



**PART # 68610, 68616 & 68618**  
**INSTRUCTION SHEET**  
**396-502 ENGINES**

**CAUTION!** This is a custom designed exhaust header system, designed for this particular application (s). 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!***

**PRE-INSTALLATION:**

1. Disconnect the battery, water temperature sending unit, oil dipstick tube, spark plugs (Number Wires), factory manifolds, and stock head pipes.
2. Remove air cleaner assembly and clutch cross shaft.

**INSTALLATION INSTRUCTIONS:**

**LEFT SIDE:**

1. With gasket in place, install the left side header from below. Start all bolts. **DO NOT TIGHTEN!**
2. Re-route brake lines, hoses, etc., making sure that there is adequate clearance. Tighten all header bolts evenly.

**RIGHT SIDE:**

1. With gasket in place, install the right side header from top. Start all header bolts and tighten evenly.
2. With end caps in place, cut factory exhaust pipes so that the system may be secured to headers with one weld on each side.
3. Replace and reconnect all parts that have been removed or disconnected. Check for proper clearance on all brake, fuel lines, hoses, cables, linkage, etc.
4. Start engine, test drive vehicle allowing engine to gain normal operating temperature. Check for leaks and new or unusual noises. After test drive is completed, re-tighten header bolts and fasteners.

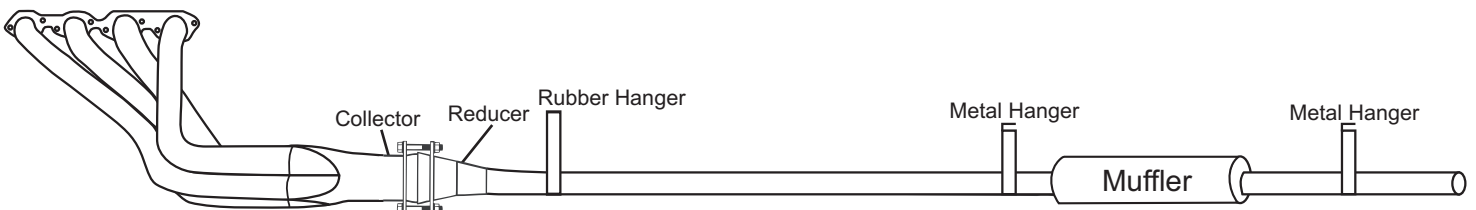
**ENJOY YOUR HEADERS WHILE COMBINING INCREASED FUEL ECONOMY WITH BETTER PERFORMANCE.**

**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:** Not applicable or intended for street or highway use. Legal only for racing vehicles which may never be used upon a public highway.