

# BILLET HEAT EXCHANGER

## 2003–2009 5.9L Cummins

**Fitment:**

2003–2009 Dodge Ram 2500/3500 — 5.9L Cummins Diesel

### PRODUCT OVERVIEW

- Upgrades the Cummins cooling system to eliminate factory failure points.
- Prevents coolant and transmission fluid cross-contamination — a known issue on 3rd Gen Cummins trucks.
- CNC-machined billet construction for performance and towing applications.

# INSTALLATION

## TOOLS & PREP

- Basic hand tools
- Hose clamp pliers
- Drain pan
- Fresh coolant
- Transmission fluid

### STEP 1 DRAIN COOLANT AND PREP

- Drain the engine coolant completely.
- Remove the components needed for access: intake horn, intercooler piping (if required), and move battery terminals and cables out of the way.

### STEP 2 REMOVE FACTORY HEAT EXCHANGER

- Disconnect the coolant hoses from the factory heat exchanger — remove hose clamps and expect residual coolant.
- Disconnect the transmission fluid lines.
- Remove the bolts securing the heat exchanger bracket to the engine block.
- Remove the factory heat exchanger with the bracket still attached.

### STEP 3 SWAP TO FULL SEND DIESEL BILLET HEAT EXCHANGER

- Remove the factory heat exchanger from the bracket.
- Install the Full Send Diesel billet heat exchanger onto the factory bracket using the supplied hardware only.
- Verify correct port orientation (coolant + transmission).

# INSTALLATION (CONTINUED)

## STEP 4 REINSTALLATION

- Reinstall the bracket and exchanger assembly onto the engine block.
- Torque the bolts to factory spec.
- Reconnect the transmission lines.
- Reconnect the coolant hoses and secure all clamps.
- Reinstall the removed components — battery cables, intake horn, and intercooler piping.

## STEP 5 FINAL STEPS

- Refill coolant.
- Top off transmission fluid.
- Start the engine and let it idle in neutral.
- Inspect for leaks.
- Test drive the vehicle.
- Recheck all fluid levels.
- Perform a final leak inspection.

## WHY UPGRADE

Eliminates a known factory failure point · Prevents coolant / transmission fluid cross-contamination · Increased reliability under towing and performance use · CNC-machined billet construction.

## NEED HELP?

Call or text **908-223-9744**. Send pictures or video and we'll walk you through it.

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