



**PART # 61618, 66611, 66617
68611, 68617, 68687**

**INSTRUCTION SHEET
396-502 ENGINES**

CAUTION

SAFELY RAISE THE VEHICLE AT LEAST 36 INCHES FROM THE GROUND AND SOLIDLY SUPPORT THE VEHICLE USING JACK STANDS. NEVER WORK BENEATH A VEHICLE THAT IS NOT PROPERLY SUPPORTED BY JACK STANDS WITH SUFFICIENT LOAD CAPACITY, DO NOT USE A BUMPER JACK!

CAUTION

BEFORE STARTING INSTALLATION:

- ▶ Install headers using the Hedman Hedders gaskets included in this kit. For additional protection against leaks, we suggest the application of a quality copper gasket spray adhesive (not included).
- ▶ These exhaust headers are designed to fit a variety of Small Block Chevy applications. 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!

INSTALLATION INSTRUCTIONS:

1. Disconnect the battery, water temperature sending unit, oil dipstick tube, spark plugs (*number wires*), factory manifolds, and stock head pipes.
2. Remove air cleaner assembly, clutch cross shaft and ball sockets, oil filter and oil pressure sending unit.

LEFT SIDE:

3. With gasket in place, install the left side header from below. Start all bolts. **DO NOT TIGHTEN!**
4. Re-route brake lines, hoses, etc., making sure that there is adequate clearance. Tighten all header bolts evenly, from the center out.

RIGHT SIDE:

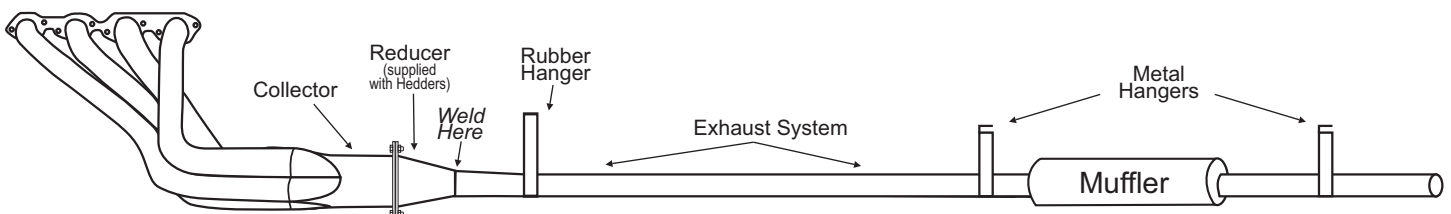
5. With gasket in place, install the right side header from below. Start all header bolts, then tighten all bolts evenly, from the center out.
6. With Hedders reducers (*supplied with hedders*) bolted to the hedders, cut the factory (or aftermarket) exhaust pipes to length, so that the system's pipes can be welded to the reducers, creating a secure connection to the hedders. Weld the reducers to the exhaust system around the entire circumference to ensure a secure, leak-proof seal.
7. Replace and/or reconnect all electrical, fluid and emissions components that were previously removed or disconnected. Check for proper clearance from all components, including but not limited to, brake lines, fuel lines, hoses, cables, linkage, etc.
8. Affix provided E.O. Sticker to the underside of the hood, or other location visible to the emissions technician.
9. Start engine. Test drive the vehicle allowing engine to gain normal operating temperature. Check for leaks and new or unusual noises. After the test drive is completed, re-torque header bolts and all other fasteners related to your Hedders installation.

DO NOT WRAP YOUR NEW HEADERS!

The use of thermal wraps will dramatically shorten the life of your Hedders, and will void the Hedman Limited Lifetime Guarantee.

SPECIAL INSTRUCTIONS REGARDING THE VEHICLE'S EXHAUST SYSTEM!

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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