



1. Locate the center of the raised section on top of the fuel tank where the filler neck will go



2. Drill a 1/4" pilot hole in the center of the embossment as shown.



3. Using the pilot hole as a guide, cut out the opening for the filler neck using 1 1/2" hole saw.



4. Use a square to find and mark the center of the flange (approx. 1/4" from outside edge of flange).



5. Assemble the filler cap to the Filler neck and place the filler neck with the cap install, onto the tank.



6. Align the ears perpendicular to the front of the tank and mark the flange and tank for reference.



7. Drill 8 somewhat equally spaced 1/16" holes through the flange center marks. Place the drilled flange onto the tank and align the reference marks. Use the drilled flange as a guide to drill the 1/16" holes into the tank.



8. Drill a 9/16" hole in the rear center of the tank about 1" from the bottom edge. After drilling check to make sure there are no burrs on the inside of the tank. Feed a long piece of strong wire through the hole and

out through the filler neck opening. Slide the machined fuel outlet onto the wire so that the flange on the fitting is the last thing to enter the tank. Tip the tank upright so that the fuel outlet hole is on the bottom. Drop the fuel fitting down the wire so that the threaded end can be pulled through the drilled hole. Pull the fitting through the hole until the flange is snug against the inside wall. (A small loop or bend in the end of the wire behind the flange will help pull the fitting snug.) Remove the wire from the fuel tank.



9. Place the washer and then the nut onto the fuel outlet tube and tighten until outlet is secure. The flange is self sealing.



10. Enlarge the holes in the filler neck flange enough to allow the mounting screws to slide through them. **WARNING!**

**DO NOT ENLARGE THE MATCHING 1/16" HOLES THAT ARE DRILLED IN THE TANK.**

Apply a layer of aviation gasket sealant around the filler opening on the tank where the filler neck will be attached. Align the filler neck so that the ears of the cap are parallel to the airflow over the wing. Install the filler neck to the tank and secure with the 8 mounting screws.