



Fitting Instruction for MFK40240 Engine Mount Kit for LS1, LS2 & LS3 Engines into Land Rover / Range Rover

Important Information

This instruction booklet can be used standalone for the above stated conversion but we would also recommend having a workshop manual for your vehicle and for the engine/transmission you are installing to cover any factory torque / installation settings to complete the installation.

The instruction booklet describes the required modifications (if any) and installation process in order for our kit to fit and work properly. These instructions **make no assumption** on whether additional changes need to be considered or made. It is highly possible that other aspects of your vehicle and/or third party products, eg. Engine, transmission etc. will have an impact on all that is required for you to achieve your desired outcome.

Marks 4WD Adaptors do not and cannot take responsibility for knowing everything that may impact on your conversion. Before beginning any work, thoroughly work through the sequence of changes, work and potential impact of your conversion. You must ensure you completely understand all the factors that may impact on achieving your desired results.

NOTE: We have fitted this conversion into the Discovery 2 vehicle, if you are fitting to a different model you may have to remove the existing chassis posts depending on the original engine that was fitted.

Kit Contents

This kit contains the following parts. Before beginning any work ensure that you have all parts.

Part No.	Quantity	Description
MFC40230	2	Chassis post reinforcing bracket
MFC40240	1	LS to Land Rover left hand engine block bracket
MFC40245	1	LS to Land Rover right hand engine block bracket
MFC20389	2	Heavy duty engine mount rubber
Nuts, bolts & Washers		
MFI40240	1	Fitting instructions
WARR	1	Warranty



Step 1 Engine Mountings

Clean the existing chassis posts to remove rough welds, welding splatter and paint. Do not remove the factory chassis posts as the new mounts get welded over the top.



Image 1.1 Clean chassis posts.



Clamp the new chassis post reinforcing brackets over the top of the original and tack weld.



Image 1.2 Clamp the new chassis post plates in place.



Image 1.3 Fully weld new chassis post reinforcing brackets

Fully weld both new chassis reinforcing brackets to the chassis. Clean any welding splatter and paint. Image 1.3

Fit the engine mount rubbers with the two studs facing down to the new chassis posts, loosely fit the M12 flanged headed nuts under the post to hold the rubbers in place.



Image 1.4 Fit modified engine mount rubbers



Image 1.5 Left hand engine block bracket.

Fit the engine mount brackets to the LS engine block.

From sitting in the driver's seat the MFC40240 fits on the left hand side and the MFC40245 fits on the right hand side. Use the supplied M10 x35mm bolts with spring washers to secure to the block



Image 1.6 Right hand engine block bracket.



Image 1.7 Line up mounts and fit loosely fit nuts

Lower the engine so the engine mount rubbers line up with the chassis posts.

Loosely fit an M12 flange nut on both mounts.

Tighten all fixings

Terms and Conditions

Thank you for purchasing this product manufactured by Marks 4WD Adaptors. Components supplied in this kit are designed and machined for a specific conversion only as outlined in this guide. Modifications to or substitution for any of the components without the written consent of Marks 4WD Adaptors will void any possible warranty or return privileges.

The following instructions are intended as a guide and only for Marks 4WD Adaptors kits. If you do not fully understand the steps, modifications or changes required to complete the conversion, contact our sales department for more information. We recommend that you purchase a service manual pertaining to your vehicle for specific torque values, wiring diagrams and other related information.

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