



# INSTALLATION INSTRUCTIONS

## ARCTIC FOX HYDRA LINER

### H-4000-XXSTORE SERIES – B-640 11/07

The H-4000-XXSTOR Hydra Liner is designed to mount into an SAE J1926/1 female port with 2.5" diameter x 12 threads per inch. Do not attempt to use in an NPT port, NPT ports require non-STOR series Hydra Liners.

- A) To install the Hydra Liner, first verify that the jam nut is not covering the O-ring flat between the mounting threads. Turn the jam nut toward the coolant ports as necessary.
- B) Lubricate the o-ring, threads, and o-ring entry area of the J1926/1 flange with engine oil.
- C) Insert the Hydra Liner into the J1926/1 port, engage the threads and turn in by hand until the o-ring back up washer is in contact with the face of the J1926/1 port and also is slid against the start of the second set of threads. This will insure full engagement of 100% of the first set of mounting threads into the J1926/1 port.
- D) Align the Hydra Liner to desired position by turning it counter-clockwise no more than 360°.
- E) Tighten the jam nut against the back up washer and the J1926/1 port. Torque to 200 to 225 lb. Ft. (271 to 305 nm).
- F) Coolant ports are 3/4" NPT, plumb coolant supply with minimum 3/4" I.D. hose. 1" I.D. hose is preferred for single Hydra Liner installations, and Mandatory if plumbing two Hydra Liners in series.
- G) For typical applications using hot coolant directly from the engine, connect the hot coolant supply to the engine oil cooler or rear of engine block/cylinder head. Route the return hose directly to the suction side of the engine water pump. In applications which require integration of a diesel fired coolant heater, contact Arctic Fox Applications Engineering at (800) 654-5382 or (763) 972-2758. for system integration assistance.