



## **INSTALLATION INSTRUCTIONS FOR 03-08 CROWN VICTORIA HEADERS**

Thanks for purchasing Stainless Works Muscelflow Headers for your 03-08 Crown Victoria. We have gone to great pains to make sure that our exhaust systems fit and sound great. Please follow these steps to ensure that your installation goes as planned.

1. Stainless Works recommends the use of Permatex Hi-Temp RTV silicon gasket maker as an option to or in conjunction with the use of factory gaskets. The recommended RTV is Sensor-Safe P/N 101BR or 27BR, available at NAPA and other retailers.
2. Disconnect the battery before starting work on the exhaust system for your vehicle. Reconnect the battery when the job is completed.
3. Your exhaust system can be installed by a weekend warrior but the use of a lift is recommended for ease of installation. If using a jack, the vehicle must be placed on a level hard surface and jack stands are required for safety reasons.
4. Raise and support the vehicle.
5. Mark and disconnect steering shaft from upper U joint (1) 10mm bolt.
6. Remove (4) 10mm bolts (2 per side) and nuts from both flanges at factory connection point behind cats.
7. Disconnect O2 sensors (2 per side).
8. Remove (4) 10mm nuts (2 per side) from 2 bolt flanges at manifold and remove cat pipes.
9. Remove 6mm nut and 8mm nut holding wires on starter then remove (3) 10 mm bolts and the starter.

10. Remove (16) 10mm nuts (8 per side) from manifolds and EGR fitting from left manifold.
11. Remove (1) 12mm nut from motor mount to frame.
12. Raise motor on the right side using a jack and remove manifolds.
13. Remove (16) 10mm studs (8 per side) from heads.
14. Remove (1) 6 mm bolt from dipstick and remove dipstick.
15. Install headers using sensor safe silicone and 8mm x 1.25 thd. x 25mm long bolts (not provided). Re-install EGR tube to left header.
16. Lower motor and re-install (1) 12 mm nut to motor mount.
17. Re-install dipstick.
18. Re-install steering shaft.
19. Install O2 extensions to O2 front sensors.
20. Install O2 sensors into headers and re-connect wires.
21. Install catalytic converters or cat eliminators using 3" clamps.
22. Install lead pipes using 3" clamps.
23. Re-install rear O2 sensors and re-connect wires.
24. Re-connect exhaust to lead pipes using bolts removed earlier or if going to Stainless Works exhaust system, see catback installation instructions.
25. Be sure to have adequate clearance around all wires, hoses and lines. **If anything is in contact with the exhaust system, it will melt.** Make sure to have at least ½" of clearance and wrap any suspect areas with DEI thermal barrier wrap.
26. After double checking for clearance and making sure all lines, wires and hoses are secured, drive the car for 10-20 miles and re-check all clamps and clearances. Your system may be tack welded at the joints/ clamps to reduce shifting of the system during heating and cooling cycles. Make certain to disconnect the battery before performing any welding.