

RK025009

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INSTALLATION BULLETINIB73-002FRESH WATER COOLING KIT INSTALLATION INSTRUCTIONS:

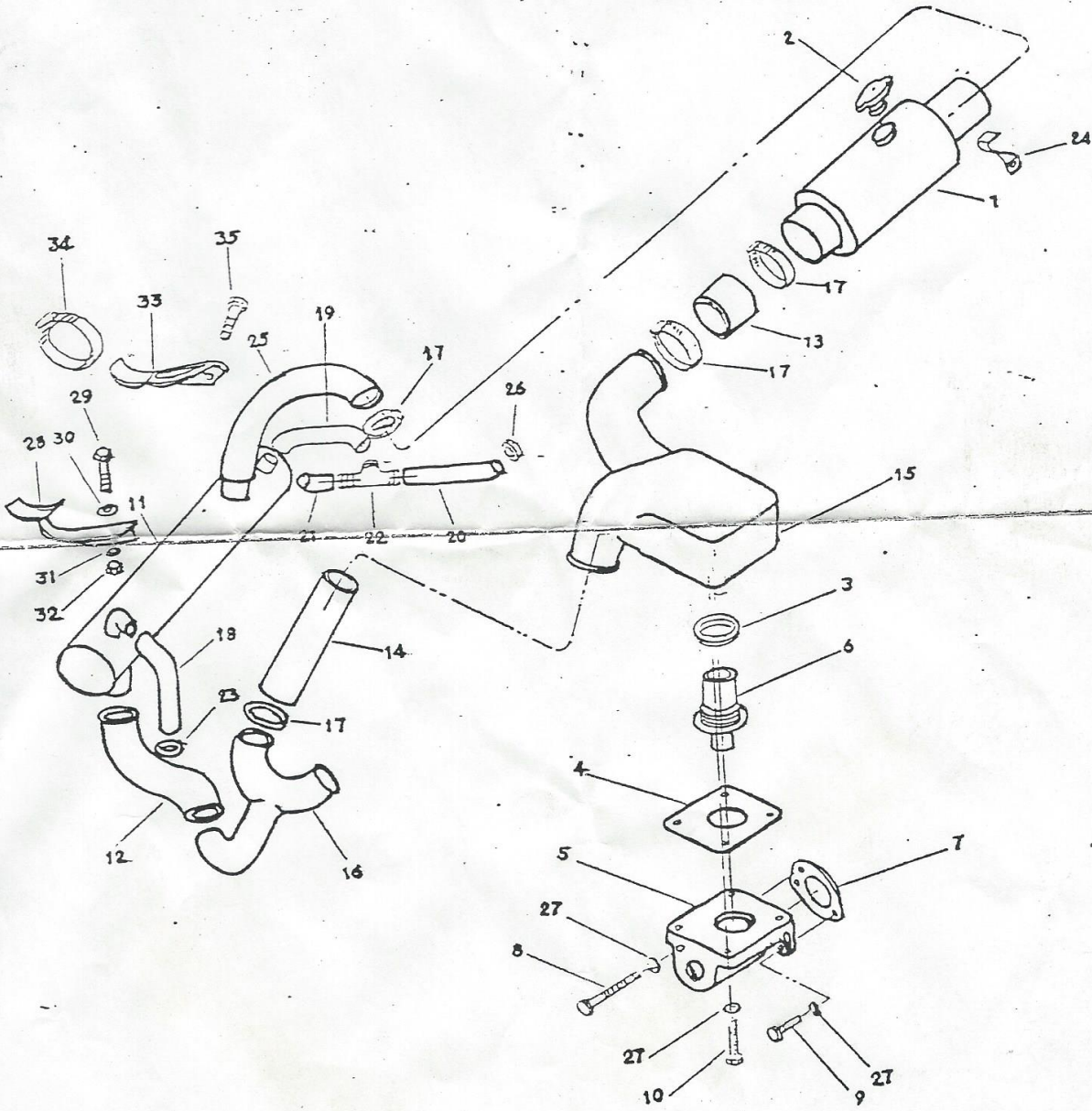
1. Drain water from hoses and water pump by removing plug on bottom of elbow fitting.
2. Remove all hoses from thermostat and elbow fitting, and remove thermostat cover and elbow. Replace with new thermostat housing assembly, PN - RA025009, and Y-fitting (16), PN - R024002. Use long, straight 1-3/4" hose (14), PN - R045005D, between Y-fitting and thermostat cover. (It may be necessary to move alternator to right to gain access to short thermostat cover attaching bolt on 302 CID.)
3. Remove exhaust risers and dipstick tube in order to move exhaust manifold water inlet elbows from front to rear of exhaust manifolds. Reinstall risers using new gaskets, PN - RM0002.
4. Remove intake manifold bolt (third from rear if 351 CID, or second from rear if 302 CID) on right side of engine, and use to attach surge tank support bracket (24), short bracket for 351 CID and long bracket for 302 CID.
5. Slip short, straight 1-3/4" hose (13), PN - R045005B, onto top thermostat cover outlet. Place inlet tube of surge tank (1), PN - RA147009 (pressure cap to front of engine), into opposite end of hose and secure with two hose clamps (17), PN - RS3852. Attach surge tank to support bracket with another hose clamp, PN - RS3852, around outlet tube of surge tank.
6. Remove the bellhousing attaching bolt at approximately the two O'clock position, and attach rear heat exchanger mounting bracket (33), PN - R090038, with longer bolt (35). Use the 3/8 x 1-1/4" bolt (29) and large, flat washer (30) to install front heat exchanger mounting bracket (28), PN - R090039, through the front hole of the webbed area of front engine mount bracket.
7. Install heat exchanger (11), PN - RA147008, to brackets with the two large clamps (34), PN - RS3853. The right angle outlet on heat exchanger should be in front and on top. Replace dipstick tube by bending to fit around heat exchanger.
8. Install small molded hose (18), PN - R045025, from raw water pump to right angle fitting on heat exchanger. Install long 1-3/4" molded hose (25), PN - R045026, from surge tank to large rear inlet tube on heat exchanger. Install shorter 1-3/4" molded hose (12), PN - R045027, to Y-fitting from large front outlet tube of heat exchanger.
9. Install short, straight 1" hose (19), PN - R045004R, from small rear outlet of heat exchanger to plastic tee fitting (22), PN - R024028, and install medium length 1" hose (21), PN - R045004F, from tee to right-hand exhaust manifold fitting, and long, straight 1" hose (20), PN - R045004M to left-hand exhaust manifold fitting.
10. Remove PCV valve hose and replace with longer hose, PN - R045028, supplied in kit with molded right angle end installed at carburetor spacer plate. Install overflow hose, PN - R045018A, onto fitting of surge tank filler neck.
11. Check all clamps for tightness, and fill with a 50% solution of anti-freeze and water; bleed system of air, and check for leaks under pressure.

