



## Installation Instructions

### Cast Aluminum Rear End Cover - Black

Fits: GM 9.5" 14 Bolt  
See Application Guide for Specific Vehicles  
Catalog # 71505

Rev. 1/9/2020

**WORK SAFELY!** For maximum safety, perform this installation on a clean, level surface and with the engine turned off. Place blocks or wedges in front of and behind both rear wheels to prevent movement in either direction.

**CAUTION:** To avoid any possibility of bodily injury or damage to vehicle, do not attempt installation until you are confident that the vehicle is safely secured and will not move.

### INTRODUCTION

This B&M Cast Aluminum Rear End Cover has been designed to work on most GM vehicles equipped with a GM 9.5" 14 bolt style axle. The cover provides several advantages over stock factory covers. The extra capacity provides increased oil volume and added cooling, while the thick aluminum construction increases case rigidity. The reinforced center bar, along with the load bolts, prevents bearing cap deflection under severe loads. The magnetic drain plug feature allows regular gear oil changes without the usual mess, and limits ferrous debris from circulating in the axle.

This rear end cover can be installed in about an hour by carefully following the instructions. It is suggested that the vehicle be allowed to cool off for a few hours to avoid burns from hot oil and parts. The vehicle should be off the ground for ease of installation - jack stands, wheel ramps or a hoist will work fine. **MAKE SURE VEHICLE IS FIRMLY SUPPORTED - DO NOT WORK UNDER A VEHICLE IF IT IS SUPPORTED BY ONLY A JACK!** Try to raise the vehicle 1-2 feet so you will have plenty of room to work. Also, have a small box to put bolts in and a drain pan to catch oil.

### INSTALLATION

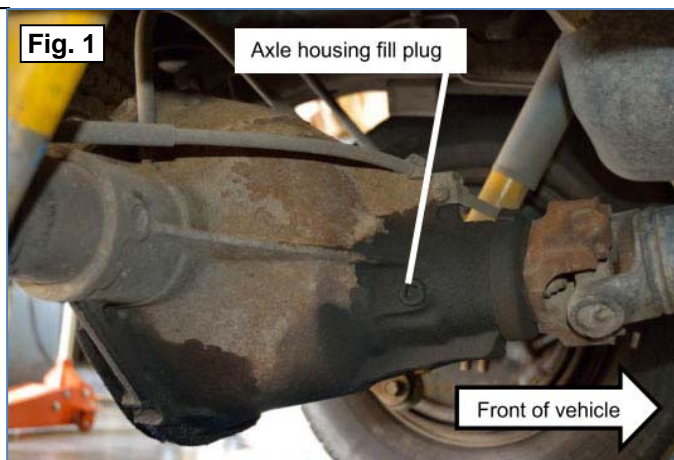
1. Clean axle housing cover area from dirt and other debris.

**NOTE:** On some vehicles it might be necessary to remove some parts (e.g. sway bar, panhard rod) to make the installation of the cover easier.

2. Place a drain pan underneath the axle housing.

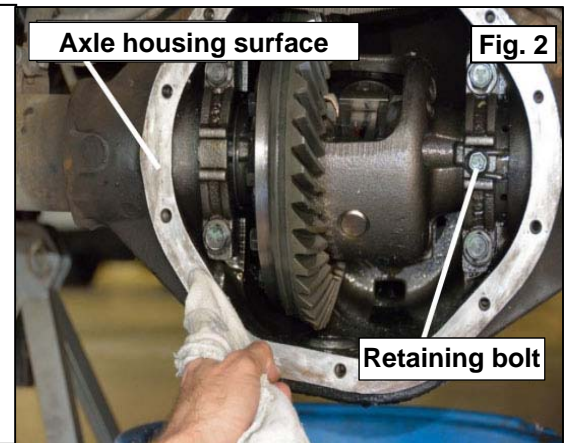
3. Remove the axle housing fill plug with a 3/8" square ratchet and extension (See Figure 1).

**NOTE:** On some newer vehicles, the fill plug might be on the cover and not the axle housing.



4. Remove all the bolts from the cover except one at the top. Loosen the remaining bolt but do not remove.
5. Carefully pry the cover loose with a flat head screw driver, being careful not to damage the surface, and allow the oil to drain.
6. Remove the last bolt and the cover once completely drained.
7. Using a dry lint free rag, clean the accessible areas of the axle housing and check internal components for visible excessive wear or other problems.

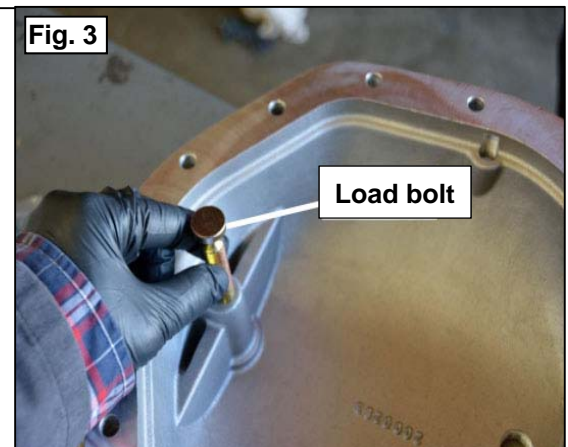
8. Clean all gasket material from the axle housing surface (See Figure 2).



