

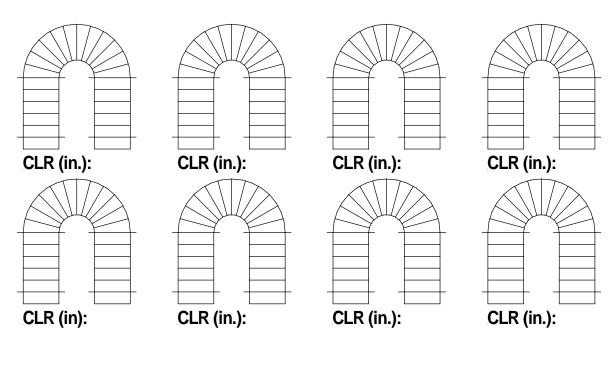
Control Sheet for FESeries

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Directions for Use:

- Upon completion of your icengineworks[™]-modeled full exhaust/downpipe design and starting at the collector/open end tube going downstream of flow, identify the first section of blocks with same CLR and aligned arrows as explained in the Instructions Manual.
- 2. Mark and label the corresponding blocks or spaces in the drawings below per CLR. Using one bend drawing for every CLR you use, start by filling the field provided with the CLR used. All blocks in the FESeries are 15-deg. It's necessary to record only how many blocks and of what CLR are needed per section. Write the bank number and the section number in that exhaust tube. Label also the direction of flow to avoid confusion. For example: D1, D2, etc., denoting the first section of the DRIVER cylinder bank, followed by the next section (2) going downstream, and so on until all sections in that exhaust tube are accounted for. Maximize the available metal in each U-Bend to reduce costs. Take into consideration blade thickness and tolerance build-up. For straight sections, record lengths of sections in the same manner.
- 3. Move on to the other bank (s) (PASSENGER side for example) and repeat until the entire design is tallied. You may need to rearrange the drawings if empty or unused block spaces are still available. This will save on bends to buy. Review your information before ordering bends to reduce mistakes. It is wise to order extra bends just in case something unexpected happens.
- 4. When cutting the metal bends, remember to label each section as you go through all the sections to avoid mixing them up when assembling, particularly the flow direction. When they are all cut, many of them may look very similar.

Tubing OD (in):



Straight sections in 1" and 5" increments

