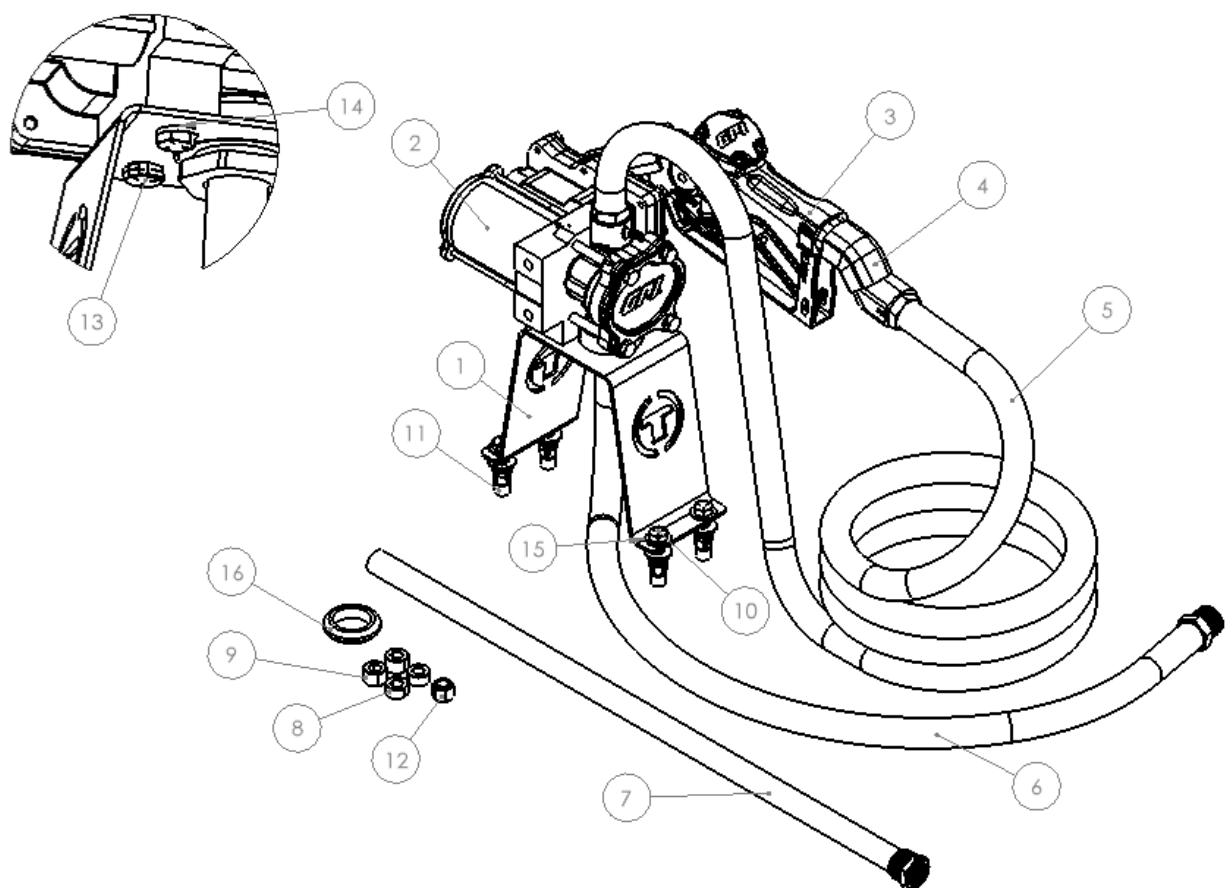


TITAN™ Fuel Tanks
Installation Instructions

Gen 7 In-Bed Transfer Pump Kit (9901790)





Item Number	Part	Quantity
1	Pump Mount Bracket	1
2	Pump	1
3	Nozzle	1
4	Swivel	1
5	Nozzle Hose	1
6	Draw Hose	1
7	Pickup Tube	1
8	.375" spacer	2
9	.5" Spacer	2
10	.375" X 1.5" Hex Head Screw	4
11	.375" Plus Nut	4
12	Plus Nut Tool	1
13	.375" X .75" Hex Head Screw	2
14	.375" Split Lock Washer	2
15	.375" Washer	4
16	Grommet	1

Part 1: Prepare the Bed for Pump Installation

Step 1: Confirm Tank Compatibility

- Ensure the **Titan Extra Range tank is Gen 7-compatible**.

