



INSTALLATION INSTRUCTIONS FOR SIPHON TUBES

**16183NOS, 16283NOS, 16184NOS, 16284NOS, 16185NOS, 16285NOS,
16193CFNOS, & 16293CFNOS**

NEEDED FOR INSTALLATION:

1. 1" Socket
2. In./lb. torque wrench
3. Ft./lb. torque wrench
4. Vice with aluminum jaws such as 1004ERL, found on the Holley website, or another method capable of holding the siphon tube without deformation.
5. Medium strength thread locker such as *Loctite 242®* or equivalent.
6. Tube/pipe/conduit bending tool with minimum 3" radius

Step 1: Threading Siphon Tube into Valve

1. Place siphon tube into vice with threads facing up and tighten until it will not slip or rotate when being threaded into valve. Be careful not to crush the tube between the vice jaws. Leave enough room to thread the valve all the way down onto the siphon tube.
2. Put a bead of thread locker onto threads (this will also act as a pipe thread sealant, so apply a generous amount). **DO NOT USE PLUMBERS TAPE TO SEAL THREADS!**
3. Thread valve onto siphon tube hand tight then switch to torque wrench and tighten to 100 in/lb. of torque.

Step 2: Bending Siphon Tube

1. See **Figure 1** for dimensions of the finished siphon tube/valve assembly. **Valve handle must be directly opposite of siphon tube dogleg after bending for final bottle assembly as seen in Figure 1.**

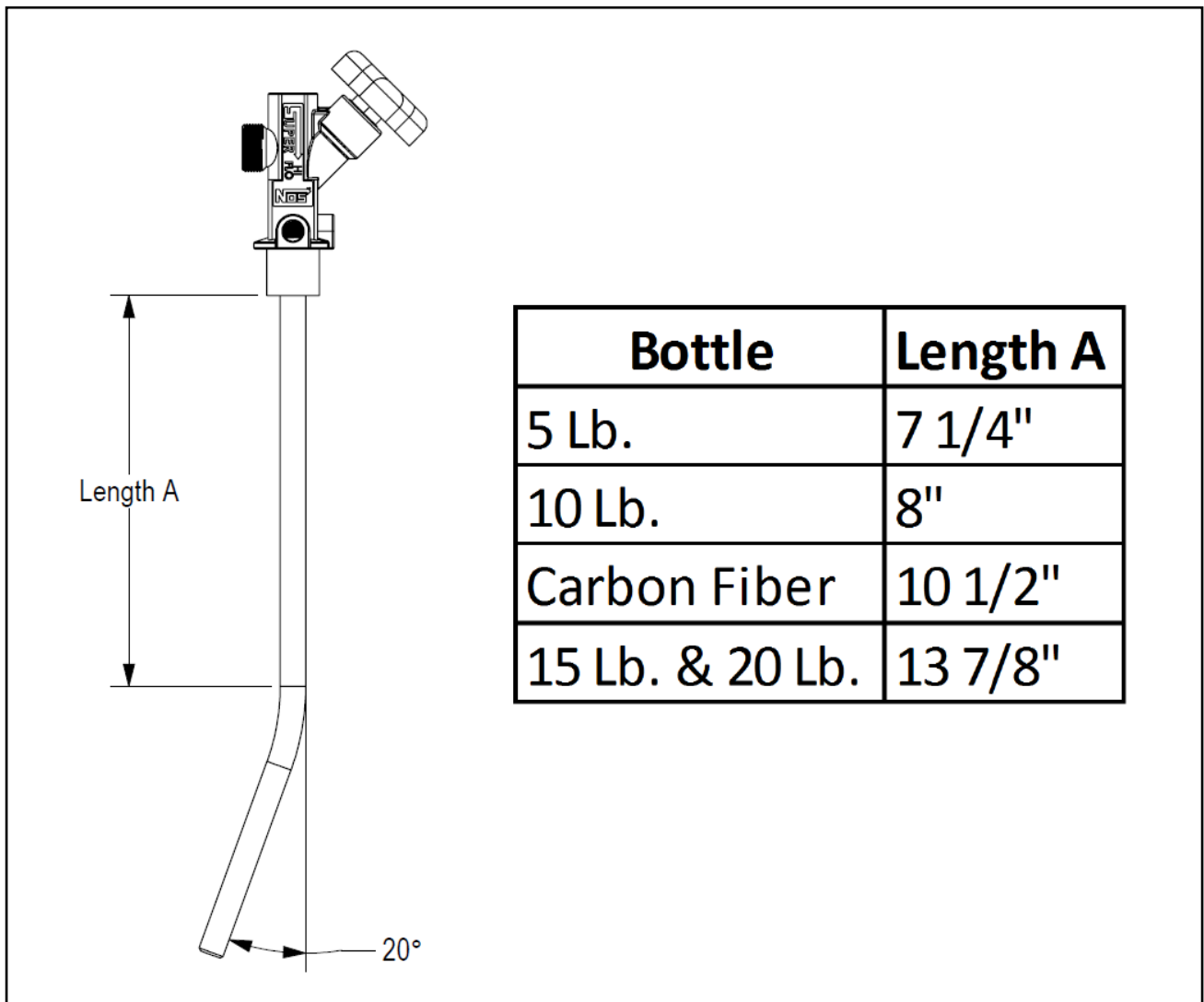


Figure 1

Step 3: Installing Valve Assembly into Bottle

1. Torque the valve into the bottle at 60 ft./lbs for the 5 lb. bottle and 100 ft./lbs. for anything larger.

NOTE: When assembly procedure is complete, place a new nitrous bottle label on the same side of the bottle as the handle to help identify the location of the end of the siphon tube.

Congratulations! You now have a complete valve/siphon tube assembly.

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