

INSTALLATION INSTRUCTIONS

SUBJECT: DODGE CUMMINS COOLANT BYPASS KIT

FPE-2018-05
October, 2018
Page 1 of 4

FITMENT: 1994 – 1998 12V Dodge Cummins

KIT P/N: FPE-CLNTBYPS-CUMMINS-12V (-SS Optional Stainless Steel line)

ESTIMATED INSTALLATION TIME: 1.5 - 2 Hours

TOOLS REQUIRED: 16mm ratcheting wrench, 6mm Allen, 1" wrench, hammer, 5-gallon clean drain pan, 36" pry bar, Scotch-Brite™ pad (included in kit).

KIT CONTENTS:

Item	Description	Qty
1	Coolant bypass line (-SS optional)	1
2	Coolant bypass thermostat housing and O-ring	1
3	M12 x 1.75, 40mm flange head bolt	2
4	M8 x 1.25, 20mm socket head cap screw	2
5	3/8" NPT to -10AN 90Deg	2
6	3/8" Female x 1/4" Male Pipe adaptor	2
7	1/8" NPT to 1/4" Hose Barb 45Deg	2
8	13/16" vinyl P-clamps	2
9	Scotch-Brite™ pad (not shown)	1



WARNINGS:

- Use of this product may void or nullify the vehicle's factory warranty.
- User assumes sole responsibility for the safe & proper use of the vehicle at all times.
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INSTALLATION INSTRUCTIONS

PROCEDURE:

FPE-2018-05
October, 2018
Page 2 of 4

STEP 1: Disconnect the vehicle batteries.

STEP 2: Locate the engine coolant drain, located under the driver's side of the radiator. Drain the coolant system into a clean drain pan.

STEP 3: Remove the factory coolant fitting at the engine side of the upper radiator hose. Install the supplied fittings (items 5, 6, and 7) in the orientation shown in the image to the right.



STEP 4: Locate the large 58mm (2 ¼") freeze plug at the rear of the engine block. From underneath the truck, using a 36" pry bar and hammer, drive the outer edge of the freeze plug in to rotate it in its bore. Remove the freeze plug from the block.

NOTE: Do not hit the plug in the center.



STEP 5: With the freeze plug removed, using a Scotch-Brite™ pad and a degreasing solution, thoroughly clean the block surface area from the head down to the rear cover, as well as the bore where the freeze plug was previously installed. Be sure to remove any dirt or foreign debris.



INSTALLATION INSTRUCTIONS

FPE-2018-05
October, 2018
Page 3 of 4

STEP 6: Using a 1" wrench, thread the bypass coolant line (item 1) to the fitting on the coolant bypass thermostat housing (item 2).



STEP 7: With assembly grease or light oil, lubricate the sealing O-ring on the coolant bypass thermostat housing (item 2), and press it into place on the back of the engine block. The bypass coolant line should be oriented towards the passenger side of the vehicle and over the exhaust manifold.



STEP 8: Ensure that the coolant bypass thermostat housing is firmly seated on the back of the engine block and fasten it securely into place using the supplied M12 flange head bolts using a 16mm socket. (item 6).



STEP 9: Fit the vinyl P-clamps (item 8) over the coolant bypass line and fasten the clamps to the coolant tubes running parallel to the engine using the supplied M8 fasteners (item 4).

NOTE: Ensure the coolant line does not contact the exhaust manifold.



STEP 10: Ensure that the coolant drain plug has been reinstalled in the radiator and proceed to re-fill the coolant system. Re-use or replace coolant as necessary to properly fill the system with clean fluid.

STEP 11: Re-connect the vehicle batteries

STEP 12: Start the truck and allow the engine to idle. Inspect all fittings and split-lines for possible leaks. If no leaks are observed, bring the engine to a normal operating temperature and confirm that no leak is present. Repair any observed leaks.

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For Technical Assistance contact Fleece Performance Engineering at 855-839-5040.