INSTALLATION INSTRUCTIONS:
1) APPLY GREASE TO THE (2) 625-1131 O-RINGS, FIG A.
2) INSTALL THE O-RINGS INTO THE STAINLESS CROSSOVER BODY.
3) APPLY LIQUID TEFLON PIPE SEALANT TO THE (2) 540-223000 PIPE PLUGS, FIG. B. & 540-222173 FIG. C FITTING.
4) USING 1-7/16 WRENCH, INSTALL PIPE PLUGS INTO BOTH SIDES THE STAINLESS CROSSOVER, FIG. D.
5) INSTALL FITTING INTO BOTTOM THE ALUMINUM HOUSING, FIG. E. BE CAREFUL NOT TO OVER TIGHTEN FITTING. DOING SO CAN CRACK THE HOUSING.
6) SLIDE (4) 90037C275SHS BOLTS & 90037AN-STSS WASHERS IN THE CROSSOVER, FIG. F.
7) USING 5/16 HEX HEAD ALLEN KEY TO INSTALL CROSSOVER TO THE ENGINE BLOCK. TORQUE TO 30 INCH LBS..
8) THE TOP OF THE CROSSOVER HAS A 3/4 NPT HOLE FOR INSTALLING BYPASS, SEE ATTACHED DRAWING. IF NOT INSTALL BYPASS PLUG OFF WITH PIPE PLUG.
9) STOCK HP500 PULLEY CAN BE INSTALLED ON THIS UNIT. WILL NOT WORKING WITH STOCK 454/502 PULLEY. SEE DRAWINGS 625-4453 & 625-4454 THAT COME WITH PULLEY.
IF YOU ARE GOING TO USE A THERMOSTAT WITH THIS CROSSOVER KIT YOU NEED TO BYPASS WATER TO ABOVE THE THERMOSTAT. THIS WILL PROVIDE WATER TO THE EXHAUST UNTIL THE THERMOSTAT OPENS.

COMPONENTS AS SHOWN:
- (2) 100-720-6316 HOSE CLAMPS
- (1) 410-1499 WATER OUTLET w/ 1" BARBS
- (1) 410-1506 BYPASS HOSE
- (1) 540-222110 FITTING, 3/4NPT x 1" BARB

AVAILABLE THERMOSTATS:
- 540-160110: 120°
- 540-160106: 142°
- 540-160101: 160°
- 540-160108: 180°

APPLY LIQUID TEFILON TAPE AND INSTALL 540-222110 FITTING INTO TOP OF CROSSOVER, USING A 1-1/16 WRENCH.
1-1/4 HOSE

HP500 CIRCULATION PUMP
ELIMINATOR CROSSOVER KIT

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