



**Installation Manual v1.1:
Coolant Return Lines
Ford 6.0L Power Stroke**

Please read all instructions before installation.

If you are trying to stop coolant from purging from the overflow tank on your 6.0L Power Stroke, consider ATS 6.0L Head Studs, ATS 6.0L Fire Ring kit, the ATS EGR Blocker, in addition to ATS Cylinder Head Coolant Return Line Modification.

1. Reference the supplied photo for location of coolant return fitting. Drill pilot hole in desired location, progressively drill to a size of 7/16". Tap hole with 1/4-18" NPT tap. Install fitting with thread sealant. Perform operation to other cylinder head.



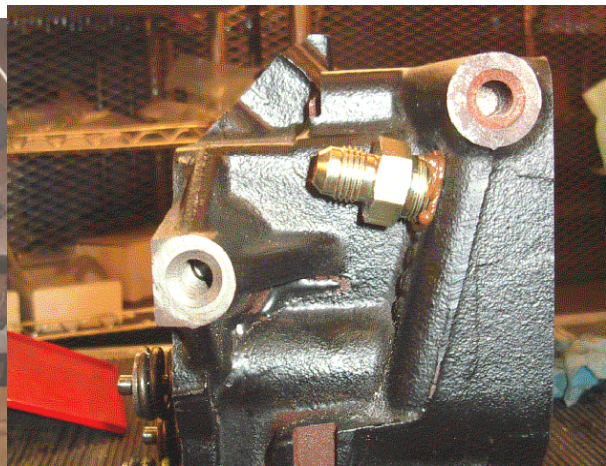
Drilling Pilot hole in Driver side Cylinder Head



Finished Passenger Side



Fitting will be offset to water jacket port



Finished Driver Side

2. Install coolant lines to cylinder heads before installing heads onto block. Long coolant line goes to rear of passenger cylinder head.
3. Remove thermostat. Plug hole below thermostat with a rag.
4. Drill holes in water manifold in locations shown in photo. **Important: Make sure the coolant lines are routed so that they reach the water manifold without any problems. Do this before drilling holes.**



5. Drill pilot hole in desired location, progressively drill to a size of 7/16". Tap hole with 1/4-18" NPT tap. Install fitting with thread sealant. Repeat for second hole. Attach lines.

Make sure there is no debris from drilling left in the engine/cylinder head

Thank you for purchasing the ATS Coolant Return Line kit. Call or check our website for other products that ATS has developed for the 6.0L Power Stroke including E-Power Tuners, Head Studs and Fire Rings, High Performance Fuel System, Fuel Injectors, Aurora Turbochargers, Five Star™ Viskus Drive Torque Converter, Heavy Duty Transmission, Torque Pro Propane Injection, and Stainless Steel Exhaust. If you have any problems with this install, please call or e-mail our Technical Service Department, 8:00am to 5:30pm Mountain Standard Time, Monday through Friday.

Contact Information

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Bill of Materials

1. Passenger Side Coolant Return Line
 - (1) 39" -6 Steel Braided Line
 - (1) 10691N-6-6 Straight Fitting
 - (1) 13991N-6-6 90° Fitting

2. Driver Side Coolant Return Line
 - (1) 33" -6 Steel Braided Line
 - (1) 10691N-6-6 Straight Fitting
 - (1) 13991N-6-6 90° Fitting

3. (4) ¼ NPT to -6 Fittings