



2003-2004 MERCURY MARAUDER HEADER INSTALLATION INSTRUCTIONS

Thanks for purchasing **Stainless Works** Muscle-flow headers for your Mercury Marauder. 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. Disconnect the battery.
2. Raise and support the vehicle.
3. Remove (4) 10 mm bolts at the exhaust factory connection point after the catalytic converters
4. Remove the air intake tube.
5. Unplug and remove the rear O2 sensors from the exhaust.
6. Unplug and remove passenger side front O2 sensor.
7. Remove (4) 10mm nuts - two per side which connect the catalytic converters to the manifolds and remove the converters.
8. Unplug and remove driver side front O2 sensor.
9. Remove the EGR tube from manifold - (you may need to apply heat to remove it).
10. Remove 8 mm bolt and nut from dipstick tube.
11. Remove dipstick tube, you may have to unbolt motor mount from engine block by removing (3) 10mm bolts.
12. Mark and remove 10mm bolt from steering shaft and slide shaft out of way. The mark is necessary to assure that it is reassembled in the same location.
13. Remove (2) 8 mm bolts from left manifold heat shield and remove the shield.
14. Remove (16) 8 mm nuts, 8 per side from both manifolds and remove manifolds.
15. Remove (16) 8 mm manifold studs from engine.

16. Install all (8) 8mm header bolts in lower holes on both sides of the engine. Leave sticking out about ½". These will be used to hang the header on while inserting the top bolts.
17. Apply RTV to header and install from bottom and install remaining (8) 8mm bolts. Tighten passenger side header at this time.
18. Thread the EGR tube onto driver side header then tighten header and EGR tube. Reinstall dipstick tube and if motor mount was unbolted, re-bolt it back to engine.
19. If there is a problem with getting the dipstick tube to properly fit, you may have to purchase a flexible replacement from Lokar P/N ED-5014.
20. Reinstall the steering shaft as marked and the air intake tube.
21. Install front O2 sensors and extensions supplied. You may have to remove small plastic tabs on O2 sensor wire connectors in order to plug extensions in.
22. Install cats or cat eliminators with 3" clamps.
23. Install lead pipes using 3" clamps or 2 ½" clamps. Reinstall rear O2 sensors.
24. Make 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.
25. 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.