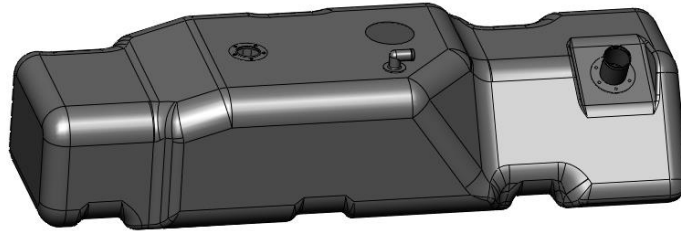




## 1972-1980 Dodge D-Series Truck EFI Conversion Fuel Tank

P/N: 19-591 & 19-593



### Parts List

Image	QTY	Description	Part Number
A 3D rendering of the fuel tank with three black plastic mounting brackets shown above it.	1	1974-1980 Dodge D-Series, Fuel Tank Kit	19-591
A black, flexible fuel filler hose.	23 Inches	1-3/4" Fuel Filler Hose	19-660
A fuel gauge sending unit assembly, including a brass float arm, a fuel sender probe, a float, and several small hardware items like screws and a washer.	1	FUEL GAUGE SENDING UNITS Fuel Sender, 73-10 OHM	19-162
A black diecast fuel module with a red returnless system, mounted on a silver base.	1	SNIPER DIECAST 340 LPH IN-TANK RETROFIT FUEL MODULE RETURNLESS SYSTEM	19-360

The following assembly instructions will assist you in installing the tank, fuel level sender, and the fuel pump module to complete your installation.

**WARNING! THESE INSTRUCTIONS MUST BE READ AND FULLY UNDERSTOOD BEFORE BEGINNING INSTALLATION. FAILURE TO FOLLOW THESE INSTRUCTIONS MAY RESULT IN POOR PERFORMANCE, VEHICLE DAMAGE, PERSONAL INJURY, OR DEATH. IF THESE INSTRUCTIONS ARE NOT FULLY UNDERSTOOD, INSTALLATION SHOULD NOT BE ATTEMPTED. PLEASE CONSULT HOLLEY TECH SERVICE OR A QUALIFIED MECHANIC.**

Please use caution draining and removing your old tank. Gasoline is very flammable. Do not smoke or have any heat sources near your work area.

#### **OEM Fuel Tank Removal:**

1. Begin by disconnecting the battery.
2. Drain the fuel tank of as much fuel as possible before attempting to remove as the fuel tank will be exceptionally heavy and dangerous to work with if it is half a tank or more.
3. Securely lift vehicle. If a vehicle lift is not used, secure the vehicle with jack stands.
4. Remove driveshaft from vehicle. If your vehicle is equipped with a slip yoke style drive shaft, ensure that you have a way of capping the transmission off or the transmission fluid will leak out.
5. Safely depressurize the fuel system ensuring no fuel spillage occurs. **WARNING! Be aware of hot components such as the exhaust system. Do not smoke or be near any sources of flame or spark.**
6. Disconnect all electrical connections and hoses including the fuel filler neck from OEM fuel tank.



**Figure 1 – Fuel Tank Electrical/Fuel Connections**

7. The 1972-1980 Dodge D-Series has 3 fuel tank straps which need to be removed. Start by supporting the fuel tank from the bottom. Ensure a ratchet strap, or similar, is used to secure the fuel tank to the mechanism being used to support the fuel tank.



**Figure 2 – 74-80 Dodge D100 Fuel Tank**

8. There are (x8) bolts connecting the fuel tank straps and two bolts holding the front fuel tank bracket. All these will need to be removed to remove the fuel tank from the truck.



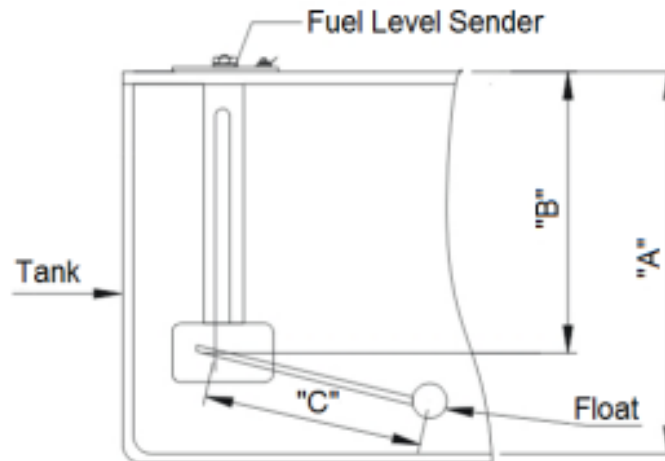
**Figure 3 – Fuel Tank Bracket/Strap Connections**

