



## CLAMP-ON OXYGEN SENSOR BUNG

71014301-RHKR (3"), 71014302-RHKR (2.5"), & 71014303-RHKR (2.25")

### Installation Instructions

#### PRE-INSTALLATION CONSIDERATIONS:

Check that the hardware package includes the following:

Qty.	Description
1	Oxygen Sensor Bung Casting
2	Stainless Steel T-Bolt Clamps
1	Gasket

If any listed hardware is missing, please contact Technical Service at: 1-866-464-6553 or 270-781-9741.

**IMPORTANT!** Position and support your vehicle on a suitable surface. **USE CAUTION AND WORK ONLY ON A LEVEL SURFACE USING JACKS AND JACK STANDS OF SUFFICIENT CAPACITY TO LIFT AND SUPPORT YOUR VEHICLE. NEVER WORK UNDER A VEHICLE SUPPORTED BY A FLOOR OR BUMPER JACK.** Use of a two-post under arm lift or four-post drive-on lift will considerably reduce the time and effort required to complete the installation. **MAKE SURE LIFT LOCKS ARE ENGAGED BEFORE WORKING UNDER THE VEHICLE.**

**IMPORTANT!** Must use small amount of anti-seize on the threads of the T bolt clamps to prevent thread damage.

#### INSTALLATION:

1. Place the vehicle on a flat surface, set the parking brake, and block the front wheels.
2. Lift the vehicle and support with jack stands.
3. Locate a place in the exhaust to drill a 3/4" hole. Make sure to allow enough clearance for an O<sub>2</sub> sensor and wiring harness. It is important to keep the O<sub>2</sub> bung at least 12 inches from open exhaust. Ensure the location for the sensor is at an angle (Figure 1). This will help prevent condensation in the exhaust tubing from entering the sensor. The sensor can be mounted on either side of the tubing.

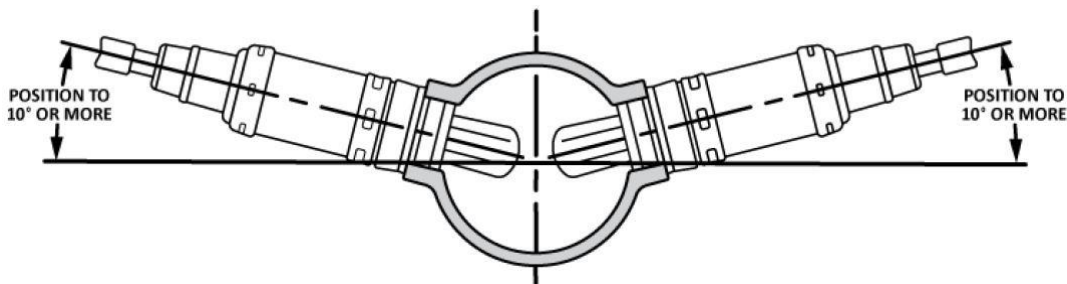


Figure 1

4. Mark the center of the casting on the exhaust tube and drill a 3/4" hole. Deburr the hole after drilling (Figure 2).

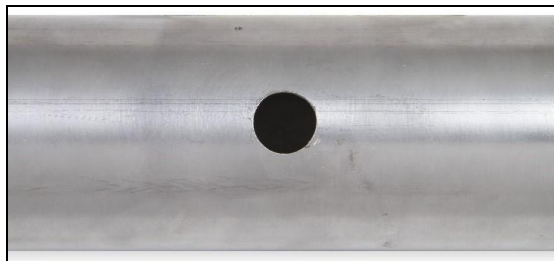


Figure 2

5. Place the gasket on the tube, then the casting on the tube. Slip a clamp on one side and lightly tighten. Slip the second clamp on and lightly tighten. It is necessary to use a small amount of anti-seize on the threads of the T bolt clamps to prevent thread damage.



**Figure 3**



**Figure 4**



**Figure 5**

6. Verify the center of the casting is in the center of the hole and tighten clamps.
7. Install the O2 sensor in the bung. Lightly tighten with a wrench.



**Figure 6**

**Technical Service: 1-866-464-6553**

**Phone: 1-270-781-9741**

**For online help, please refer to the Tech Service section of our website: [www.holley.com](http://www.holley.com)**

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**199R10982**

**Revision Date: 7-18-16**