Step 2: Select Pump Mounting Location

- Mount the pump bracket in the **front left corner** of the truck bed.
- Check underneath for **wiring or structural interference** before drilling.

Step 3: Mark and Drill Mounting Holes

- Use the **pump bracket (Item 1)** to mark 4 holes.
- Drill **four 17/32" holes** in the marked spots.

Step 4: Install Plus Nuts

- Insert **3/8" plus nuts (Item 11)** into the holes:
 - Tap in gently as needed.
 - Expand using the **plus nut tool (Item 12)** and a 3/8" bolt.

Step 5: Drill Draw Hose Access Hole

- Drill a **1.5" hole** directly beneath the pump bracket using a hole saw or step bit.
 - Install the **rubber grommet (Item 16)** in the hole.
 - *Tip:* Use alcohol spray to ease installation.
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Part 2: Install the Fuel Pump

Step 6: Mount the Pump Bracket

- Use **four 3/8" x 1.5" screws (Item 10)** and **washers (Item 15)** to secure the bracket to the bed.
- Add **spacers (Items 8 or 9)** if needed to keep the bracket level.

Step 7: Attach Draw Hose & Mount Pump

1. Apply **blue Teflon tape** to the **draw hose (Item 6)** fitting.
2. Feed the hose **through the bracket** and **down through the grommet (Item 16)**.

3. Secure the **pump (Item 2)** to the bracket using:

- **Two 3/8" x 0.75" screws (Item 13)**
 - **Split lock washers (Item 14)**
 - **Flat washers (Item 15)**
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Part 3: Prepare the Titan Tank for Fuel Pickup

Complete these steps *before the tank is fully raised into position*.

Step 8: Locate Drill Point for Pickup Tube

- Identify the **insert located above the fuel trap** on the Titan tank.
- Remove any **plug or cap** in this location.

Step 9: Prevent Plastic Shavings

- Place a **rag, cup, or vacuum hose** under the drill point inside the tank to catch debris.

Step 10: Drill the Tank Hole

- Start with a **pilot hole**, then enlarge gradually to the final size.
- Use **grease on the drill bit** to capture plastic shavings.

Step 11: Trim the Hole Edge

- Use a **razor blade or utility knife** to smooth the edges and avoid cross-threading.

Step 12: Clean the Tank Thoroughly

- Remove all debris using **compressed air, vacuum, or damp cloth**.
 - This is **critical to avoid fuel system damage**.
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Part 4: Install the Pickup Tube & Final Connections

Step 13: Cut and Install Pickup Tube

- Measure and cut the **pickup tube (Item 7)** to sit **3" above the tank floor**.
 - Do **not** let it touch the bottom.

- Apply **blue Teflon tape** and thread the tube into the hole.

Step 14: Connect Draw Hose

- Before fully raising the tank:
 - Thread the **draw hose (Item 6)** into the pickup tube fitting.
 - Use **thread sealant** to ensure a tight, leak-free seal.
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Final Steps

Step 15: Install Titan Tank

- Complete tank install per Titan's instructions.
- Check for:
 - **Kink-free hose routing**
 - **Tight fittings**
 - **Proper clearance**

Step 16: Install Nozzle Assembly

1. Connect **swivel (Item 4)** to **nozzle hose (Item 5)**.
2. Attach **nozzle (Item 3)** to swivel.
3. Connect the assembly to the **pump outlet**.

Step 17: Wire and Prime the Pump

- Wire pump according to manufacturer instructions.
- Use a **relay or switch** for safe control.
- Prime the system and **check for leaks or air pockets**.



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