9. Once all connections have been removed slowly and carefully, remove the OEM fuel tank from the vehicle.

## Fuel Level Sender Installation:

1. Install the fuel level sender into the fuel tank following the below instructions. The Sniper EFI 72-80 Dodge D-Series Fuel tank is 10 inches deep, which will require elimination of a part of the fuel level sender assembly. See **Figure 4** and proceed as follows.

<b>Table 1 – Fuel Level Sender Tank Depth Dimensions</b>		
A = Tank Depth, B = Float Pivot Depth, C = Float Arm Length (Dims. Are in inches)		
<b>A</b>	<b>B</b>	<b>C</b>
9.50	4.75	6.00
10.00	5.00	6.40
10.50	5.25	6.70

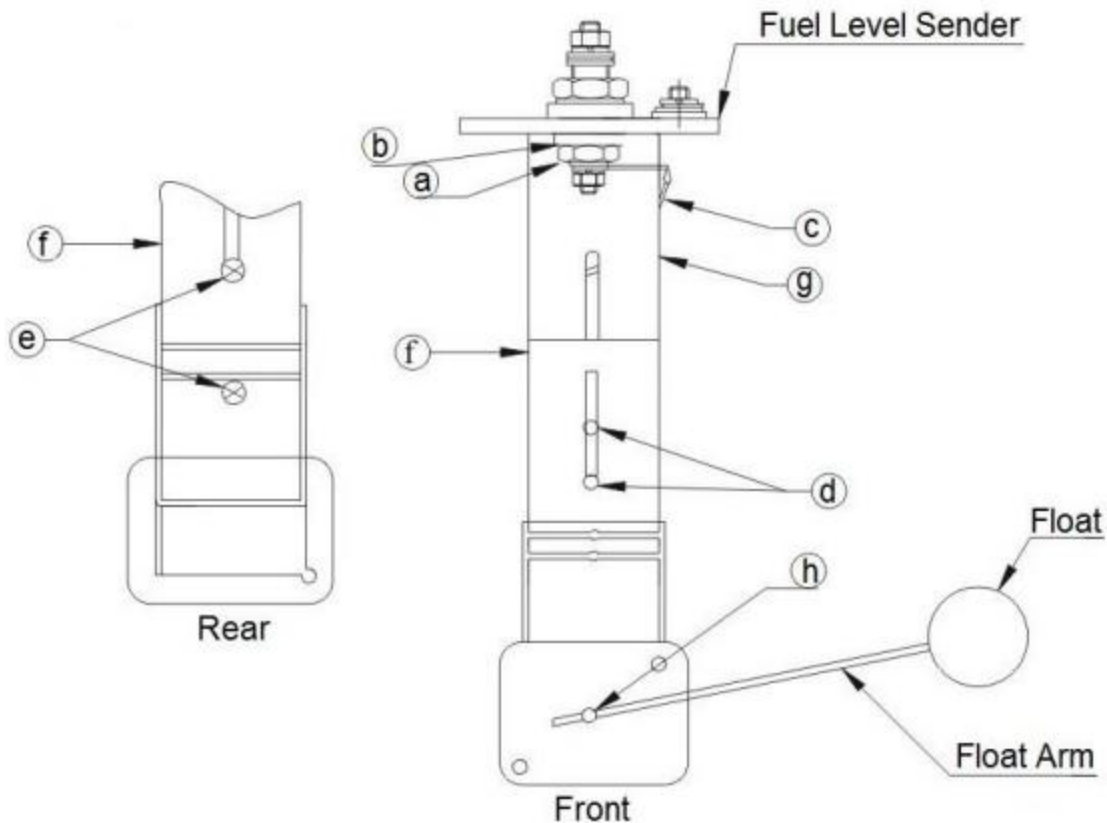


**Figure 4 – Fuel Level Sender Tank Dimensions.**

2. Measure depth of the fuel tank. Locate this dimension in Column "A" of Table 1. Column "B" shows the length from the underside of the sender flange to the center of the float pivot. Column "C" shows distance from the center of the float pivot to the center of the float. For example, a tank 10" deep would need a measurement of 5" from the flange to the pivot and 6.4" from the pivot to the float.
3. Remove two screws "d" and discard (**Figure 5**).
4. Remove two screws "e" from the plastic housing and reserve for later use.
5. Carefully remove bracket "f" from the plastic housing and discard. Replace with bracket "g" in the housing and loosely re-install the two screws "e" into housing. **NOTE:** 6" tanks require mounting rheostat with float toward the outside of the mounting bracket and use of only lower "e" screw to fit.
6. Slide housing up or down until the proper dimension from Table 1 is reached, then tighten screws securely.

