



AEROMOTIVE
Part # 18651 & 18652
Stealth Fuel Tank Sump
INSTALLATION INSTRUCTIONS

This product is not legal for sale or use on emission-controlled vehicles except when used as a direct replacement part matching OEM specification.

WARNING!



Always be aware of flammable situations. Drilling and grinding can be potential ignition sources. Extinguish all open flames, prohibit smoking and eliminate all sources of ignition in the area of the vehicle and workspace before proceeding with the installation. Ensure you are working in a well ventilated area with an approved fire extinguisher nearby.

WARNING!



etc.

Installation of this product requires modification to a fuel tank/ the fuel system, failure to satisfy all safety considerations will result in fire, explosion, injury and/or loss of life to yourself and/or others. All fuel system components **MUST** be located as far from heat sources as possible, like exhaust, engine block,

WARNING!



Mechanical and hydraulic lifting devices can tip over or lower accidentally due to incorrect maneuvering or technical errors. A falling object can cause injury and/or loss of life to yourself and/or others. When working under the vehicle, always use stands, and ensure that the ground or floor is stable and level. Never crawl under a vehicle which is only supported by a jack.

WARNING!



The fuel system is under pressure. Do not open the fuel system until the pressure has been relieved. Refer to the appropriate vehicle service manual for the procedure and precautions for relieving the fuel system pressure.

CAUTION!



When installing this product always wear safety glasses and other appropriate safety apparel. A drilling operation will cause flying metal chips. Flying metal chips can cause eye injury.

CAUTION:



Installation of this product requires detailed knowledge of automotive systems and repair procedures. We recommend that this installation be carried out by a qualified automotive technician. Careless installation of this product can result in damage to the product, injury or loss of life to yourself and/or others.

Compatible Fuels:

Pump Gas
Race Gas
E85
Alcohol/Ethanol

The following steps are typical of most installations:

- 1-1. Once the engine has been allowed to cool, disconnect the negative battery cable and relieve the fuel system pressure.
- 1-2. Raise the vehicle and support it with jack stands.
- 1-3. Referring to the appropriate vehicle service manual for instructions, drain, disconnect any electrical and fuel component connections and remove the OEM fuel tank. The removal of the vehicles exhaust system may be necessary for fuel tank removal.
- 1-4. Once the OEM fuel tank has been removed, **have it professionally cleaned to remove all traces of fuel and fuel vapors.** This can typically be done at your local radiator shop.
- 1-5. With the fuel tank upside-down find a suitable mounting location for the sump. For optimal results the sump should be located toward the rear of the tank and centered from side to side. Keep in mind that the components inside of the sump must be kept clear of the existing fuel level sender, in order for the fuel level sender to work properly. If this is not possible, you may need to purchase and install an aftermarket fuel level sender elsewhere in the fuel tank.

1-6. Set the sump, upside down, over the intended mounting location and trace the outside edges of the sump onto the fuel tank using a black marker.



1-7. Using an appropriate saw, cut the bottom of the fuel tank to accept the sump. It is usually best to cut the hole a little small to start with. Then gradually enlarge the hole until the sump edges just fit inside of the hole.

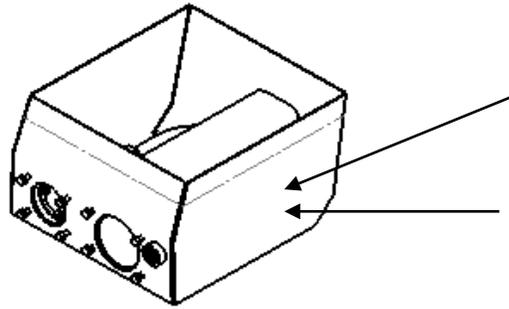
1-8. By measuring and observing the fuel tank interior and exterior, determine how deep the sump will sit in the tank. Typically the top of the sump will be approx. 1/4" from the top of the tank and the bottom of the sump will be level to 2" below the lowest part of the fuel tank. Trim the sump sidewalls down if necessary, to avoid hanging the bottom of the fuel tank sump too close to the ground. Typically, the bottom of the sump will need to be 1" - 3" higher than the bottom of the differential, to protect the sump from being struck by obstacles in the road.

1-9. The sides of the sump have a slight taper to ease installation. Gradually enlarge the hole in the fuel tank until the sump sits at the proper depth in the hole.

1-10. With the sump properly positioned in the tank, using a permanent marker, mark the location of the bottom of the tank on each side of the sump.



