



Instructions for:

## R-Series Tunnel Ram Intake Manifold for 429/460 Ford

equipped with Trick Flow PowerPort® A460 Cylinder Heads

**TFS-54494000, TFS-54494001 (Single 4500) , & TFS-54494140 (Dual 4500)**

Thank you for purchasing the Trick Flow R-Series Intake Manifold for the 429/460 Ford engines equipped with Trick Flow PowerPort® A460 cylinder heads. This manifold is designed for high performance applications and requires either one or two Holley 4500 Dominator style 4-barrel carburetors depending on which manifold top cover you purchase.

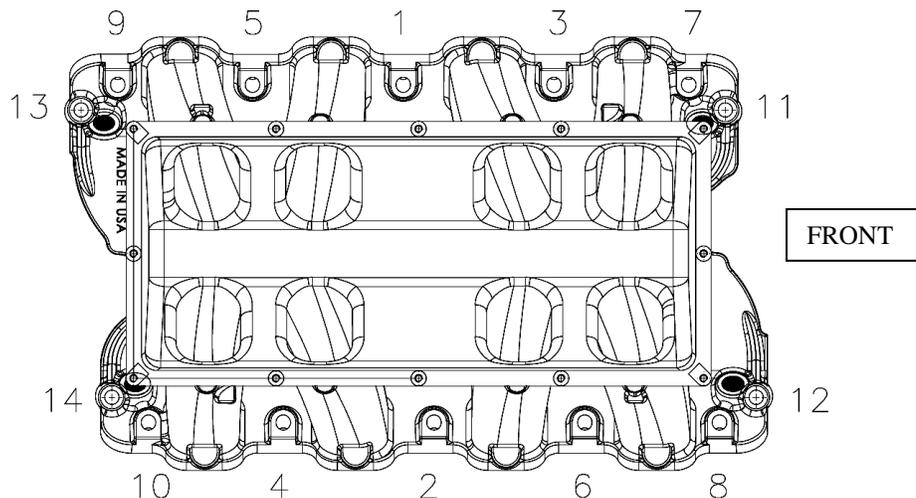
### Recommended Components:

- Permatex # 16B Black Silicone Adhesive Sealant
- Fel-Pro # 1230 Printoseal intake manifold gaskets (TFS-53400111)
- Trick Flow # TFS-53400921 intake manifold gaskets (TFS-53400112)

### Installation Procedure:

- 1.) Thoroughly clean the gasket surfaces on the cylinder heads and the block end rails.
- 2.) Run a 1/4"- 5/16" bead of silicone adhesive sealant along the end rails.
- 3.) Outline the water openings on the cylinder heads with silicone adhesive sealant to prevent potential leaks between the cylinder heads and the gasket. This will also help keep the gaskets in place while installing the manifold.
- 4.) Place the intake manifold gaskets on the heads.
- 5.) Place a small amount of silicone adhesive sealant on the end rails of all four corners where the intake manifold gaskets and end rails intersect.
- 6.) Install the intake manifold by carefully lowering it onto the gaskets.
- 7.) Thread the bolts in and begin tightening them while keeping an eye on the gaskets to make sure that they stay in place.
- 8.) Torque the manifold bolts in the following steps, using the sequence below.

Step 1: 16 ft.-lbs.  
Step 2: 22 ft.-lbs.  
Step 3: 30 ft.-lbs.



9.) Either plug coolant crossover ports or route your coolant crossover lines. The routing of your coolant lines may vary depending on your application. Below you will find a list of recommended fittings to adapt your Trick Flow manifold to your cooling system. Be sure to use Teflon tape on all pipe fittings for a leak-proof seal.

