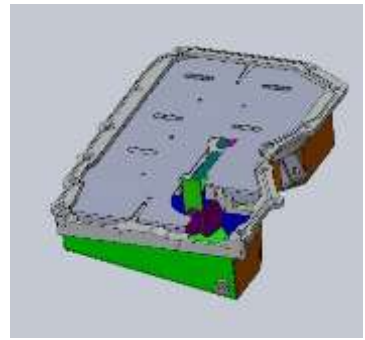
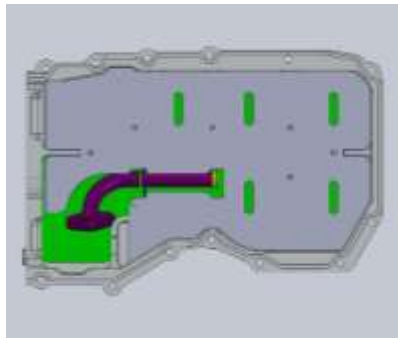
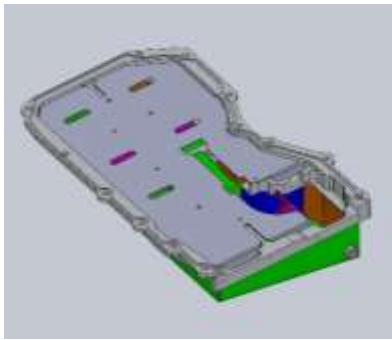


## Duratec Sump Fitting Guide:

2.5 Duratec Sump / Part Number: ENG0734

### What's Included:

- 2.5 Duratec Sump Unit
- 2.5 Duratec Sump Pick up pipe
- Oil Pickup Pipe O-Ring
- Oil Pickup Pump O-Ring
- 2 x M6 x 25mm cap head bolts
- 2x M6 Snor washers
- 13x M8 x 25mm cap head bolts
- 13x M8 Snor washers
- Magnetic Oil bung and sealing washer
- Sump comes with the windage tray pre fitted ready for fitting.



### STEP 1:



1. Make sure the Delete Kit is fitted on 2.5ltr engines with balance shafts removed. (Part Number ENG0298) use grease on O ring and retainer on the bolt with Snor washer.



**Part Number -ENG0298**

[www.atrproducts.co.uk](http://www.atrproducts.co.uk) | [www.kitspares.co.uk](http://www.kitspares.co.uk)

### Fitting guide for the Duratec Sump.

This Assembly Guide document is only a guide, and we reserve the right to change any contents and specification at any time without notification.

**STEP 2:**



2. Ensure all parts are thoroughly cleaned and free from any dirt or dust etc use a solvent cleaner or similar.
  - Fit oil pickup pipe this has an O ring seal use grease to hold it in the groove on the pickup flange then use the 2 M6 by 25mm Cap head bolts with Snor or spring washer also us lock tight, these are torqued to 13Nm. Also, there is a second O ring that sits at the end of the pickup pipe in a groove.
  - Make sure of the block face is clean & oil free.
  - Trial fit the sump without sealant first to make sure everything fits and there is access with in the vehicle if engine is fitted once happy continue.

**STEP 3:**



3. Run Sealant around the Channel and front face of the sump making sure there are no gaps and that it is run on the inside of all bolt holes. Do not use too much as you do not want excess seal to push out on the inside of the sump.

**STEP 4:**



4. Sealant bead evenly applied on all sealing faces with no gaps.



**Note:** That the sealant around the hole must go on the inside to complete the seal. Use a RTV sealant.

**Part Number - CON0655.**



#### **STEP 5:**



5. Offer up the sump and hold in place with two of the M8 by 25mm bolts in the centre on both sides (do not tighten at this stage) just loosely put it up to hold the weight.

#### **STEP 6:**



6. Start by fitting the 4 x M6 Bolts with locking washers along the front edge, again do not fully tighten at this point.

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**STEP 8:**



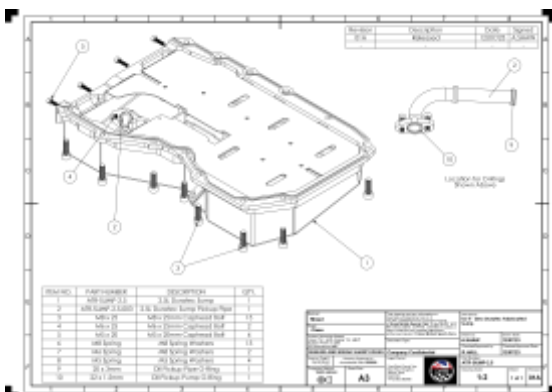
8. Go ahead and fit all other M8 by 25mm bolts with locking washers. Do not fully tighten. Let the sealant go off for 20 minutes or so before tightening all screws, start with the front edge M6 bolts – 11Nm then starting in the centre go opposites until all tight torque to 30 Nm. Then allow sealant to fully cure before filling with oil, ideally overnight / 24 hours. Also check that the sump bung is in place and tight with sealing washer.

**STEP 9:**

9. Dip stick - There is a barbed fitting on the inlet side this is where your dip stick pipe attaches fit the rubber hose over this and fit hose clip to secure fill the sump with 4.6/4.7ltr of oil (usually 5-30W) this is the low level then put in dip stick and see where the level is on the stick mark this point as you low level mark, then fill the remainder so you have 5ltrs in total and mark this point as you full point we recommend you operate your engine with the oil at this level.

See attached Sump drawing for more information.

(ATR-SUMP-2.5 / ENG0734)



ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	ATR-SUMP-2.5	2.5L Duratec Sump	1
2	ATR-SUMP-2.5-003	2.5L Duratec Sump Pickup Pipe	1
3	M8 x 25	M8 x 25mm Caphead Bolt	13
4	M6 x 25	M6 x 25mm Caphead Bolt	2
5	M5 x 20	M5 x 20mm Caphead Bolt	4
6	M8 Spring	M8 Spring Washers	13
7	M6 Spring	M6 Spring Washers	2
8	M5 Spring	M5 Spring Washers	4
9	20 x 3mm	Oil Pickup Pipe O-Ring	1
10	22 x 1.5mm	Oil Pickup Pump O-Ring	1

Location for O-Rings  
Shown Above

Revision	Description	Date	Signed
01A	Released	12/07/23	A.S.HAW

Material: Mixed	Finish: Clean	Tolerances: Unless otherwise stated 1st. 48.8°	Surface Finish: 3.2µm
All Dimensions in mm			
<b>DEBURR AND BREAK SHARP EDGES</b>			
Approx Weight: N/A(kg)	Drawing Produced by: A3	Approved With: 85593	Company Confidential
Copyright © 2023 ATR Products Ltd. All Rights Reserved. No part of this document may be reproduced without the prior written permission of ATR Products Ltd.			
Description: <b>Its 4 - Zero Duratec Fabricated Sump</b> Drawn by: <b>A.S.HAW</b> Checked/Approved by: <b>R.HALL</b>		Date: <b>12/07/23</b> Checked/Approved Date: <b>12/07/23</b>	Part Number: <b>ATR-SUMP-2.5</b> Drawing Scale: <b>1:2</b> Sheet: <b>1 of 1</b> Revision: <b>01A</b>

### Fitting guide for the Duratec Sump.

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