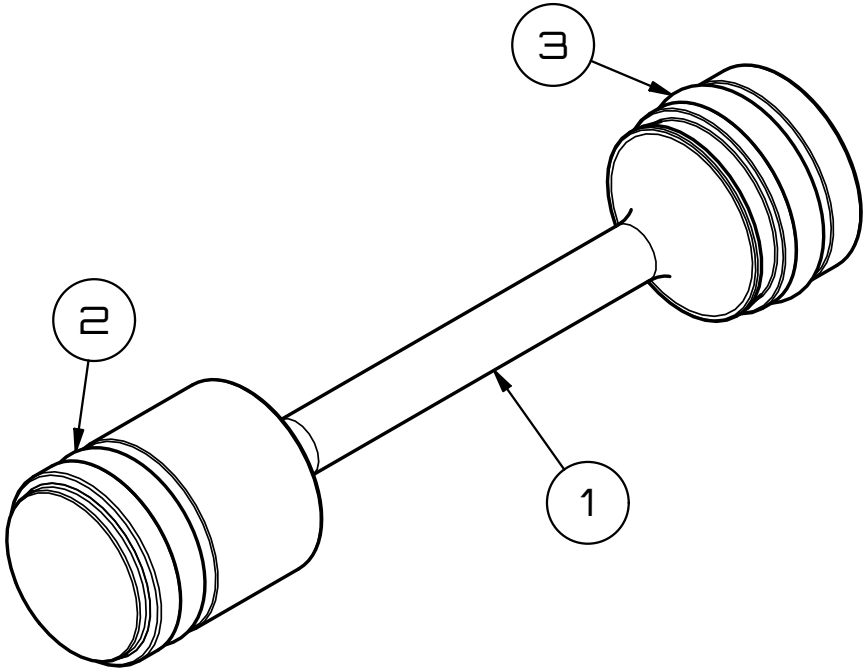




Figure 1 - EGM-502 Schematic

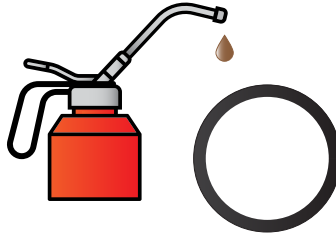
Item	Qty	Part Number	Description
1	1	EGM-502-01	Rear Oil Galley Plug "Barbell" for Gen V GM V8s
2	1	HRG-1024	Front O-ring for Plug
3	1	HRG-1027	Rear O-ring for Plug


TECHNICAL SPECIFICATIONS

Maximum Operating Temperature	400°F (204°C)
Minimum Operating Temperature	-22°F (-30°C)
EGM-502 Info	CNC-Machined 6061-T6 Billet Aluminum, M4x0.7 Thread
HRG-1024 Info	AS568 Dash Size -111 FKM (Viton Rubber), 75A
HRG-1027 Info	AS568 Dash Size -112 FKM (Viton Rubber), 75A








BEFORE YOU BEGIN

-  **This product should only be installed by a qualified mechanic.**
-  **Improper installation could result in severe engine damage.**



-  Lubricate O-rings prior to installation to prevent damage and ensure a leak-free seal.

INSTALLATION INSTRUCTIONS

-  The rear engine cover must be removed to install this product. It is critical that the instructions, tightening sequences and corresponding torque values detailed in the GM factory service manual for the engine be followed during removal and reinstallation of the rear engine cover.
1. Use a flat prying tool to remove the OEM plastic plug from the left rear oil galley of the engine block (see Figure 2 for hole location).
 2. Inspect the inside of the oil galley for dirt and debris and clean if necessary.
-  **Debris left in the oil galley may damage the O-rings and prevent a proper seal.**
 - 3. Generously slather assembly lube onto both O-rings.
 -  **O-rings will be damaged if they are not lubricated prior to installation.**
 - 4. Carefully insert the plug into the rear oil galley shown in Figure 2.
-  The plug is installed correctly when the rear of the plug is flush with the engine block sealing surface for rear the timing cover.
 -  Any M4x0.7 screw can be threaded into the rear of EGM-502 for more control during insertion.
 -  **If the plug is difficult to insert during installation, remove it and inspect both the oil galley and plug for possible interference issues.**
 -  **Inspect the O-rings for damage prior to reinstallation. Do not reuse damaged O-rings.**

⚠ Contact [Customer Service](#) if the plug does not install flush.

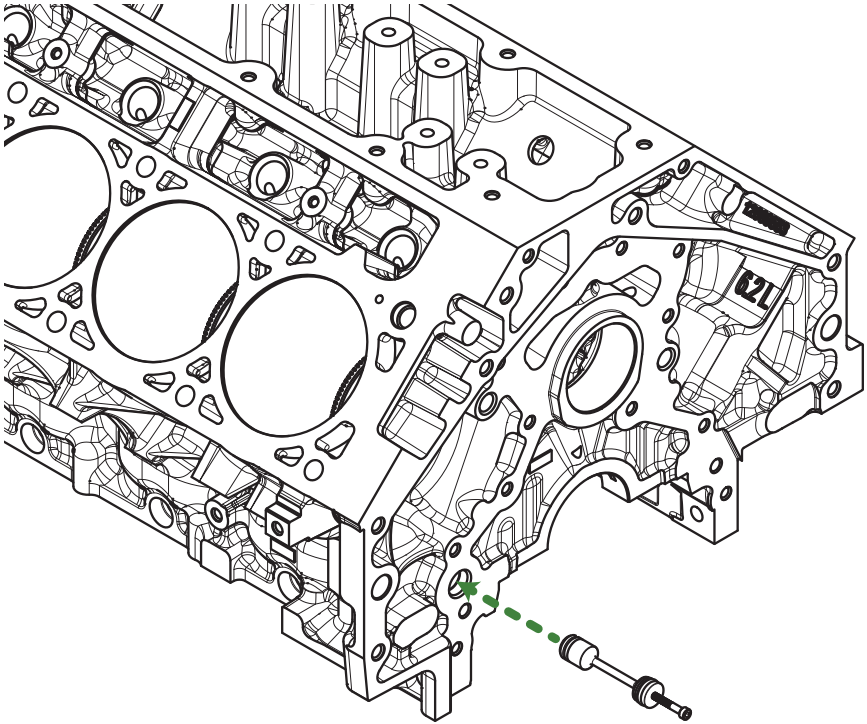


Figure 2 - Rear galley plug installation

5. Carefully follow the instructions, tightening sequences and the corresponding torque values detailed in the GM factory service manual to reinstall the rear engine cover and any other components that were removed.

Installation is now complete. Thank you for purchasing an Improved Racing product!

REMOVING EGM-502 FROM YOUR ENGINE

- 💡** EGM-502 features a M4x0.7 screw thread at the rear of the plug for easy part removal.
- 💡** Pull the plug out after threading any M4x0.7 screw into the plug.
- ⚠** Always inspect both O-rings for damage and compression set after removing the plug.
- ⚠** Replace all damaged or compressed O-rings before reinstallation.