HEDMAN HEDDERS

PART # 69570 & 69571
PART # 69576 & 66571 - HTC
INSTRUCTION SHEET
1988-95 7.4L GM Trucks w/ or w/o A.I.R. - 1 Ton 2 & 4WD

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!*

This tubular exhaust manifold system is designed as a system to improve the exhaust efficiency of the GM T.B.I. 7.4L V8 engine. A performance gain can be expected by the install of the system. Requires no welding for install & retains all O.E.M. emissions equipment.

DISASSEMBLY
1. Disconnect the negative cable from battery and remove spark wires (Number Wires).
2. Use penetrating oil on all nuts and bolts to be removed. This will prevent the possibility of broken or stripped nuts & bolts.
3. Remove air cleaner system (note position of line and hose connections).

DISASSEMBLY - LEFT SIDE
1. Disconnect A.I.R. (If applicable).
2. Disconnect temperature sensor wire.
3. Remove bolts and exhaust manifold.

DISASSEMBLY - RIGHT SIDE
1. Disconnect A.I.R. (If applicable).
2. Remove dipstick and both sections of dipstick tube.
3. Remove bolts and exhaust manifold.
4. Clean exhaust flange surfaces on cylinder head at this time.

DISASSEMBLY - CROSSOVER PIPE
1. Raise vehicle and support with jackstands.
2. Remove O2 sensor, being careful not to rupture or destroy the unit. **WARNING:** Do not clean this unit in any cleaning solvent and do not rupture wire.
3. Making sure the converter is cool, remove the exhaust crossover pipe. You may find it helpful to clamp the converter to the crossmember using pieces of wood and C-clamps. This will allow you to work the crossover pipe loose from the converter more easily. If the pipe is frozen to the converter, it can be heated with a propane torch to help loosen the joint.

INSTALLATION - LEFT SIDE
1. With flange the gasket in place, install header from bottom and start all bolts. Tighten all bolts evenly from center out.
2. Re-connect spark plug wires (the use of hi-temp silicone plug wires for protection from heat and added performance is recommended).
3. Clean and re-connect temperature sensor wire to sensor.
4. If applicable, re-install A.I.R. system with parts supplied.

INSTALLATION - RIGHT SIDE
1. With flange the gasket in place, install right header from top and start all bolts. Tighten all bolts evenly from center out.
2. Re-connect spark plug wires.
3. Install dipstick tube and dipstick.
4. Install hot air kit supplied.
5. If applicable, re-install A.I.R. system with parts supplied.
6. To prevent damage to heater hose, use a nylon tie wrap and secure to the A/C dryer unit on the firewall.

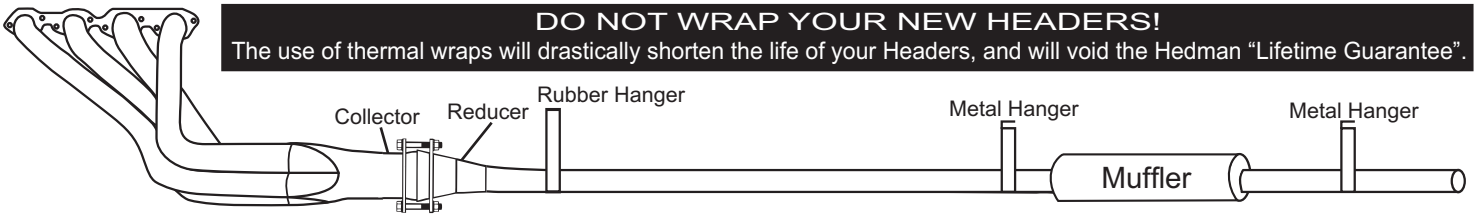
CROSSOVER PIPE ASSEMBLY

Note: *The extension pipe 3" x 27½" may need to be cut and welded to catalytic converter on some vehicles.*

1. Place extension tube into engine side of catalytic converter and leave loose.
2. Bolt the right and left side of the y-pipe to the headers using bolts and clamps supplied. Leave loose.
3. Install u-clamps at slip areas. Tighten y-pipe assembly to headers and secure all clamps, nuts and bolts.
4. Re-install O2 sensor in y-pipe using anti-seize compound (GM #5613695). Do not over tighten.
5. Re-connect O2 sensor computer lead using extension provided in kit (36").
6. Check to make sure all fuel and brake lines, and hoses have adequate clearance.
7. Start engine, test drive vehicle, allowing engine to gain normal operating temperature. Check for leaks & new or unusual noises. After test drive allow engine to cool & re-tighten all header bolts.

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".



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