



## INJECTOR BUNG INSTALLATION INSTRUCTIONS

**WARNING!** These instructions must be read and fully understood before beginning installation. Failure to follow these instructions may result in poor performance, vehicle damage, personal injury or death. If these instructions are not fully understood, installation should not be attempted.

### INTRODUCTION:

Holley Performance Products cannot and will not be responsible for any alleged or actual engine or other damage, or other conditions resulting from misapplication of the products described herein. However, it is our intent to provide the best possible products for our customer; products that perform properly and satisfy your expectations. Should you need information or parts assistance, please contact our Technical Service Department at 1-270-781-9741, Monday through Friday, 8 a.m. to 5:00 p.m. Central Time; please have the part number of the product you purchased when you call.

**WARNING!** Installation of injector bungs requires machining your intake manifold. This procedure must be performed by a professional machine shop. All injector bungs must be drilled at the same angle to provide proper alignment of the fuel rails.

**WARNING!** For optimum performance, the injector must be pointed towards the center of the intake valve or in a position that will allow good fuel air distribution and allow for clearances. Before drilling the intake manifold for the injector bungs, three things need to be determined - one being, the angle of the drilled injector bung hole. Secondly, the height of the fuel rail assembly needs to be determined from the location of the injector bung installation location to check for interference. The injector bung can be raised and lowered in the machined hole providing a limited amount height clearances. The last thing to be determined is the securing of the fuel rails. Securing of the fuel rails need to be taken into consideration, because this could cause clearance problems in the final installation of your fuel injection system.

### INSTALLATION:

1. Determine the angle at which the injector bung mounting hole will be machined.
2. Drill a 27/32 hole for the injector bung in each of the intake runners. This should only be performed by a machine shop with the proper equipment.

**WARNING!** Each drill hole must be drilled at the exact same angle or binding and misalignment will occur in the fuel injection system causing leaks and possible fire.

3. Install the fuel injectors into the fuel rail and install an injector bung onto each injector.
4. Fit and align the fuel rail assembly into the machined injector bung holes to check for clearance height and binding.
5. If the bungs are to be TIG welded, hold the fuel rail assembly in place and tack weld each bung into position. Remove the injectors before fully welding the bungs into position. To epoxy the injector bungs into position, use a quality fuel proof epoxy such as J.B. Weld. Apply a liberal amount of epoxy to each of the injector bungs and slide the fuel rail assembly into position and hold in position until epoxy sets up.

**WARNING!** DO NOT weld injector bungs in place with injector in the bung. The extreme heat from the welding will damage the injector.

**WARNING!** DO NOT allow the injector to come into contact with the epoxy. This could make the injector non-removable and possibly damage the injector.

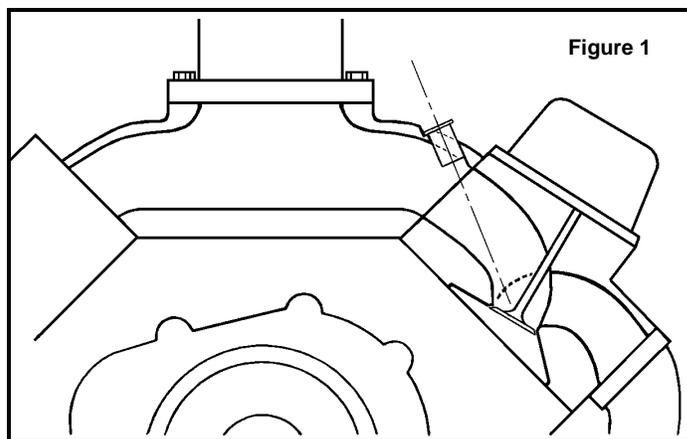


Figure 1

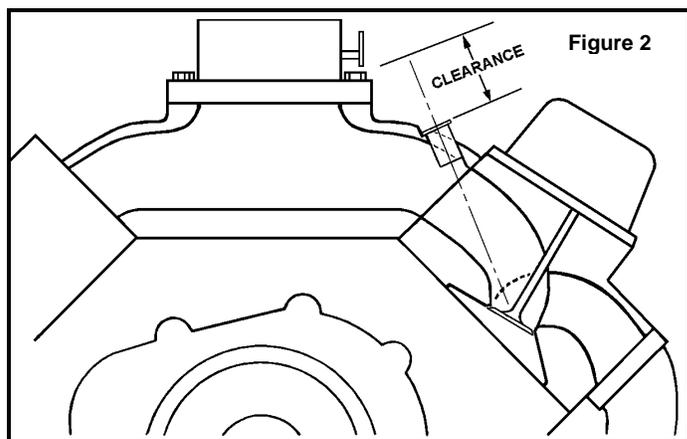
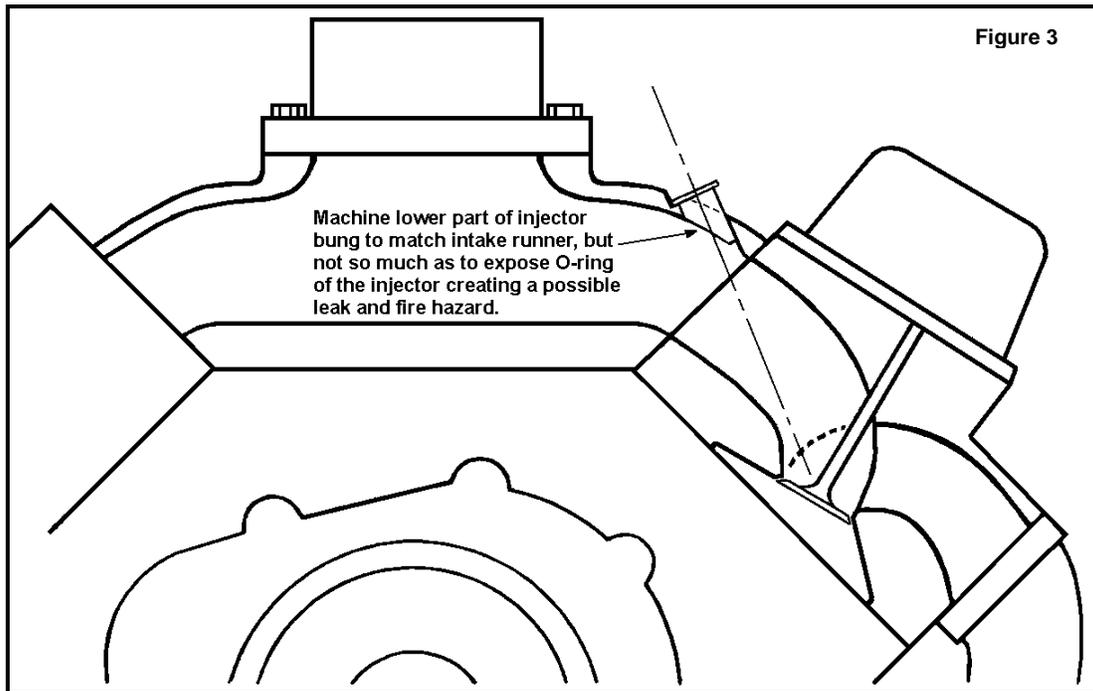


Figure 2

6. Remove the injectors from the injector bungs.
7. Remove the lower part of the injector bung sleeve, which extends into the intake runner with a hand grinder. This will prevent disruption of the air flow, however, DO NOT remove so much of the injector bung as to expose the O-ring of the injector which will cause a leak and possible fire.



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