



## Fitting Instructions for MFK40430 Engine Mount Kit - LS V8 60 Series



### 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.

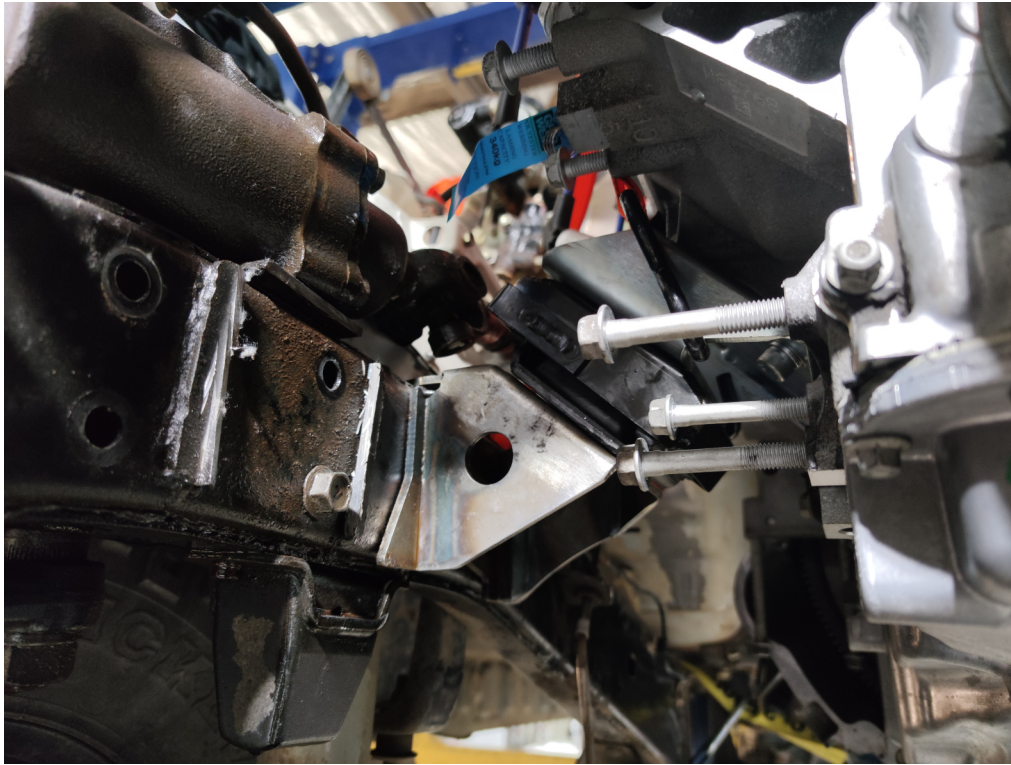
Marks 4WD Adaptors do not and cannot take responsibility for knowing everything that may impact on your conversion. Before beginning any work, thoroughly work through the sequence of changes, work and potential impact of your conversion. You must ensure you completely understand all the factors that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

**NOTE:** We have fitted this conversion into the Toyota LandCruiser FJ60 with a three-piece cross member. If fitting to different models or configurations, modifications may be required.

### **Step 1 Remove factory engine mount chassis brackets**

Cut away the original engine mount chassis brackets on both chassis rails.

Old versus new location See *image 1.1*



**Image 1.1 Old vs New Chassis Post Location**

### **Step 2 Prepare chassis rails for new engine mount chassis brackets**

You may require surface preparation for welding. The condition and cleanliness of the metal surfaces can affect weldability. The chassis should be free from rust, scale, paint, dirt, and other materials. These can cause variability in weld quality. Loose contamination may be wiped from the surface, whereas paint may need to be removed by solvent or wire brushing. See *image 2.1*



**Image 2.1 Prepare Chassis Rails**

### Step 3 Assemble Engine Bracket, Engine Rubber Mount & Chassis Post Together

Bolt engine brackets to both side of engine block. Then bolt rubber engine mount, engine mount stabilizer and chassis post to each side. See image 3.1 & image 3.2