WATER HOSES AND COOLING SYSTEM COMPONENTS

Fresh Water Cooling System

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FWC KIT PARTS LIST

<u>Ref. No.</u>	<u>Part No.</u>	<u>Description</u>	<u>Quantity</u>
1	RA147009	Surge Tank	1
2	R034006	Pressure Cap, Surge Tank	1
3	RM0004	Gasket, Cover to Body	1
4	R025004	Thermostat Body	1
5	R026001	Thermostat	1
6	RM0001	Gasket, Body to Manifold	1
7	RS0297	Bolt, Body to Manifold, Long	1
8	RS0282	Bolt, Body to Manifold, Short	1
9	RS3928	Bolt, Body to Cover	4
10	RA147008	Heat Exchanger	1
11	R045027	Hose, Heat Exchanger to Y-Fitting	1
12	R045005B	2½" Hose, Surge Tank to Thermostat Housing	1
13	R045005D	9½" Hose, Thermostat Cover to Y-Fitting	1
14	RB025009	Thermostat Housing Assembly w/Seal	1
15	R024002	Y-Fitting	1
16	RS3852	#28 Clamp, Fresh Water Hoses	9
17	R045025	Hose, Raw Water Pump to Exchanger	1
18	R045004R	6" Hose, Exchanger to Tee	1
19	R045004M	18½" Hose, Tee to L.H. Manifold	1
20	R045004F	5" Hose, Tee to R.H. Manifold	1
21	R024028	Tee, Raw Water Distribution	1
22	RS3851	#16 Clamp, Exchanger to Pump Hose	2
23	R090040	Bracket, Surge Tank, 302 CID	1
24	R090035	Bracket, Surge Tank, 351 CID	1
25	R045026	Hose, Exchanger to Surge Tank	1
26	RS3854	#12 Clamp, Raw Water Hoses	6
27	RS2424	Lockwasher	2
28	R090039	Exchanger Bracket, Rear	1
29	RS0305	Capscrew	1
30	RS2675	Flat Washer	1
31	RS2180	Lockwasher	1
32	RS1028	Hex Nut	1
33	R090038	Exchanger Bracket, Rear	1
34	RS3853	#48 Clamp, Heat Exchanger Mounting	2
35	RS0329	Bolt, Rear Bracket to Bellhousing	1
NI	R045029A	½ x 24 Hose, Overflow	1
NI	RM0002	Gasket, Riser to Manifold	2
NI	R045028	Hose, PCV Valve to Carb. Spacer	1
NI	R035007	PVC Valve	1
NI	RS2179	5/16 Lockwasher	4