

INSTALLATION INSTRUCTIONS

COOLANT TANK KIT

TOYOTA GR COROLLA



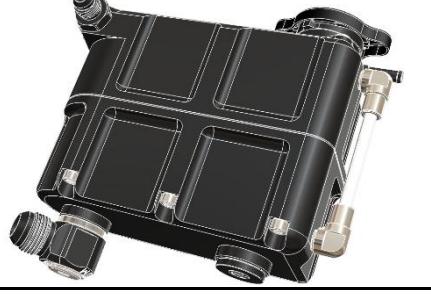
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NOTES:

- Installation to be performed on engines that are completely cooled down.
- Do NOT perform installation on a hot engine.
- It is NOT necessary to drain the coolant system before installation.

STEP	TOOLS NEEDED	INSTRUCTIONS	PHOTO
1	8mm wrench	Unwrap both halves of the coolant tank and clean out any residual packaging material. Grab the top half of the coolant tank (shown) and 1 of the push-to-connect NPT elbows provided in the kit.	
	PTFE thread paste		
		Apply PTFE thread paste then hand tighten the elbow fitting into the port shown. Now add an additional 1.5 to 3 turns until it faces directly downwards, as shown.	
2	8mm wrench	Grab the bottom half of the coolant tank (shown) and the other push-to-connect NPT elbows provided in the kit.	
	PTFE thread paste		
		Apply PTFE thread paste then hand tighten the elbow fitting into the port shown. Now add an additional 1.5 to 3 turns until it faces directly downwards, as shown. NOTE: The tapered pipe threads are preimpregnated with Teflon so no addition lubrication is required.	
3		Push-in and fully insert the clear sight tubing into the elbow fitting on the bottom half of the coolant tank.	
4	Anti-seize	Place the gasket between the 2 tank halves. Lineup and fully seat the opposite side of the clear sight tube into the opposing elbow.	
	4mm Allen wrench		
	Torque wrench	Install the 7 socket head bolts. It is recommended to use anti-seize on the threads to prevent galling. Tighten all screws evenly until snug in a crisscross sequence, then torque to 53 in-lbs (6 Nm).	
		NOTE: After the tank is heat cycled, check the gasket for leaks and retorque if needed.	

5	3mm Allen	<p>Insert the included O-ring into the groove on top of the coolant tank.</p> <p>Install the coolant tank neck in the orientation shown using the 3 included button-head screws.</p>	
6	3/8" Allen Wrench 6mm Allen Wrench 19mm Wrench Oil Lubrication	<p>Lubricate the O-rings on the following fittings prior to installing.</p> <p>Install the plug fitting into the bottom port shown.</p> <p>Install the 10AN banjo fitting into the other bottom port.</p> <p>Install the included 6AN fitting into the side port.</p> <p>Install the pressure cap (sold separately).</p>	
7	4mm Allen Wrench Thread Locker	<p>As shown, secure the mounting bracket to the coolant tank using 3 of the provided screws.</p>	
8		<p>Pop the front hood (bonnet). To remove the engine cover, simply pull up on all 4 corners. This will release the 4 rubber grommets.</p> <p>Unplug the HVAC electrical connector shown.</p>	
9	10mm Socket	<p>Unscrew the mounting bolt shown.</p>	
10	Pliers	<p>As shown, loosen the spring clamp on the upper hose. Pull the coolant tank upwards to release it from the rubber mounting grommet. To prevent spilling, tip the coolant tank up and carefully remove the hose from the tank.</p> <p>NOTE: temporarily plug the hose or keep it at a high point to avoid seepage.</p>	

11	Empty the coolant into a clean container.	
12	Remove the cap to completely empty the tank.	
13	<p>Pliers</p> <p>As shown, loosen the spring clamp on the lower hose. To prevent spilling, tip the coolant tank and carefully remove the hose from the tank.</p> <p>NOTE: temporarily plug the hose or keep it at a high point to avoid seepage.</p>	
14	The OEM coolant tank and cap will NOT be reused.	
15	<p>Pliers</p> <p>1" Wrench</p> <p>While holding the coolant tank, screw the 10AN hose end into the lower 10AN fitting.</p>	
16	When placing the coolant tank into position, be sure to insert the bracket mounting indicator to the OEM rubber grommet (as shown).	

17	4mm Allen Wrench	As shown, install the last 2 provided screws.	
18	Pliers Hose Cutter	<p>The upper coolant tank hose will be modified. Temporarily loosen the inner OEM spring clamp, but do not remove the hose from the inner bar.</p> <p>Remove the outer hose clamp. This OEM spring clamp will NOT be reused.</p> <p>As shown, cut the outer bend from the upper hose.</p>	
19		As shown, insert the provided spring clamp to the OEM hose.	
20	Pliers 11/16" Wrench	<p>Insert the 6AN hose end into the upper coolant hose. Secure with the provided spring clamp, as shown.</p> <p>Screw the 6AN hose end into the upper 6AN fitting.</p> <p>If necessary, rotate the hose with respect to the inner and outer connections for optimal fitment. Be sure to secure both spring clamps.</p>	
21		<p>Insert the provided 7/32" hose to the overflow barb. As shown, insert the hose through the slot on the backside of the mounting bracket. Route the hose down into the fender well.</p> <p>NOTES:</p> <ol style="list-style-type: none"> 1. No hose clamp is necessary. 2. Keep the hose away from hot areas and any moving components. If necessary, cut this hose to length. 	
22		Fill the tank with the recycled coolant. If no coolant was spilled, it is likely that there will be just enough. A good starting point is when the rear sight tube registers halfway full.	

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Install the pressure cap. NOTE: Radium Engineering caps are available with different pressure relief ranges for optimal performance.

Plug in the HVAC electrical connector. Start the vehicle and let the engine reach operating temperature. Check for leaks. The coolant tank may need to be refilled after the thermostat has opened and all air has been discharged from the system.

INSTALLATION COMPLETE