DRAWING/PART NUMBER MFK40430	REV No. 0	DO NOT SCALE REMOVE SHARP EDGES									
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REV ID	CHANGE/DESCRIPTION	ECN No.	APP/DATE

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	MFC40430	Engine Mount - LS V8 to 40 Series LandCruiser L/H	1
2	MFC40435	Engine Mount - LS V8 to 40 Series LandCruiser R/H	1
3	MFC40360	Chassis Post - Toyota 80/105 to Suit MFK1765 RH	2
4	MFC40272	MTR460 Engine Mount Stabilizer	2
5	A5388	Engine Mount	2
6	208M12125	Nut Flange M12 X 1.25	4
7	FW-2010	Flat Washer - M10 x 22 x 2mm	8
8	SHCS-2045	SHCS - M10 x 1.5 x 30mm - Z/P	8

**NOTE:**  
ENGINE MOUNT BOLTS M10 (ITEM 8)  
USE MEDIUM THREAD LOCK  
TORQUE TO 45Nm

ENGINE MOUNT FLANGE NUTS M12 (ITEM 6)  
USE MEDIUM THREAD LOCK  
TORQUE TO 85Nm

Released For Production

PDM Vault: \Hardman Group Companies\Marks 4WD\MFC\		MATERIAL:		DRAWN		GDK 23/08/2021		TITLE:	
THIS DRAWING REMAINS THE PROPERTY OF MARKS 4WD ADAPTORS AND IS SUBJECT OF COPYRIGHT		DIMENSIONS IN MILLIMETERS		HEAT TREATMENT:		DRAWING CHECKED		PAM 23/08/2021	
DRG: STANDARD/PRACTICE AS 1100		UNTOL DIMENSIONS		SURFACE FINISH:		FINISHED WEIGHT: 12.64 kg		SCALE: 1:2	
CAD_FILE NUMBER MFK40430		OPEN DIM ±0.25		TWO DEG PL ±0.10				DRAWING 1 of 1	
		ONE DEC PL ±0.15		ANGULAR ±0'30"				DRAWING/PART NUMBER	
								MFK40430	
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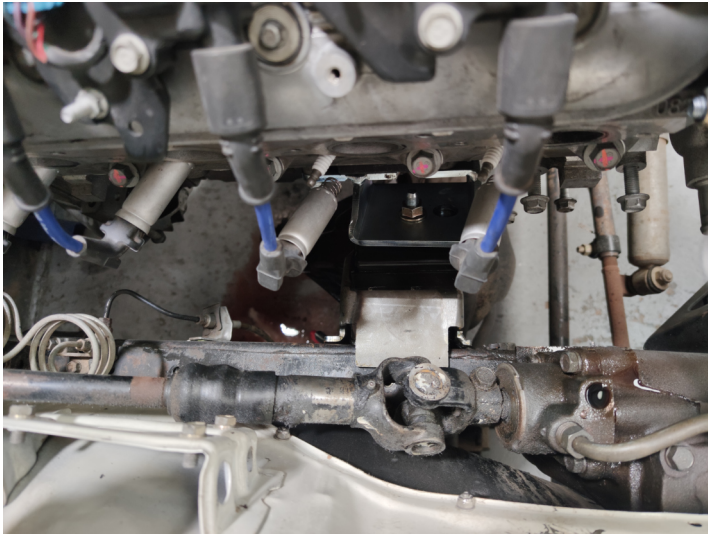
**Image 3.1 Assembly Drawing**



**Image 3.2 Engine Bracket, Engine Rubber Mount & Chassis Post**

#### **Step 4 Install Engine, Transmission & Transfer Case**

Install the engine, transmission, and transfer case to the vehicle. Doing this will be a test fit installation to find the new location of the engine mount brackets that will require welding to the chassis. This location will vary depending on the transmission you use. Ensure your engine mount location is correct on the chassis, then check for clearance around the firewall, exhaust headers, engine sump to front diff and distance to the radiator. See images 4.1, 4.2, 4.3, 4.4, 4.5 & 4.6



