

Manifold and Riser Installation



1. Clean all necessary mounting areas of old gasket material ensuring not to scrape into manifold or riser.
2. Place necessary gaskets onto mounting surface before mounting manifolds and risers.
3. Tighten all mounting bolts to recommended specifications (See chart below).
4. Install all NPT pipe plugs where applicable.
5. Reconnect cooling hoses (Check for damage to hoses before connecting, replace where needed).

***Note:** Apply Safe-T-Loc to all mounting bolts and nuts before installing.

(DO NOT USE SAFE-T-LOC ON NPT PIPE PLUGS)

For more detailed information on this installation procedure, reference the Sierra Manual that fits your engine application.

Torque Specifications

Bolt Size	Torque Value Ft lbs	Torque in lbs	Torque Metric
#6		7-10	0.8 N•m
#10	2-3	25-35	2.8-4.0 N•m
#12	3-4	35-45	4.0-5.1 N•m
1/4"	5-7	60-80	6.8-9.5 N•m
5/16"	10-12	120-140	13.6-18.8 N•m
3/8"	18-20	220-240	25-27 N•m