

2005+ HEMI HEADERS

FOR 2005+ MAGNUM/CHALLENGER/CHARGER/300C INSTALLATION INSTRUCTIONS

Thanks for purchasing Stainless Works Headers for your 5.7L, 6.2L, 6.4L Hemi. We have gone to great pains to make sure that your system has the best in fitment and sound. Please follow these steps to ensure that your installation goes as planned.



Hemi Headers System

1.

Stainless Works recommends the use of Hi-Temp RTV sensor safe silicon gasket maker as an option or in conjunction with the use of factory gaskets. The recommended Oxygen Sensor Safe RTV is either Valco All-in-One Aluminum or Permatex Copper P/N 101BR available at NAPA, Autozone and other retailers.

EXHAUST MANIFOLD REMOVAL

2.

Let car cool completely and allow exhaust to cool completely to the touch before starting any work.

3.

Disconnect battery.

4.

Raise and support vehicle.

5.

Remove (2) 13mm bolts holding left rear tailpipe on and remove from hangers, then remove pipe.

6.

Loosen 2 clamps at the front of the X-pipe and the remaining hangers on system. This may require some force to separate at clamped area.



Detail 1

7.

Remove the (4) 13 mm bolts at tail pipe hangers and remove hangers.

8.

Remove (4) 10 mm bolts holding engine service cover on.

9.

Disconnect and remove all four O2 sensors.

10.

Remove (4) 16mm flange bolts and remove factory lead pipes.

11.

Mark steering shaft so it can be replaced in the same location and remove 10 mm and 12 mm bolts from steering shaft and remove shaft.

12.

Remove (2) 10 mm bolts that hold dipstick tube to valve cover and remove dipstick tube.

13.

Remove all (16) 8mm bolts that hold exhaust manifolds on and remove manifolds and gaskets.

HEADER INSTALLATION

14.

Apply high temp silicone (RTV) to mating surface of headers and install headers using (16) 8mm bolts and tighten to OEM specs.

15.

2. Re-install steering shaft, noting its proper alignment using 10 mm and 12 mm bolts.

16.

3. Re-install dipstick tube using the provided spacer and tighten (2) 10mm bolts.



17.

Install 3" lead pipes using silicone and (2) 3" clamps.

18.

Use two 3" clamps and 6" long, 3" ID x 2.75" OD adapters, slip adapters over lead pipes. Slip 2-3/4" clamps over rear of adapters and slide adapters into factory X-pipe or Stainless Works adapters for the catback. (Use the 2-3/4" adapters and clamps for a 6.1L/ 6.4L vehicle or 2-1/2" adapters and clamps for a 5.7L vehicle).

19.

Adjust and tighten all clamps.

20.

Re-install O2 sensors using supplied extensions, (2) #109209 10" long for Passenger side. (The 2015+ model years also take the same extension on the Driver Side) header (front O2) and (2) #109209 10" long for rear O2 sensors.

21.

Be sure to have adequate clearance around all wires, hoses and lines. **If anything is in contact with the system, it will melt.** Make sure to have at least 1/2" of clearance and wrap any suspect areas with DEI thermal barrier wrap.

22.

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.