

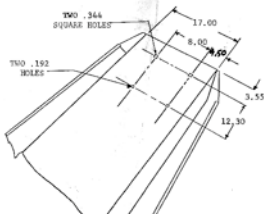
INSTRUCTIONS FOR INSTALLING REAR FUEL TANK KIT AM54147

Instructions M66644



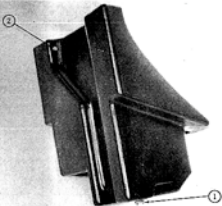
PREPARING SNOWMOBILE

1. Remove seat from snowmobile.
2. Remove foam insert from inside rear part of seat.
3. Disconnect vent line from fuel tank.
4. Close fuel shut-off valve. Disconnect gas line from fuel pump.
5. Drill out pop rivets securing fuel tank holding brackets. Remove brackets and fuel tank.
6. Open fuel shut-off valve and drain gas from tank into a clean container.
7. Remove gas line, fitting, and fuel line with filter from gas tank.



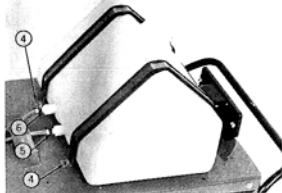
3. Drill two .192" and two .344" holes in tunnel as shown in drawing above. File the rear two .344" holes square as shown above.

INSTALLING REAR FUEL TANK KIT

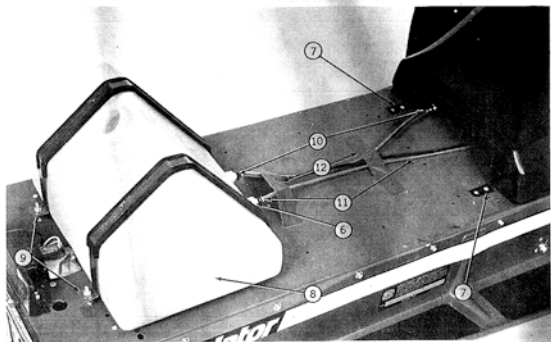


1. Apply thread sealer or wrap pipe plug with teflon tape. Install pipe plug in hole in gas tank.
2. Drill a 1/2" hole in rear of tank as shown above. IMPORTANT: Remove all drill chips from inside tank. Insert rubber bushing and fitting into rear hole of tank.

NOTE: Lubricate bushing with snowmobile oil to facilitate installation into tank.

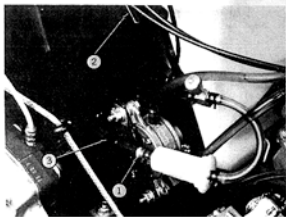


4. Pop rivet rear fuel tank straps to tunnel. NOTE: Straps must be riveted from bottom of tunnel. Remove the two rear suspension bolts to allow suspension to be lowered for access.
5. Cut off 8" of fuel line with filter removed from front gas tank. Install fuel line with filter and fitting removed from front tank on rear tank as shown above.



6. Install other fitting from kit on rear gas tank.
7. Place front gas tank on snowmobile. Pop rivet gas tank brackets in place.
8. Position rear gas tank under straps as shown above.
9. Insert two 5/16" x 2" round head bolts (from bottom of tunnel) and secure with 5/16" nuts. Place tank straps over bolts and secure in place with two 5/16" lock nuts.
10. Attach 22" fuel line to rear gas tank fitting and fitting on rear part of front gas tank with clamps.
11. Attach 44" fuel line to rear gas tank fitting with clamp. Route gas line under front gas tank to fuel pump.
12. Tape fuel lines to tunnel with duct tape (Part No. TY5030).

ATTACHING GAS LINES TO FUEL PUMP

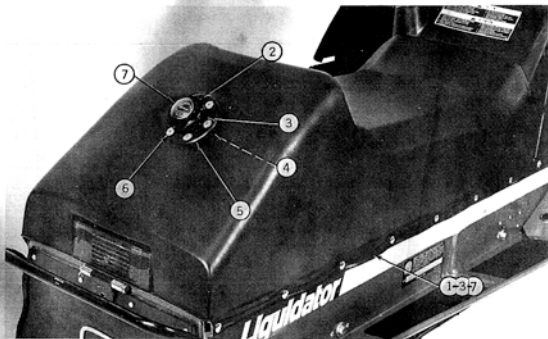


1. Attach fuel filter to 44" line from rear gas tank.
2. Connect vent line to tank.
3. Bolt J-clamp to fuel pump bracket as shown. Secure fuel line in J-clamp.

IMPORTANT: Do not close J-clamp too far or fuel line may become pinched causing restriction of fuel to pump.

Fill both fuel tanks with fuel, open fuel shut-off valve, and test for leaks before installing seat. See page 3 for operating instructions before filling fuel tanks.

INSTALLING SEAT BEZELS, FILLER CAP, AND SEAT



1. Remove rear fuel tank filler cap and snap seat in place.
2. Press down on seat over filler spout and mark location of spout.
3. Remove seat and cut a 2-3/8" hole in seat for spout.

4. Loosen 1" of foam padding on inside of seat around hole and insert "SILVER" colored bezel back plate.
5. Place "BLACK" colored bezel on outside of seat.

IMPORTANT: The flange part of bezel should be down.

6. Pop rivet the two bezel parts together.
7. Install seat and rear fuel tank filler cap.

NOTE: To prevent damage to seat, instruct customer to always remove the rear fuel tank filler cap before removing seat from snowmobile.

OPERATING INSTRUCTIONS

Always fill rear fuel tank and install filler cap before filling front fuel tank. Never remove rear fuel tank filler cap when front fuel tank is full of fuel. Otherwise, fuel will be expelled out of rear tank.