



Installation Instructions

Cast Aluminum Rear End Cover - Black

Fits: Chevy 9.5" & 9.76" 12 Bolt Truck
See Application Guide for Specific Vehicles
Catalog # 71506

Rev. 8/12/2020

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 Chevy 9.5 & 9.76" 12 bolt truck 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.

PLEASE CHECK VEHICLE BEFORE INSTALL: This cover will only fit the AAM 9.5/9.76 axle.

AAM 9.5/9.76 (RPO Code SU7)



GMCH 9.5 (RPO Code SU8)



INSTALLATION

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

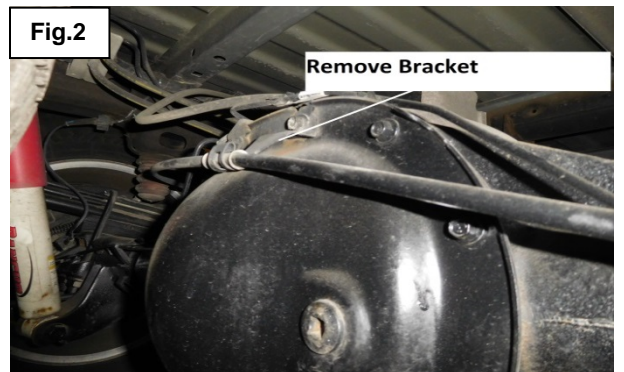
NOTE: On some vehicles it might be necessary to remove some parts (e.g. sway bar, panhard rod) to make the installation of the cover easier.

2. Place a drain pan underneath the axle housing.

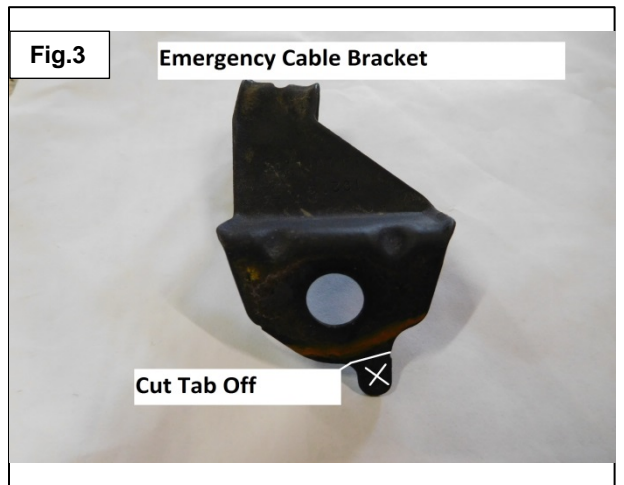
3. Remove all the bolts except one at the top. Loosen the remaining bolt but do not remove.
4. Carefully pry the cover loose with flat head screw driver, being careful not to damage the surface, and allow the oil to drain.
5. Remove the last bolt and the cover once completely drained



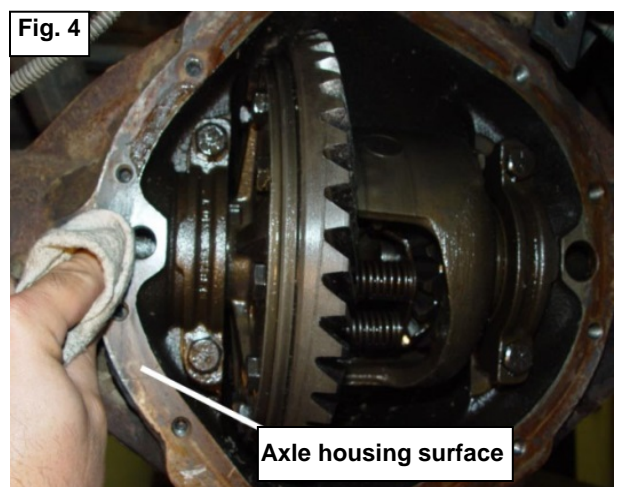
6. Once all the bolts have been removed, carefully remove the emergency brake cable bracket from the cable. (See Figure 2)



7. Now remove the lower tab from the emergency bracket to allow clearance once reinstalling back on the B&M diff cover. (See Figure 3)