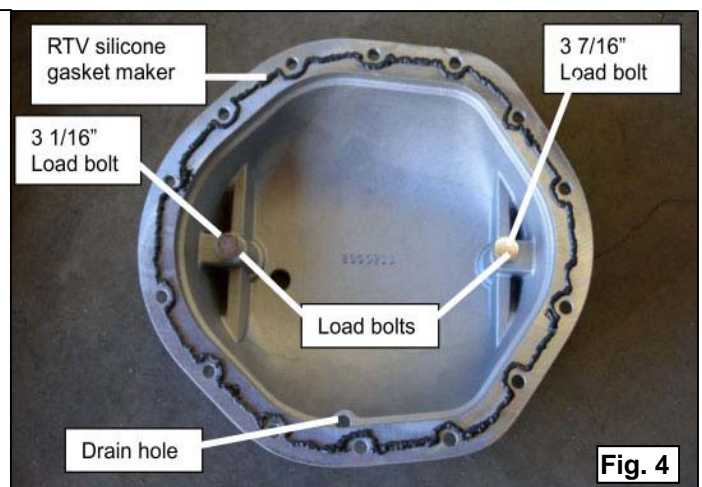
9. We recommend running a M8-1.25 tap through each threaded cover hole on the axle housing to ensure an accurate torque on all bolts.

10. Install the supplied load bolts in each boss from the inside of the B&M Cast Aluminum Rear End Cover as shown until they bottom out (See Figure 3 & 4).

**NOTE:** There are two load bolt lengths. The 3 1/16" load bolt should be touching the bearing cap with the retaining bolt.



11. Apply a bead of RTV silicone gasket maker to the B&M Cast Aluminum Rear End Cover. Run the bead inside the bolt holes (See Figure 4).



12. Install the B&M Cast Aluminum Rear End Cover on the axle housing using a supplied bolt and washer at a bottom hole on the cover so it can be used as a guide.

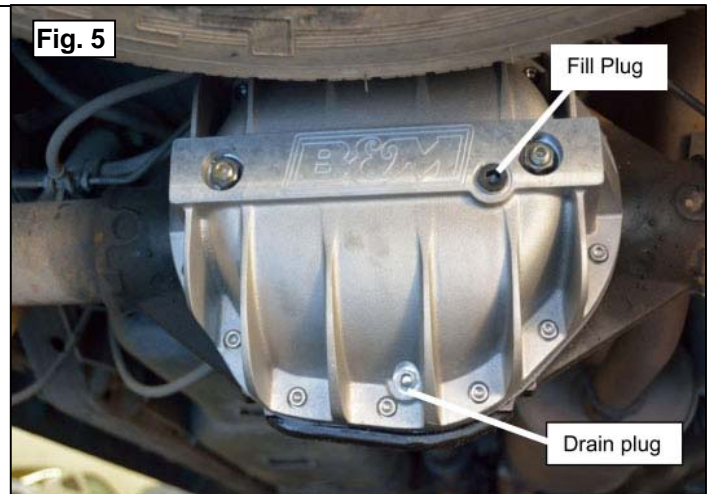
13. Install the rest of the supplied bolts and washers and torque to 15ft.lb in a crisscross pattern.

14. Screw in the two load bolts by hand until they touch the bearing caps. Torque the load bolts to 5ft.lb max.

**NOTE:** Do not over torque the load bolts as you run the risk of distorting the bearing caps, creating abnormal wear and premature failure.

15. Apply a very small amount of RTV on the threads of the load bolts and install on the two supplied jam nuts on the load bolts. Torque the jam nuts to 5ft.lb.

16. Install the supplied magnetic 1/4" NPTF drain plug on the B&M Cast Aluminum Rear End Cover and tighten (See Figure 5).



17. Fill with factory recommended gear oil using the B&M Cast Aluminum Rear End Cover fill plug hole (See Figure 5). Add gear oil until oil runs out of the axle housing fill hole.

**NOTE:** If the original fill plug was on the cover instead of the axle, then add gear oil until up to the bottom of the filler plug hole.

18. Install the axle housing fill plug and torque to 20ft.lb (if equipped).

19. Install the supplied 1/2" NPT fill plug on the B&M Cast Aluminum Rear End Cover and tighten.

20. Install and tighten any other parts (e.g., sway bar, panhard rod) if removed.

Owner's Manual/Maintenance Booklet recommends replacing axle lubricant anytime axle is submerged in water. (Refer to Owner's Manual/Maintenance Booklet for details).

Parts List	Tools List
(1) Cast Aluminum Cover (1) 1/2-13 x 3 7/16" Load Bolt (1) 1/2-13 x 3 1/16" Load Bolt (2) Jam Nuts (1) 1/4" NPTF Drain Plug (1) 1/2" NPT Filler Plug (14) M8-1.25 Bolts (14) M8 Washers	Jack & Jack Stands Drain Pan Rags RTV Silicone Gasket Maker Gear Oil Gear Oil Pump Torque Wrenches 3/8" Ratchet & 3" Extension 1/4" Allen 3/8" Allen 9/16" Socket 3/4" Socket Flat Blade Screwdriver

**IMPORTANT: RETAIN THESE INSTRUCTIONS FOR FUTURE REFERENCE**

