



**AEROMOTIVE**  
**Part # 18650**  
**Generic Fuel Tank Sump**  
**INSTALLATION INSTRUCTIONS**

**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.

Installation of this product requires handling of gasoline. Ensure you are working in a well ventilated area with an approved fire extinguisher nearby. Extinguish all open flames, prohibit smoking and eliminate all sources of ignition in the area of the vehicle before proceeding with the installation.

Installation of this product requires welding and modification to your existing fuel tank, failure to satisfy all safety considerations will result in fire, injury and/or loss of human life.

When installing this product, wear eye goggles and other safety apparel as needed to protect yourself from debris and sprayed gasoline.

**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.

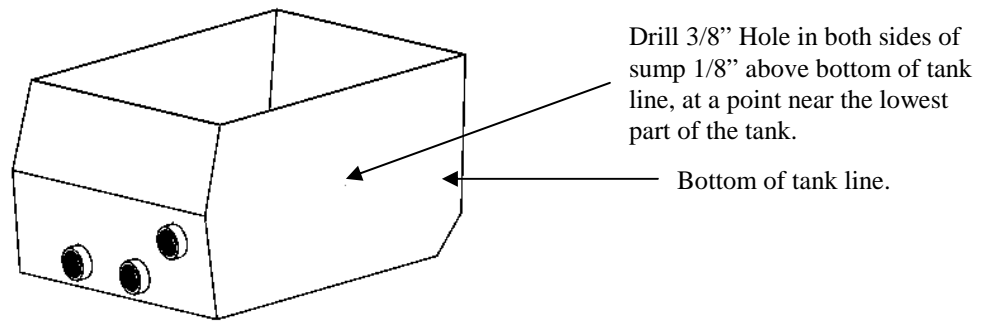
Welding must be done in a well-ventilated area. Welding of galvanized steel produces a white zinc oxide fume, breathing these fumes can cause flu like symptoms.

Aeromotive system components are not legal for sale or use on emission controlled motor vehicles.

The following steps are typical of most installations:

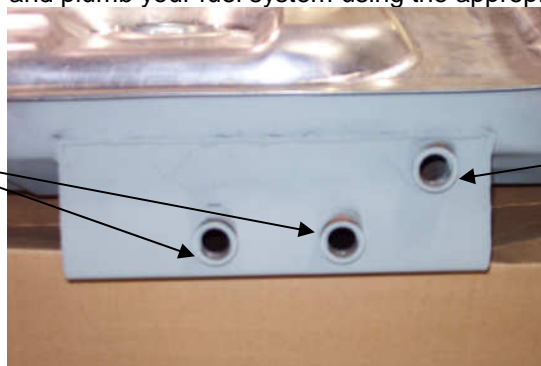
- 1-1. Once the engine has been allowed to cool, disconnect the negative battery cable and relieve the fuel system pressure.
- 1-2. Raise the vehicle and support it with jack stands.
- 1-3. Referring to the appropriate vehicle service manual for instructions, drain, disconnect any electrical and fuel 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 result the sump should be located toward the rear of the tank and centered from side to side.
- 1-6. Once a suitable mounting location has been decided on, 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 1" 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. Ensure that the sump will not be struck by debris in the road or by the road itself.
- 1-7. The sides of the sump have a slight taper to ease installation, measure the length and width of the sump at this depth and transpose these measurements to desired mounting location on the fuel tank.
- 1-8. Using an appropriate saw, cut the bottom of the fuel tank to accept the sump.

- 1-9. 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.
- 1-10. 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.



- 1-11. Place the sump back in the tank to insure everything fits as desired and make any corrections necessary.
- 1-12. Insure that the surfaces that will be welded are clean and free from dirt, oil and debris.  
**Note: We recommend purging the inside of the fuel tank with argon or CO2 to minimize the risk of explosion!**
- 1-13. Tack weld the four corners of the sump first and then go back and tack weld each side every couple inches.  
**Note: We recommend purging the inside of the fuel tank with argon or CO2 to minimize the risk of explosion!**
- 1-14. Finish weld around the sump alternating sides to minimize warpage.  
**Note: We recommend purging the inside of the fuel tank with argon or CO2 to minimize the risk of explosion!**
- 1-15. Plug the three sump AN-10 ports and fill the tank with water. If any leaks are found empty the tank and re-weld. Repeat this process until no leaks are detected.
- 1-16. Once no leaks are detected, remove the three AN-10 port plugs and drain all the excess water from inside the tank. At this time ensure that the inside of the tank is clean from all dirt, debris and welding residue.
- 1-17. It is recommended that the interior of the tank be coated with a high quality fuel tank sealer. Take necessary precautions not to plug the two 3/8" holes you drilled in the sides of the sump inside the fuel tank.
- 1-18. Reinstall the tank in the vehicle and plumb your fuel system using the appropriate fittings.

AN-10 Outlet Ports.  
 We recommend using Aeromotive P/N 15608 for AN-10 supply lines and P/N 15617 AN-10 Port plug for any unused ports .



AN-10 Return Line Port,  
 We recommend using the following Aeromotive fittings: P/N15609 for AN-06 return lines, P/N 15610 for AN-08 return lines or P/N 15608 for AN-10 return lines.



**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](http://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.