



## LS1 F BODY HEADER INSTALLATION INSTRUCTIONS

Thanks for purchasing Stainless Works headers for your LS1 F Body. We have gone to great pains to make sure that our headers fit and perform flawlessly. Please follow these steps to ensure that your installation goes as planned. You will need to purchase new header gaskets (We recommend the original GM factory gaskets). We also highly recommend using ACCEL Extreme 9000 spark plug wires which will greatly improve the spark plug boot to header tube clearance.

1. Remove factory manifolds and Y-pipe assembly. Disconnect all air tubes and O2 sensors before removing from car. We also recommend disconnecting the battery and ECM before welding.
2. Install headers by inserting driver side header in from the bottom. On the passenger side, it may be necessary to remove the starter, put the header in place, and reinstall the starter, as well as lift the motor slightly to facilitate slipping the header in place.
3. Install the factory gaskets between header flange and block, and tighten bolts holding flange onto head to factory torque specs starting from the center out.
4. Install O2 sensors with never-seize on the threads-be sure not to touch or get never-seize on the O2 element. You will need to lengthen the harness on the passenger side (Caspers Electronics part #109006 - 12" square extension harness). You may also be able to unloose the existing wires and zip tie them away from the headers. For the rear O2 sensors, you will need to reprogram the factory ECM using LS1 Edit. **HEADERS WHEN USED WITHOUT CATALYTIC CONVERTERS ARE FOR OFF ROAD USE ONLY AND NOT INTENDED FOR STREET USE.**
5. Install Y-pipe using red high temp RTV on all slip joints (you may have to move the factory exhaust as far rear as possible to install the Y-pipe and in some cases it may be necessary to remove the intermediate pipe for sufficient clearance to install the Y-pipe). Tighten supplied band clamps. You may need to weld the Y-pipe to intermediate pipe joint, or you can clamp the joint reusing the factory clamp.