



## Installation Instructions and Warranty Information

1999-2004 Ford Super-Duty Truck, Excursion, Motor Home  
Part #1669S Triton 6.8L V-10 Engine W/O EGR  
Part #1669S-1 Triton 6.8L V-10 Engine W/ EGR



This Product has been granted a California Air Resources Board (CARB) "E.O" (Executive Order) Exemption, or is considered a Direct Replacement or Consolidated Replacement part. It is 50 State Legal when installed on the appropriate vehicle per the Manufacturer Application guide and Installation Instructions.

Read all instructions carefully before attempting installation.

PerTronix© thanks you for choosing JBA [HEADERS](#), the best fitting, highest quality header on the market. In order to realize the full potential of our good fit, please read and understand these instructions completely prior to starting work.

Check to make sure you received the proper parts for your application. The header number will be stamped on the engine flange. If you are unsure you have received the proper parts call before you start work.

Be sure to work safe! Whenever you work under the vehicle be sure that it is located on level, solid ground and is supported by adequate safety stands! Remember: Hot asphalt will not support most jack stands!

Many factors affect the installation of headers, some of which are broken or aftermarket motor mounts, accidents that impact the configuration of the frame, and/or the installation of different engines or aftermarket cylinder heads.

Attention Customers breaking in new engines: Due to the extreme heat generated during the break-in process, the appearance of the ceramic coating may be altered in certain areas. The protection characteristics and thermal barrier properties of the coating is never compromised. It is recommended that a cast iron manifold or old set of headers be used for this process.

Notice: The coating of these headers can be marred or scratched during installation. If the header needs to be returned and is damaged, you will be charged for recoat.

JBA uses sealing beads on all its headers. We have found that when installed correctly, the raised bead around each port increases the pressure exerted on the gasket directly adjacent to the port and effectively prevents leaking gaskets. It is normal for the flange to be raised off the cylinder head the thickness of the sealing bead. It is important when installing the header, to install all bolts loosely, then tighten evenly to ensure the flat installation of the flange. The torque sequence from one flange to another will vary, but generally every bolt on a header should be first fit snug, starting from the inside of the flange working out, alternating from top to bottom so that the bolt connects the flange to the manifold to the point where they barely touch. Second, using the same inside-out pattern, tighten each bolt until finished. This method will help prevent leakage and will give the user the best possible performance out of their pair of headers.

1. Place vehicle in a location where the floor is solid and flat, with adequate lighting. Do not attempt to work on a hot engine. Heat causes metal to expand and makes removal of fasteners difficult at best. Disconnect the battery cables from the battery. Raise the front of the vehicle to obtain adequate access to the bottom exhaust manifold flanges. Use large-base jack stands to support the vehicle. Do not rely on the jack! Block the tires to prevent the vehicle from rolling off the jack stands.
2. Spray WD-40 or some type of penetrating oil on all accessible fasteners and fittings before attempting to remove them.
3. Start by removing the factory y-pipe. Unbolt the y-pipe from the rest of the exhaust system and the stock manifolds and disconnect the O<sup>2</sup> sensors.
4. Next, if equipped, loosen the EGR tube from the driver side manifold.
5. Remove the nuts attaching the manifolds to the heads. Remove the manifolds. Remove the studs from the heads.
6. Remove the dipstick by unbolting the factory bracket.
7. Using a scraper remove all carbon deposits and high spots from head surface, use care not to gouge the aluminum heads.
8. From underneath the vehicle, slip the new headers into place. Apply a small amount of anti-seize to the threads of the supplied bolts.  
Passenger Side: Slide the header into place and install using the supplied gasket, Header Bolts and Washers. Torque to 23 ft/lbs.  
Driver Side: Slide the dipstick through the header into its hole. Make sure it is seated well. Loosely attach the EGR tube. Using the supplied gasket, headers bolts and washers install the header and torque to 23 ft./lbs. Now tighten the EGR tube and dipstick bracket.
9. Apply a small amount of Hi-temp RTV (sensor safe) around the exhaust pipe flares. Reinstall the factory y-pipe using the supplied hardware. Then reconnect the O<sup>2</sup> sensors.
10. Recheck everything. Make sure there is adequate clearance on all lines (vacuum, brake, A/C, fuel)
11. Reconnect the battery cables.
12. Start the engine, check for leaks and test drive. Then let engine cool and then re-torque the header bolts.
13. Periodically check and retighten the header bolts.

Parts List:

- (1) Driver Side Header Assembly
- (1) Passenger Side Header Assembly
- (2) Header gaskets
- (4) Collector Bolts & Nuts.
- (20) 8mm x 25mm Bolt w/ lock washers
- (1) CARB EO Sticker

### LIMITED ONE YEAR WARRANTY

All JBA HEADERS and exhaust products are guaranteed, to the original purchaser, to be free of defects in materials and workmanship for one year. This warranty covers the replacement or repair of the product only and does not cover the cost of removal and installation, customer applied aftermarket coatings or any discoloration or corrosion of finished surfaces.

Damage or product failure resulting from collision, improper installation, off-road use, road hazards, the use of exhaust insulating wrap or like products or rust occurring after installation, is not covered by the warranty. The warranty extends only to the original purchaser.

Should a part become defective it should be returned to the original selling retailer and must be accompanied with the sales receipt. If there is no retailer in your area, call the factory for a return authorization and return your part prepaid to the factory for inspection. PerTronix reserves the rights to replace or repair the alleged defective part and return the part freight collect.

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performance**exhaust**®