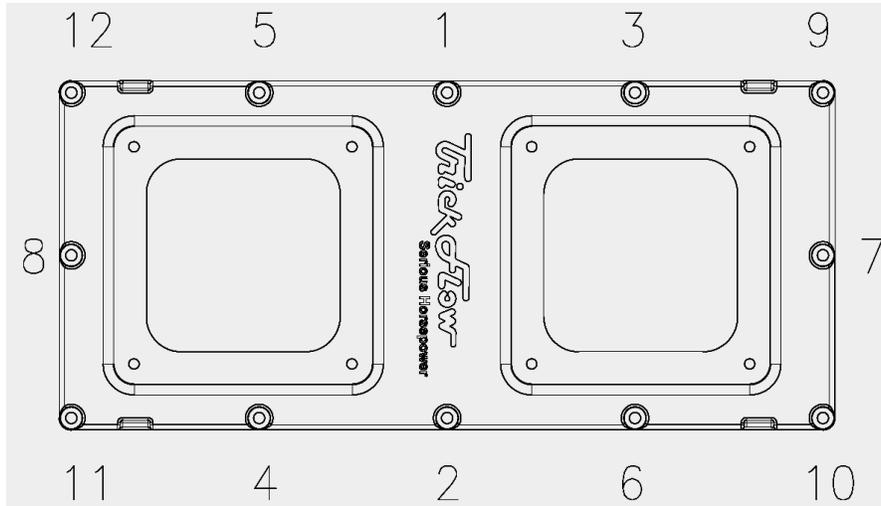
#### **Recommended cooling system fittings**

- EARL'S # AT981688ERL or equiv.  
8AN – ½ NPT Adapter
- EARL'S # AT92388ERL or equiv.  
8AN – ½ NPT, 45 Degree Adapter  
*(For distributor clearance using MSD #8569 distributor)*
- EARL'S # AT993205ERL or equiv.  
½" NPT Plug
- Trick Flow # TFS-22908 or equiv.  
8AN 90 Degree Hose End

Below is a picture showing the use of EARL'S 45 Degree Adapter and a Trick Flow 90 Degree Hose End in order to provide adequate distributor clearance if a front coolant crossover is required.



- 10.) Install top cover gasket on top of Tunnel Ram base. A thin coating of RTV may be helpful to hold the top cover gasket in position.
- 11.) Place top cover onto Tunnel Ram base.
- 12.) Thread top cover bolts in and begin tightening them while keeping an eye on the gasket to make sure that it stays in place.
- 13.) Torque the top cover bolts to 70 in. lbs. using the sequence on the following page.



14.) After initial start-up, check for leaks.

### **Ultimate Bolt-On Performance® Lifetime Warranty**

**Trick Flow Specialties cylinder head castings are backed by a lifetime warranty. If a cylinder head casting fails to provide the original purchaser with complete satisfaction, Trick Flow Specialties will repair or replace it free of charge — guaranteed!**

Moreover, the valves, valve guides, valve seats, valve job, valve springs, valve spring retainers, valve locks, rocker arm studs, guideplates, and valve stem seals included on assembled Trick Flow Specialties cylinder heads are warranted to the original purchaser to be free from defects in materials and workmanship for a period of two years from the date of purchase. All other Trick Flow Specialties products are warranted to be free from defects in materials and workmanship for a period of 90 days. There are no mileage limitations.

#### **Extent of Warranty**

Customers who believe they have a defective product should return it to the dealer from which they purchased or ship it freight prepaid to Trick Flow Specialties along with proof of purchase and a complete description of the problem. If a thorough inspection indicates defects in materials or workmanship, our sole obligation is to repair or replace the product.

This warranty is only if the product is properly installed, subjected to normal use and service, did not fail due to owner negligence or misuse, and has not been altered or modified.

Trick Flow Specialties warranties do not cover any installation or removal costs.

Trick Flow Specialties is not liable for consequential damages for breach of contract of any warranty in excess of the purchase price of the product sold.

#### **PROPOSITION 65 WARNING**

This product may contain one or more substances or chemicals known to the state of California to cause cancer, birth defects or other reproductive harm.

TRICK FLOW SPECIALTIES  
285 WEST AVE.  
TALLMADGE, OHIO 44278  
(330) 630-1555

