

# Installation Guidelines

## VENTILATION

The engine must be provided with a supply of fresh air for cooling and for combustion. Figure 2.

**Pressure Cooled Engine:** Position the air inlet opening directly in front of the engine and as close to the engine blower wheel as possible. The area of the inlet should be not less than 60 square inches (419-cm<sup>2</sup>). If louvers or grill work are used, increase the area to compensate for the reduced air flow. Provide extra ventilation if the driven load generates heat during operation.

The heated air outlet must allow the heated air to escape freely and prevent recirculation with the cooling air. A duct between the compartment air inlet and the engine blower housing may be necessary. Locate the air outlet opposite the intake or at least at a 90 degree angle. The area of the outlet should be at least 15 percent larger than that of the inlet. Allow sufficient room on all sides to permit access for servicing.

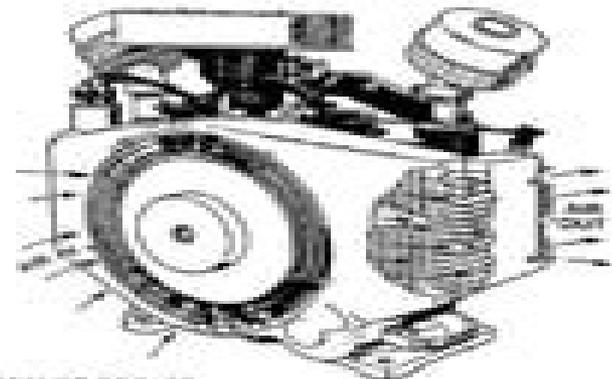
**Open Air Installation:** For installations where the engine is operated outside, ventilation will be no problem. However, in protecting the engine from the elements, see that nothing obstructs the flow of air around the engine.

**Vacu-Flu Cooled Engine:** The Vacu-Flu equipped engine uses separate flywheel and a blower wheel to pull cool air into the engine shroud and over the cooling fins and surfaces of the engine. Figure 2. The heated air is directed through an air tight scroll which encases the blower. The scroll may be positioned to discharge heated air in the 12 o'clock or 3 o'clock direction. (Figure 2). The scroll outlet has a mesh-type screen for safety.

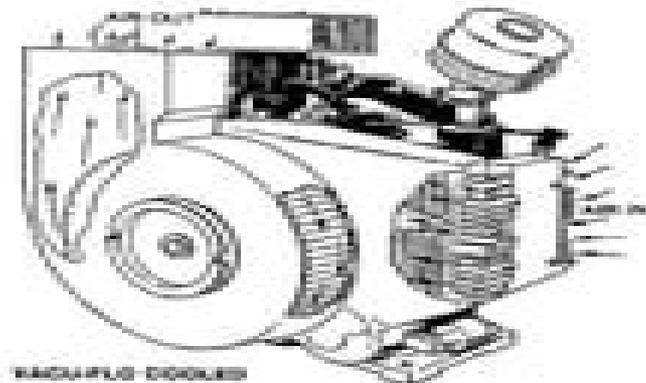
### CAUTION

The outlet of the VACU-FLU scroll must not be restricted or overheat- ing will result. Engine overheating can cause troubles ranging from upper lock to scored pistons and cylinders.

The area of the air inlet must be at least 140 square inches (900 cm<sup>2</sup>). If a filter, grille, or louvers are used, the inlet opening must be increased accordingly. The air outlet opening should be located as close to the engine as possible.



PRESSURE COOLED



VACU-FLU COOLED

FIGURE 2. AIRFLOW THROUGH ENGINES

If the duct length exceeds 5 feet (1.52 m), increase duct size 50 percent. Use no more than two 90 degree radius-type (not square-type) elbows if it is necessary to change air flow direction. When a duct is used between the scroll discharge and the outlet vent, its unobstructed airflow area must be at least as large as the scroll discharge. The cross-sectional area of the duct must be increased if air flow is restricted by bends, long runs, screens or the exhaust pipe. Exhaust pipes running inside Vacu-Flu ducts should be covered with asbestos tape.

# 1r Engine Manual

**J Spring**



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