1-11. Remove the sump from the fuel tank, using the line marked on the side of the sump as a reference drill a 3/8" hole in each side of the sump, 1/8" above the bottom of the tank line, as shown below.



Drill 3/8" Hole in both sides of sump 1/8" above bottom of tank line, at a point near the lowest part of the tank.

Bottom of tank line.

- 1-12. Place the sump baffle into position inside of the sump as shown below. If the top edges of the sump were trimmed to fit inside of the fuel tank, it may be necessary to trim certain edges of the baffle as well. Trim the baffle as necessary to fit within the envelope of the sump box.



- 1-13. Tack weld the sump baffle into position inside of the sump box. Weld in 3 or more locations to securely fasten the baffle into place.

- 1-14. Ensure that the sump box and fuel tank surfaces that will be welded are clean and free from dirt, oil and debris. Sand or grind any tank galvanizing away from the weld area to prevent weld contamination.

Note: We recommend purging the inside of the fuel tank with argon or CO2 to minimize the risk of explosion!

- 1-15. Place the sump into position in the fuel tank and tack weld the four corners of the sump. Then go back and tack weld each side every couple of inches.

- 1-16. Finish welding around the sump, alternating sides to minimize warpage.

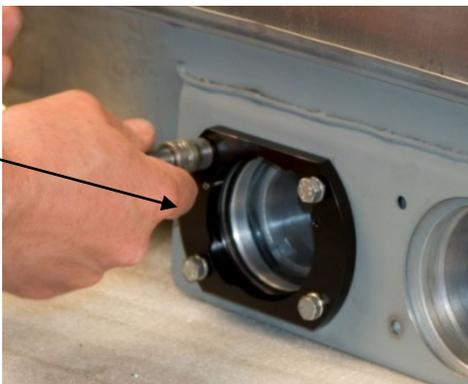
If you have a means for plugging all of the openings in the sump and tank and checking for leaks around the welds, it is recommended that you do so now. If not, then you may have to disassemble the unit to repair any weld leaks later.

- 1-17. Remove the 8 bolts and washers located on the front side of the sump. Locate the gasket that fits the bolt pattern and hole size on the right side of the sump. Working from the outside of the sump, slip the gasket in between the aluminum housing located inside of the sump and the inner wall of the sump. Do the same with the left side gasket.



- 1-18. Install the filter cover with the tab slots facing outward and the stop pin located in the upper left corner, with 4 of the bolts and washers removed earlier. Make sure that the gasket holes align properly with the bolts during installation. Do not tighten the 4 bolts yet.

Stop pin.



- 1-19. Reinstall 2 of the bolts in the pump housing, but do not tighten them.



- 1-20. Open the lubricant packet and apply a generous amount of o-ring lubricant to all 3 o-rings on the pump assembly. Center the pump assembly in the sump opening and slide the pump assembly into the pump housing, being careful to not nick or cut the o-rings.



- 1-21. Slide the pump assembly out far enough to remove the 2 bolts previously installed. Remove the 2 bolts, then slide the pump assembly in far enough to reinstall the bolts and washers. Thread 4 bolts and washers through the pump outlet endcap and into the pump housing, being sure that the gasket holes are properly aligned. Now tighten all 8 bolts on the front of the sump.
- 1-22. Apply a small amount of o-ring lubricant to the o-ring on the inside edge of the fuel filter element. Install the element by sliding it into the filter housing until you feel it snap into position.



- 1-23. Apply a generous amount of o-ring lubricant to the o-ring on the outside of the filter endcap. Align the tabs on the endcap with those in the filter cover and slide the endcap into place.



- 1-24. Using a wrench, rotate the filter endcap clockwise until you feel it stop. Then insert and tighten the 8-32 screw and lock washer to lock the endcap in place.



- 1-25. Properly cap and seal any stock fuel pickup and return holes that exist in the tank, as they are no longer needed.
- 1-26. Reinstall the fuel level sender, making sure that its operation is not impeded by the sump assembly.
- 1-27. Reinstall the fuel tank, reconnecting the fuel filler and vent lines as necessary.
- 1-28. Complete your fuel system installation using appropriate lines, fittings and wiring. The fuel pump outlet and sump return port require an AN-10 ORB fittings and o-rings, while the fuel pump terminals require a 12V feed capable of a minimum of 30 amps. We recommend using our wiring kit P/N 16301 to ensure that your fuel pump is wired correctly. The sump return port is used on return style fuel systems only; returnless systems require that this port be plugged with an AN-10 port plug and o-ring.