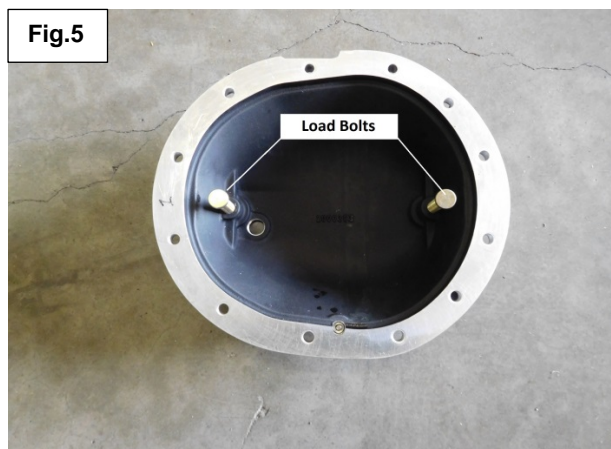


8. Using a dry lint free rag, clean the accessible area of the axle housing and check the internal components for visible excessive wear or other problems.
9. Clean all gasket material from the axle housing surface (See Figure 4).
10. We recommend running an 8mm x 1.25 tap through each threaded cover hole on the axle housing to ensure an accurate torque on all bolts.



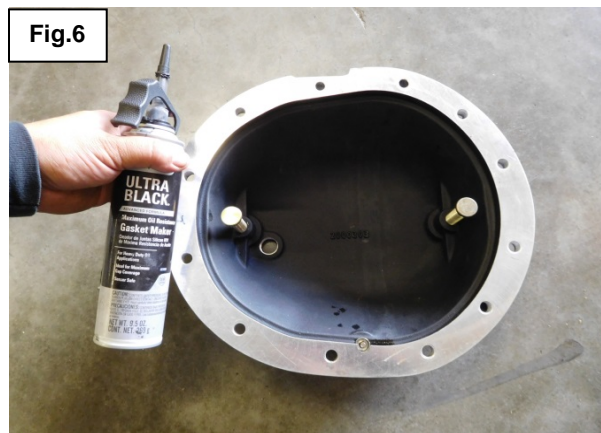
11. Install the supplied load bolts in each boss from the inside of the B&M Cast Aluminum Rear End Cover until they bottom out (See Figure 5).

Fig.5



12. Apply a bead of RTV silicone gasket maker to the B&M Cast Aluminum Rear End Cover. Run the bead inside the bolt holes. If your vehicle has a reusable gasket it may be reused but check condition of it. (See Figure 6)

Fig.6



13. 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

14. Flip up and re-install the modified emergency brake cable bracket back onto the cable, then install bracket with supplied bolt to cover and tighten down.

(See figure 7)

Fig.7



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

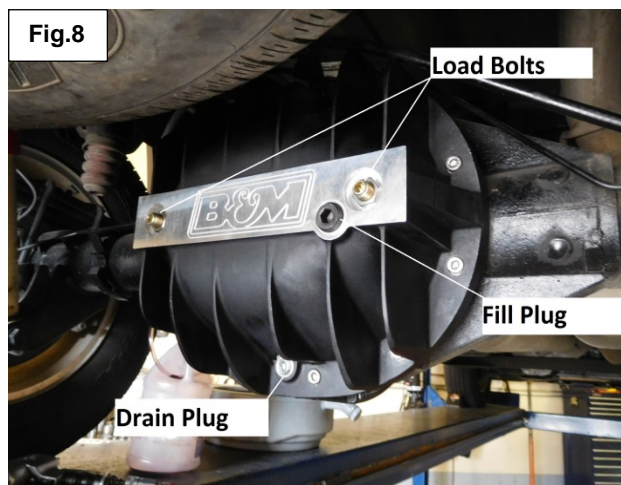
16. Screw in the two load bolts by hand until they touch the bearing caps. Torque the load bolts to 5ft.lb max.

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

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

18. Install the supplied magnetic 1/4" NPTF drain plug on the B&M Cast Aluminum Rear End Cover and tighten (See Figure 8).

19. Fill with factory recommended gear oil using the B&M Cast Aluminum Rear End Cover fill plug hole (See Figure 8). Add gear oil until oil runs out of the axle housing fill hole.



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

21. 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
<ul style="list-style-type: none">(1) Cast Aluminum Cover(2) Load Bolts(2) Jam Nuts(1) 1/4" NPTF Drain Plug(1) 1/2" NPT Filler Plug(10) 8mm x 1.25 x 25mm Bolts(2) 8mm x 1.25 x 30mm Bolts(12) 5/16 AN Washers	<ul style="list-style-type: none">Jack & Jack StandsDrain PanRagsRTV Silicone Gasket MakerGear OilGear Oil PumpTorque Wrenches3/8" Ratchet & 3" Extension1/4" Allen3/8" Allen10mm SocketBlade Screwdriver

IMPORTANT: RETAIN THESE INSTRUCTIONS FOR FUTURE REFERENCE.

