



# INSTRUCTION SHEET

**PART # 68640, 68643, 68646, 63648, 68648, 68650, 68653, 68656**  
**1964-87 SB CHEVY 283-400 ENGINES**

**CAUTION!** This exhaust header system is designed for this particular application. Do not bend, bang, cut, dent, drill or heat any portion of this header! Any alteration other than those suggested in this instruction sheet will void the Hedman Lifetime Guarantee!  
To prevent leaks, install your headers using Hedman Hedders exhaust gaskets ONLY and a spray copper gasket sealant.

### BEFORE STARTING INSTALLATION:

It is necessary to raise the vehicle at least 36 inches from the ground. A floor hoist is recommended. If not available, use a hydraulic floor jack with jack stands. **DO NOT USE A BUMPER JACK!**

### BEFORE INSTALLATION:

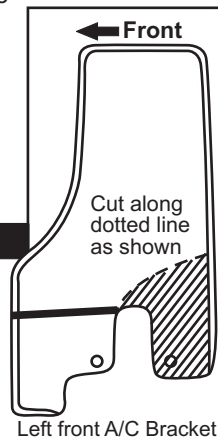
1. Disconnect battery, wires to temperature sending unit and oil dipstick tube.
2. Remove all spark plugs (number wires), factory exhaust manifolds, stock head pipes and air cleaner assembly.
3. Remove clutch linkage (Bell Crank), or Hydraulic slave unit.

### LEFT SIDE: (If equipped with A/C, see "Vehicles Equipped With Air Conditioning" below)

4. To gain adequate clearance to install the left side header, it may be necessary to lift the left side of the engine about an 1". This can be done by unbolting the left side engine mount and using a floor jack under the engine (use a block of wood between engine and jack to prevent damage.)
5. Carefully position the header from below, and loosely thread a bolt into the 2 end holes only. Pull the header away from the head and hang a copper spray treated gasket between the header and head using the 2 end bolts in the header and the slots in the gasket. Insert the remaining header bolts. **DO NOT TIGHTEN BOLTS AT THIS TIME!**
6. If engine was raised in step 1, lower the engine and re-torque the motor mount bolts to spec.
7. Install clutch linkage, or Hydraulic slave unit previously removed.
8. Tighten all bolts on left side header to 35 ft lbs. starting from the inner bolts and working outward.

### RIGHT SIDE:

9. If installing on an A/C equipped vehicle, follow the procedure in step 5 above. If no A/C is installed, the procedure is the same, with the exception that the passenger side header can be installed from above.
10. Tighten all header bolts to 35 ft lbs.
11. With the reducers in place, cut factory exhaust pipes so that the system may be secured by welding the exhaust system to the right and left side header reducers.
12. Reconnect battery and all other parts previously removed or disconnected. Closely inspect for proper fuel line, brake line and shift linkage clearance.
13. Start engine, test drive vehicle allowing engine to gain normal operating temperature. Check for leaks and new or unusual noises. After test drive, allow engine to cool and re-tighten all header bolts to 35 ft. lbs.



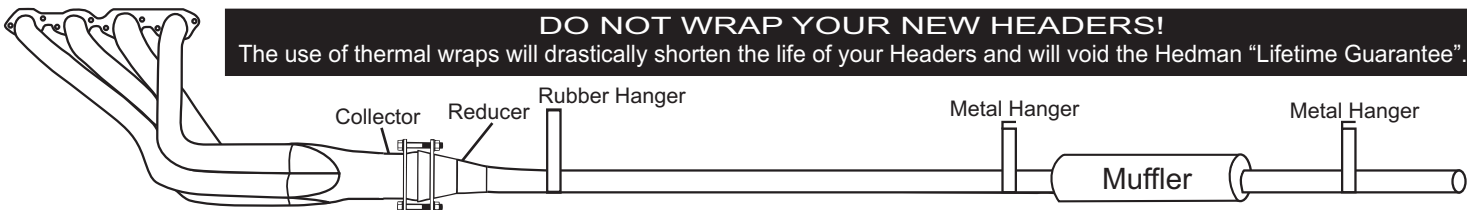
### VEHICLES EQUIPPED WITH AIR CONDITIONING

When you remove the stock bracket (late model rotary type compressor short) see diagram to the right. This shows you how to cut the stock bracket away at the second hole location to clear the header tube for a clean installation. You will have sufficient strength when using the front hole with a simple spacer equal to the thickness of the original cast iron manifold that was removed. You will need to mount the air-conditioner bracket and the power steering bracket to the same bolt with spacer. If your vehicle is equipped with a long round type (piston type) air conditioning compressor unit, you may have to use Hedman air conditioner bracket part #20110, which can be purchased at your local dealer.

### ENJOY YOUR HEADERS WHILE COMBINING INCREASED FUEL ECONOMY WITH BETTER PERFORMANCE.

#### SPECIAL INSTRUCTIONS!

After installing your headers, it is very important that your exhaust system be suspended properly. As indicated in the drawing below, you must place hangers as close to the header collector as possible. Rubber hangers should be used to allow the front of the system to flex with the engine torque. A hanger is needed before and after the muffler (s). When your exhaust system is unbolted from the header collector, it should remain suspended all by itself. Your Headers Are Not designed to support your exhaust system. Failure to follow these instructions will most likely result in cracks around the area where your primary tubes and collector are welded together, and will nullify your "Lifetime Guarantee".



### DO NOT WRAP YOUR NEW HEADERS!

The use of thermal wraps will drastically shorten the life of your Headers and will void the Hedman "Lifetime Guarantee".

**WARNING:** Removal of catalytic converters and other factory air pollution control devices is illegal. We recommend you comply with your state's local laws. Our testing indicates performance is not significantly affected by these devices.