- 1-29. Lower the vehicle to the ground, fill the fuel tank with fuel and observe the fuel tank for any leaks. If no leaks are found, start the vehicle and recheck for leaks. **If any leaks are found at any time, shut the vehicle off, clean up any spilled fuel and fix the leaks before continuing.**

Section 3 – Filter Maintenance

Follow this procedure to check and clean the filter element contained in the fuel sump.

- 3-1. Raise the vehicle and support it with jack stands. Disconnect the battery ground cable.

CAUTION: While performing the following steps, a small amount of fuel will leak from the sump filter assembly. Extinguish all sources of ignition and prohibit smoking in the area before continuing. Make sure there is an approved fire extinguisher nearby.

- 3-2. Place a small drain pan underneath the sump. Remove the 8-32 screw and lock washer locking the filter endcap in place.

- 3-3. Turn the filter endcap counter clockwise until the tabs on the endcap line up with the slots in the filter cover. Pull the endcap out of the filter housing and set aside.



- 3-4. Grasp the end of the fuel filter element, contained inside of the filter housing, and pull it out. Clean or replace the element as needed.



- 3-5. Apply a small amount of grease to the o-ring on the inside edge of the filter element. Slide the element into the filter housing until you feel it snap into place.

- 3-6. Apply a small amount of grease to the o-ring on the filter endcap. Position the endcap over the filter cover, aligning the tabs and slots. Push the endcap into the housing, being careful not to nick or cut the o-ring.

- 3-7. Rotate the endcap clockwise until it stops. Insert and tighten the 8-32 screw and lock washer that were previously removed.

- 3-8. Check the sump for any leakage from the filter housing area.

Contact Us

RGA NUMBER REQUIRED FOR ALL RETURNS TO AEROMOTIVE.

To obtain an RGA number, please call (913) 647-7300 and ask for the Returns and Repairs department or complete the online form under the "Rebuilds" section at www.aeromotiveinc.com.

- **Shipping & Returns**

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The Aeromotive Tech Lines are open Monday through Friday from 9:30AM to 5:00PM Central Standard Time.



WARNING: This product can expose you to chemicals, including chromium, which is known to the State of California to cause cancer or birth defects or other reproductive harm. For more information, visit: www.p65Warnings.ca.gov

AEROMOTIVE, INC. LIMITED WARRANTY

This Aeromotive Product, with proof of purchase dated on or after January 1, 2003, is warranted to be free from defects in materials and workmanship for a period of one year from the original date of purchase. No warranty claim will be valid without authentic, dated proof of purchase.

This warranty is to the original retail purchaser and none other and is available directly from Aeromotive and not through any point of distribution or purchase.

If a defect is suspected, the retail purchaser must contact Aeromotive directly to discuss the problem, possible solutions and obtain a Return Goods Authorization (RGA), if deemed necessary by the company. Please call 913-647-7300 and dial option 3 for the technical service dept. All returns must be shipped freight pre-paid to the company and with valid RGA before they will be processed.

Aeromotive will examine any product returned with the proper authorization to determine if the failure resulted from a defect or from abuse, improper installation, misapplication or alteration. Aeromotive will then, at it's sole discretion, return, repair or replace the product.

If any Aeromotive product is determined defective, buyer's exclusive remedy is limited in value to the sale price of the good. In no event shall Aeromotive be liable for incidental or consequential damages.

Aeromotive expressly retains the right to make changes and improvements in any product it manufactures and sells at any time. These changes and improvements may be made without notice at any time and without any obligation to change the catalogs or printed materials.

Aeromotive expressly retains the right to discontinue at any time and without notice any Aeromotive product that it manufactures or sells.

This warranty is limited and expressly limits any implied warranty to one year from the date of the original retail purchase on all Aeromotive products.

No person, party or corporate entity other than Aeromotive shall have the right to: determine whether or not this Limited Warranty is applicable to any Aeromotive product, authorize any action whatsoever under the terms and conditions of this Limited Warranty, assume any obligation or liability of any nature whatsoever on behalf of Aeromotive under the terms and conditions of this Limited Warranty.

This Limited Warranty covers only the product itself and not the cost of installation or removal.

This Limited Warranty is in lieu of and expressly excludes any and all other warranties, expressed or implied. This Limited Warranty gives you specific legal rights, and you may also have other rights which vary from state to state.