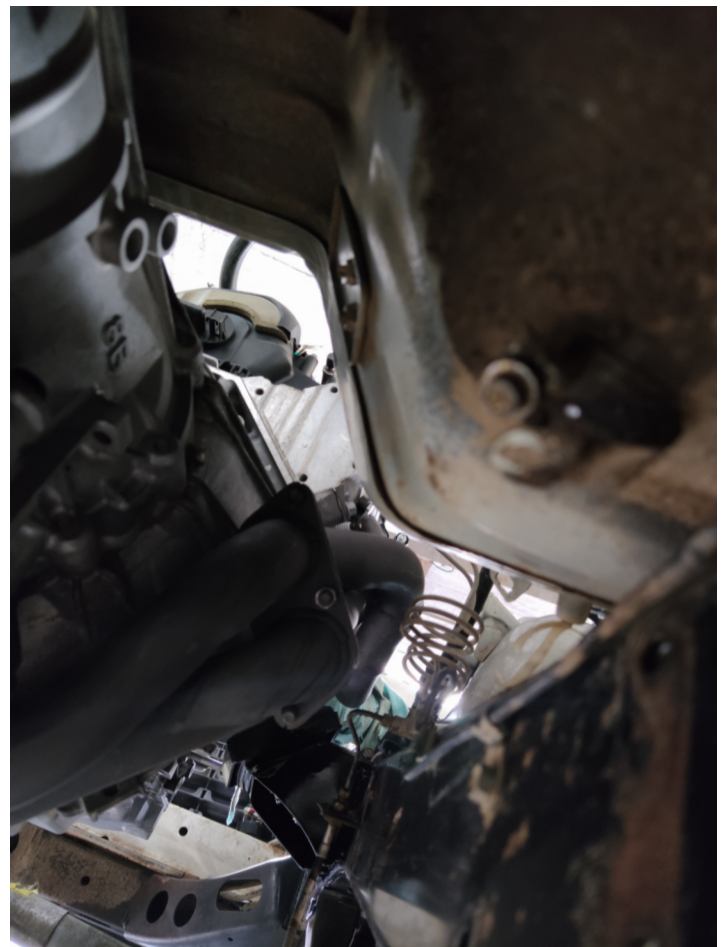
**Image 4.1 RHS Engine to Chassis Mount**



**Image 4.2 LHS Engine to Chassis Mount**



**Image 4.3 Exhaust Clearance**



**Image 4.4 Exhaust Header to Firewall**



**Image 4.5 Engine Sump to Front Diff 1**



**Image 4.6 Engine Sump to Front Diff 2**

### **Step 5 Tack Weld in Place**

When you have completed all checks and measurements, proceed to check your vehicle's electrical system and fully disconnect the battery and check your surrounding area for highly flammable items.

These include fuel and brake lines located on the chassis rail.

The model or variant of vehicle you have, adjust accordingly depending on the original engine & transmission that was factory installed. These could be too close to your welding area.

When you have completed the surface preparation, continue to tack weld engine chassis mounts.

When using a 6L80 automatic transmission, you will require to weld new mounts to the chassis for the cross member.

**NOTE:** Use MFK40440 Crossmember Mounting LS V8 - 60 Series Kit. (Separate Purchase)

### **Step 6 Complete Welding**

If required, remove the complete assembly of the engine, transmission, and transfer case from the vehicle to give more access for welding. Then fully weld mounts to the chassis. Carry out the same for both sides of the chassis. Clean any welding splatter if required, then paint.

See images 6.1, 6.2 & 6.3



**Image 6.1 Front View RHS Mount**



**Image 6.2 Rear View RHS Mount**



**Image 6.3 Rear View LHS Mount**

### **Step 7 Install Engine, Transmission and Transfer Case**

Install the engine, transmission, and transfer case to the vehicle.

You may have removed it in the previous step six.

Install all supplied bolts, nuts & washers.

Apply medium strength thread locker.

Then using a calibrated torque wrench, torque to specs.

See image 3.1

## **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.

## **Contact Information**

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