



**PART # 68534 & 66534**  
**INSTRUCTION SHEET**  
 1998-02 LS1 5.7L V8 CAMARO - FIREBIRD  
**STEPPED FULL LENGTH HEDDER**  
**FOR OFF ROAD USE ONLY!**

**CAUTION!** This is a custom designed exhaust header system, designed for this particular application (s). Do not bend, bang, cut, dent, drill or heat any portion of this header! Any alteration other than those suggested in this instruction sheet will void the Hedman Lifetime Guarantee!  
 To prevent leaks, install your headers using Hedman Hedders exhaust gaskets ONLY and a spray copper gasket sealant.

**BEFORE STARTING INSTALLATION:**  
 It is necessary to raise the vehicle at least 36 inches from the ground. A floor hoist is recommended, if not available, use a hydraulic floor jack with jack stands. **DO NOT USE A BUMPER JACK!**

- PRE-INSTALLATION:**
1. Disconnect the ground cable from the battery.
  2. Unbolt and remove the factory y-pipe assembly including the catalytic converter and set aside.
  3. Carefully remove the spark plug wires and spark plugs (Number Wires).

**INSTALLATION INSTRUCTIONS:**

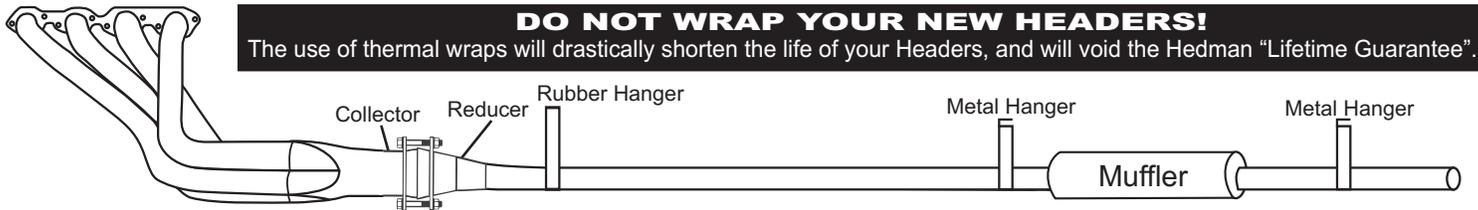
- LEFT SIDE:**
1. Carefully disconnect the O2 sensor wire from the sensor in the manifold if possible, also remove the O2 sensor from the stock exhaust manifold set aside in a clean dry area avoid damaging the sensor. Do not clean sensor with any cleaners.
  2. Unbolt A.I.R. and the left side manifold and remove. (If you can't remove the O2 sensor from manifold in vehicle carefully remove while on bench).
  3. Clean head surface and with gasket in place install the new header from below using anti seize compound on header bolts, Start with the easiest first and tighten evenly replace A.I.R. If you don't have A.I.R. plug with two bolt flat plate in kit.
  4. With header in place replace left side spark plugs.

- RIGHT SIDE:**
1. Remove the A.I.R. from top of stock manifold.
  2. Unplug the coil pack at the main connection. Carefully remove the bolts holding the coil pack to the valve cover. Lift coil pack off and set aside.
  3. Remove the dip stick tube, EGR line, and the spark plugs. Unbolt the stock manifold and remove from below.
  4. Clean head surface and with gasket in place install header from below using anti seize compound on bolts tighten easiest first.
  5. Replace the dip stick tube, the EGR, and A.I.R. line, (if not applicable us block plate in kit).
  6. Install spark plugs, and coil pack back on right valve cover, and replace spark plug wires.
  7. Connect negative battery cable back on battery.
  8. Carefully install the O2 sensors into the header collectors right & left. If the wire will not reach the original plug in location you may use a Bosch part # 13111 that will reach the point the original O2 sensor location.

With the reducers provided weld your modified exhaust system to your Hedman Hedders. Congratulations on the purchase of the most advance computer generated Hedders on the market today.  
 Start engine, test drive vehicle allowing engine to gain normal operating temperature. Check for leaks and new or unusual noises. After test drive is completed, re-tighten header bolts.

**ENJOY YOUR HEADERS WHILE COMBINING INCREASED FUEL ECONOMY WITH BETTER PERFORMANCE.**

**SPECIAL INSTRUCTIONS!**  
 After installing your headers it is very important that your exhaust system be suspended properly. As indicated in the drawing below you must place hangers as close to the header collector as possible. Rubber hangers should be used to allow the front of the system to flex with the engine torque. A hanger is needed before and after the muffler (s). When your exhaust system is unbolted from the header collector, it should remain suspended all by itself. Your Headers Are Not designed to support your exhaust system. Failure to follow these instructions will most likely result in cracks around the area where your primary tubes and collector are welded together, and will nullify your "Lifetime Guarantee".



**WARNING:** Not applicable or intended for street or highway use. Legal only for racing vehicles which may never be used upon a public highway.

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