



# LAKESTER STYLE "BUILD-IT-YOURSELF" HEDDER KIT

## CONSTRUCTION GUIDE

For use with #68850,68860, 68870, 68880, 68910, 68920, 68940, 68950, 68960, 68970, 68980, 68990,78900, 78910, 88900, 88910, 88920, 88930

Thank you for purchasing Hedman Heddors Lakester Style Hedder Kit. Our kits are designed with you, the customizer, in mind. The kit's flexible design allows you to personalize them to fit your vehicle's clearance requirements and your personal design taste. While this kit comes complete with all the components necessary to produce the ultimate set of Lakester style heddors, it does require previous fabrication and welding experience.



**Step 1:** During the fabrication process all components should be tack welded only until heddors are complete. Once you are satisfied with your headers, you can finish weld them. The Megaphones in this kit are longer than typically required. The smaller end may need to be cut down to match the primary tube's diameter, while the larger end of the cone can either be left at the current length, or if you are building a kit with turnouts, cut back to allow the collector ring to be tacked on to the cone.



**Step 2:** With the header flanges bolted to the cylinder head, position the megaphone in the area where you would like the megaphone end flange to exit from your car.

*DESIGN TIP:* With the car sitting on the ground and at ride height, prop the megaphone up in place with something (wood, blocks, etc.) which will hold it in position. From there, the primary tubes can be fit to meet up to the megaphone. Be sure to place the megaphone's welding seam to the bottom or inside of the car so that it isn't seen from the outside. It is best to finish fabrication of one side before moving to the other.



**Step 3:** Starting with the front cylinder on either side of the engine, trim one of the primary tube bends to the desired length on the flange side and megaphone side. SB Chevy & 392 Hemi flanges have oval ports, and require that the tube be slightly elongated. To do this, position the cut primary tube on the head flange at the desired angle, and mark top dead center with a marker. Place that end of the tube in a vise with the line centered between the clamps, and slowly clamp the tube until it becomes slightly oval. Once trimmed and reshaped (if necessary), the primary tube can then be tack welded to the megaphone. The primary tube and megaphone can now be tacked to the head flange.



**Step 4:** Starting with the second cylinder back from the front, determine the desired length and angle of the primary and mark your tube. Always start with a rough cut, then carefully trim away material until the tube fits snugly, and cleanly, in place. Other than the first primary tube, the remaining tubes can be mated to the megaphone in a variety of different ways, depending upon your design preference. With the primary tube in position between the head flange and the megaphone, trace the location where the primary will enter the megaphone using a marker. Once marked, remove the tube and cut a hole into the megaphone. With the hole cut into the megaphone, tack the corresponding header tube in position. Follow the same procedure for the remaining header tubes. If you purchased a basic lakester kit with NO turnouts and downpipe, you are done and can move to step 7 and finish welding the header together, otherwise, please continue to step 5.



**Step 5:** To build turnouts for the end of the megaphone, first tack weld a round collector flange to the large end of the megaphone. The welded seam at this end of the megaphone should be ground slightly to allow the collector ring to fit over the megaphone. Using a couple of collector bolts from the kit, temporarily bolt a second ring flange to the ring flange just tacked to the end of the megaphone. For the turnout, mark, then cut, a 90° bend included with your kit to your desired length and angle. Position this turnout inside the ring flange at the desired angle and tack weld it to the ring that was just bolted on. Unbolt the ring flange and turnout, and set aside until you are ready to finish weld your headers. If you are going to use an exhaust system with your Lakester headers, you will need to use one of the supplied block-off plate at this location.



**Step 6:** If you intend on bolting your headers to an exhaust system, you must now construct the downpipe. To do this, fit the short piece of 2 1/2" tubing supplied in the kit onto the megaphone in a position that mates up with your exhaust system. Once notched and its proper location is determined, mark the location on the megaphone and cut a hole to allow exhaust to flow from the megaphone into the downpipe and exhaust. Next, weld one of the 2-bolt flanges onto the opposite end of the 2 1/2" tube. A matching 2-bolt flange (included) will need to be welded to your exhaust system so the headers and exhaust can be connected.



**Step 7:** If you are satisfied with the look of your lakesters, you can now go back and finish weld your headers.

To ensure a proper seal, and to prevent exhaust leaks, install your newly built heddgers using the Hedman Heddgers gaskets included with this kit only, and a copper gasket sealant spray.

#### A NOTE REGARDING HEDDGER COATINGS

Depending on the final look your are trying to achieve, you may decide to have your Hot Rodz coated using one of the many hi-temp coatings available. Unless you are installing your Hot Rodz on a rat rod, and you want to achieve a distressed look, coating is recommended to protect your heddgers against corrosion. If you coat your heddgers using a silver or chrome colored coating, it is recommended that the newly coated heddgers not be run on a new engine, before the engine has been broken-in. The excessively high exhaust temperatures of a new engine during break-in will damage the coating. We suggest that cast iron manifolds or an old, unused set of heddgers be installed during break-in, and closely adhere to the coating manufacturer's instructions.

## DESIGN IDEAS

Below are a few photos that demonstrate some of the different looks you can achieve with a Hedman Heddgers Hot Rodz Lakester Kit.

