

## ***Installation Instructions for 15369 Fuel Tank Sump***

This kit is designed to be welded to the bottom, rearmost portion of a steel gas tank.

**NOTE: FAILURE TO CONDUCT THIS INSTALLATION IN A SAFE MANNER MAY RESULT IN SERIOUS PERSONAL INJURY OR DEATH. REVIEW THESE BASIC SAFETY GUIDELINES BEFORE PROCEEDING.**

- To avoid the possibility of fire, disconnect the battery cables.
- Always relieve fuel system pressure prior to disconnecting any fuel system component.
- Always place a shop towel or cloth around a fitting or connection prior to loosening to absorb any excess fuel due to spillage. Ensure that all fuel soaked cloths or towels are deposited into a suitable waste container.
- Always keep a Dry Chemical (*Class B*) fire extinguisher near the work area.
- Turn off all open flames and sparks such as pilot lights, portable heaters and grinders.
- Work in a well-ventilated area.

### **Installation:**

1. Remove the tank from the vehicle and drain the fuel into an approved fuel storage container.
2. Have the tank professionally cleaned to remove all traces of fuel and fuel vapors.
3. Centrally locate the sump onto the tank in the bottom rearmost area. Trace the perimeter of the sump onto the tank with a scribe or marker.
4. Using the supplied template, transfer the center locations for (4) 2-1/2" diameter holes to the fuel tank staying within the marked sump outline/perimeter. Drill the (4) holes using a metal hole saw. Remove all sharp edges and filings from the tank. There are not any holes located directly above the sump bungs creating a trapped area for fuel during hard acceleration.
5. Sand the fuel tank surface along the scribed perimeter/outline of the sump removing all paint, rust and galvanizing.

**WARNING: WELDING OF GALVANIZING METAL CAN GIVE OFF TOXIC GASES THAT CAN BE DANGEROUS TO YOUR HEALTH. MAKE SURE TO CLEAN THE METAL THOROUGHLY.**

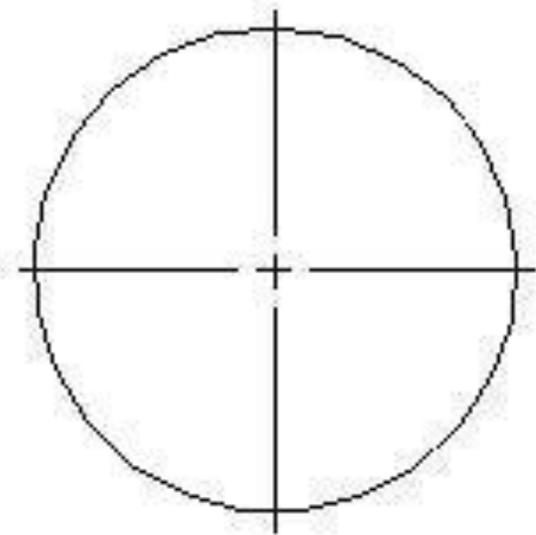
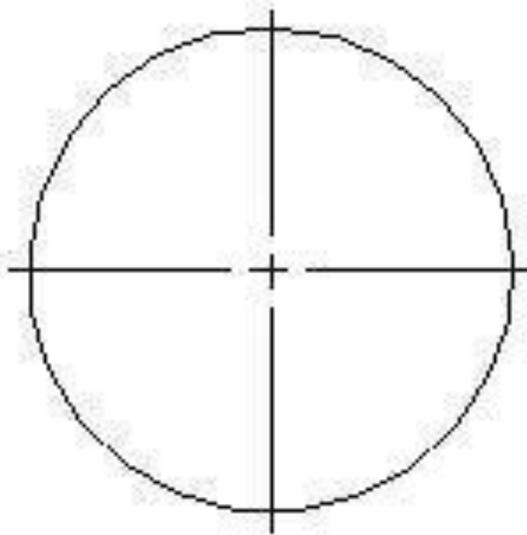
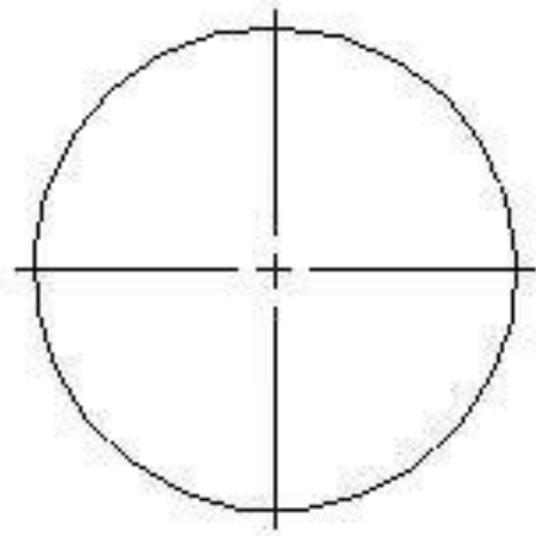
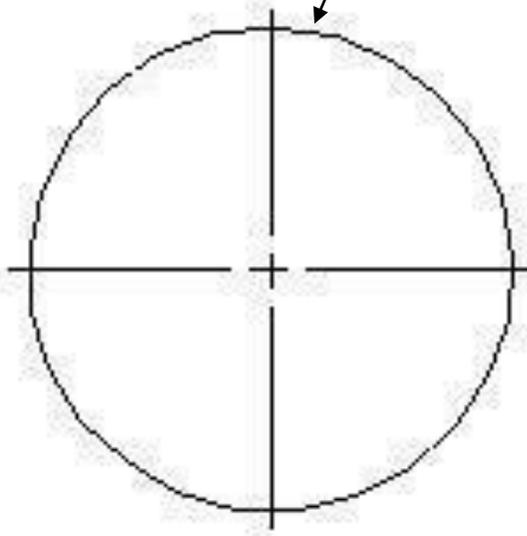
6. Position the sump in place and tack weld the four corners to the tank. Now tack weld every three inches around the perimeter of the sump. Finish-weld the sump to the tank alternating from side to side to eliminate warpage.
7. Test for leaks by filling the tank with water or another non-flammable liquid. If leaks are detected, empty tank and re-weld over them. Repeat this procedure until all leaks are eliminated.
8. Clean tank thoroughly to remove all traces of weld spatter. At this time, we highly recommend that you coat the interior of the tank/sump with a high quality gas tank sealer.
9. Re-install the tank in the vehicle and secure properly. Install the necessary fittings into the sump bungs.



**1-800-345-4545 [jeps.com](http://jeps.com)**

END WITH FITTINGS

DRILL WITH 2-1/2" HOLE SAW.



BACK (FACING FRONT OF CAR) DRIVER SIDE CORNER.

