

The surge tank should be mounted on the left side of the engine so that the tank is mounted higher than the transfer pump. The surge tank hoses should be installed onto the return fuel line on the back of the cylinder head between the cylinder head and the fuel filter. The surge tank will act to provide a steady supply of fuel and reduce hard starting.

See the following installation procedure:

1. **If muffler bracket is installed:** Mount the surge tank bracket T178083 on left hand side of engine on the cylinder head with (4) 19M7817 bolts, (4) 28H1497 spacers, and (4) 24M7404 flat washers on the non-bracket side. (2) on each bolt between bracket and spacer. [71048_2.jpg](#). Go to Step #3.
2. **If muffler bracket is not installed:** Mount the surge tank bracket on left hand side of engine on the cylinder head with (4) 19M7789 bolts.
3. Attach surge tank AT222124 to bracket using (4) 19M7784 bolts. Mount tank with the larger threaded hole in surge tank end facing up. [71048_3.jpg](#)
4. Install (1) O-ring R26448 onto adapter 38H1160 and install in the bottom hole of surge tank.
5. Attach angled end of hose RE505546 with a T77613 O-ring onto the bottom of the surge tank adapter, and the straight end onto the t-fitting 38H5127 and O-ring T77613. [71048_4.jpg](#)
6. Remove fuel return line from the rear of the cylinder head and attach to the middle of the t-fitting with an O-ring T77613. [71048_5.jpg](#)
7. Attach the straight end of hose RE507054 to the t-fitting and an O-ring T77613 and the angled end to the cylinder head. Make sure to route the lines so that they are lower than the surge tank so no air can accumulate or get trapped in the fuel lines.
8. Remove top plug from surge tank and pump the hand primer until the surge tank is ½ full of fuel. Install plug in the top of the surge tank. **Important:** Do not run engine without plug installed.