**CAUTION: Do not overtighten hardware to avoid damage to the threads.**

**NOTE: For a better seal, use Permatex® Indian Head Gasket Shellac Compound or Aviation Form-A-Gasket® sealant on the gasket and screws.**



**Figure 5 – Fuel Level Sender Diagram**

7. To install the float assembly, loosen screw “h”, remove the short piece of rod, and discard. Insert the float rod until the proper length “c” from Table 1 is met, and then tighten the screw securely. Carefully cut off any excess rod with bolt cutter or similar tool, taking care not to damage the assembly.  
**NOTE: Make sure the float is installed toward the side marked “FLOAT SIDE”. If installed backwards, the fuel gauge will indicate “full” when the tank is empty, and “empty” when the tank is full.**
8. Cut the bracket (g or f) so it doesn’t extend lower than the black rheostat assembly. The rheostat should be the lowest point of the fuel sender.
9. With the gasket in place below the flange, carefully feed the float arm and sender body into the 1.697” (43mm) hole in the tank. Make certain the float arm has free motion within the tank. Using the sender flange as a template, locate the position of the five mounting holes. Use the supplied screws to mount into the tank with threaded inserts in place.
10. Insert fuel sender assembly into tank, align holes and thread in mounting screws. Check that all screws are secure to complete assembly. If the float is obstructed inside the tank loosen the large nut on the center terminal and rotate the rheostat assembly.
11. Connect the center terminal of the sender to your fuel gauge’s signal terminal. Connect the off-center terminal to a good chassis ground.

#### **Fuel Pump Installation:**

Follow the installation instructions included with the supplied fuel pump. Your fuel tank comes predilled with the correct sized hole for the fuel pump so this step in the installation process may be skipped.

**NOTE: If installing an electric fuel pump on a carbureted engine remember to purchase a fuel pump block off plate and eliminate the OEM mechanical fuel pump on the engine block.**

## Fuel Tank Installation:

1. Once you've installed the fuel level sender and fuel pump, you're ready to proceed with installation of your Sniper EFI Fuel Tank.
2. Remove the OEM fuel filler neck and replace with the supplied piece.
3. Raise the assembled Sniper EFI fuel tank into place ensuring all hoses, electrical connections, etc. are out of the way.
4. Once in place, secure the fuel tank with the supplied fuel tank straps and reinstall the OEM front fuel tank bracket.
5. Check that the fuel tank is securely installed. The tank should have no movement in any direction.
6. Clean/Flush all fuel line/hoses to remove any dirt and debris.
7. Install the fuel filler neck, EVAP hoses, electrical connections, fuel lines, etc. Be sure to fully tighten all connections.
8. Reinstall the driveshaft.
9. Lower the vehicle.
10. Turn the fuel pump ON **without starting the engine by turning the ignition key to the "ON" position**, allow the pump to run for several seconds and check the fuel pressure gauge (if applicable). If there is no pressure, turn the fuel pump OFF, wait one minute, then turn the fuel pump ON and recheck the pressure. Repeat this fuel pump OFF and ON procedure until the fuel pressure gauge registers pressure or you detect a fuel leak.
11. It may be necessary to loosen the fuel line fitting at the pressure regulator to bleed off excessive air in the system. Tighten any fuel line fittings which were loosened and insure that any spilled fuel is cleaned up and removed from the vicinity of the vehicle. If no pressure is registered on the gauge after running the pump for several seconds and you have found no leaks, check all fuel and electrical connections to determine the cause.
12. Test drive the vehicle to insure proper operation and re-check the fuel system for leaks. **If any leaks are found, immediately discontinue use of the vehicle and repair the leak(s)!**

### Technical Support

Toll-Free Phone: 1-866-464-6553

Phone: 1-270-781-9741

For online help, please refer to the Tech Service section of our website: [www.holley.com](http://www.holley.com)

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