



Use a perfectly flat area for assembly and ensure that all machined faces and internal threads are clean.

Each section has right-handed connections at one end and left-handed ones at the other. Nipples have one end left handed and one right handed. Study the orientation of connections carefully before assembly.

There are 2 joints to be made for each pair of sections. Each of these requires 1 connection nipple and 1 gasket. A nipple key and tommy bar are required to rotate and tighten the connections.



Screw a pair of nipples into one end of the radiator.

Only screw in by one turn, do NOT screw in fully.

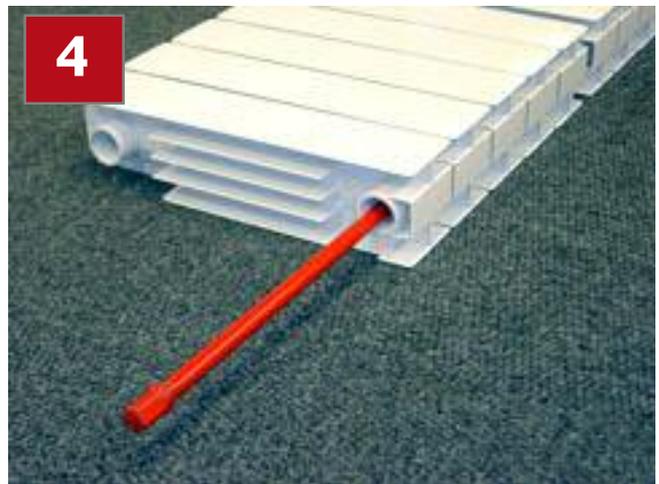
Place a gasket approximately at the mid-point of each nipple.

Do not use any jointing paste or tape (PTFE or similar) to the gasket, nipple threads or radiator.



Carefully slide the second section next to these nipples, taking care that the thread connections are correct.

Place the nipple key over the top of the radiator so the head is in line with the nipples to be turned. Mark the key so that when it is inserted the head will engage inside the nipple. Slide the key in from the open end of the waterway until it engages into the nipple that needs tightening. Check the end of the key has fully engaged in the internal lugs inside the nipple.



Rotate the nipple using the nipple key, so that it pulls the 2 sections together: At this stage only rotate the nipple by one turn. Repeat with the other nipple.

Repeat the above, alternating so that both sections are pulled gradually together and ensuring they are kept parallel. Finally, tighten the joints so the gaskets are firmly compressed. A tightening torque of 100 lb-ft must be applied to Alba, Alliance & Tropical 95.

A torque of 78 lb-ft must be applied to Longo & Sill Line.

DO NOT TEST WITH AIR

Note: Aluminium radiators cannot be tested with air and wet gaskets cannot be re used.