



## INSTRUCTION SHEET 69200, 69203, 69206

### ENGINE SWAP HEADERS for Installing an LS ENGINE INTO 1988-98 CHEVY/GMC 1/2 TON TRUCKS & SUVs

#### BEFORE STARTING INSTALLATION:

- Read This Instruction Guide In Its Entirety Before Beginning Installation.
- If you are installing HTC, Elite or Black-Maxx ceramic coated headers, please read the accompanying pamphlet regarding engine break-in with coated headers before proceeding with ceramic-coated header installation.
- When installing with a 4L80 transmission, modification to the bellhousing ears will be required.
- It is necessary to raise the vehicle at least 15 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!**

**CAUTION!** This is a custom designed exhaust header for the applications listed above. Do not bend, bang, cut, dent, drill or heat any portion of this header! Any alteration other than those noted in this instruction sheet will void the Hedman Lifetime Guarantee! To prevent leaks, install your headers using Hedman Hedders exhaust gaskets ONLY, coated with a quality copper gasket sealant spray.

#### INSTALLATION INSTRUCTIONS:

1. If connected, disconnect the battery and any wiring that may interfere with installation.
2. Remove all spark plugs wires from the spark plugs. To provide additional clearance, spark plugs may also be removed.
3. If installed, remove stock manifolds or headers. Thoroughly clean the exhaust flange on the heads of any debris.
4. Remove engine oil dipstick and tube.
5. Raise the front of the vehicle and support it with jackstands.
6. Prepare gaskets by applying copper gasket spray. Follow the product manufacturer's directions for use.

#### DRIVER SIDE:

7. Position the driver side header on the head and insert the front and rear header bolts only (*just a few threads*). You may need to insert the header in from below. In extreme cases, the motor mount connecting bolt may need to be removed and the engine raised.
8. Pull the header flange away from the head and hang a header gasket between the head and header flange using the two bolt "hooks" built into the end of the Hedman gaskets.
9. If previously raised, lower the engine back down, then reinstall and tighten the engine mount connector bolt to specification.
10. Install the remaining driver side header bolts and tighten all bolts, working from the inner to outermost bolts.

#### PASSENGER SIDE:

11. Drop the passenger side header into position from the top, and loosely insert the front and rear header bolts only (*just a few threads*). Pull the header flange away from the head, and hang a header gasket between the head and header flange using the two bolt hooks built into the header gaskets.
12. Install the remaining passenger side header bolts. Tighten all bolts, working from the inner to outermost bolts.
13. Bolt the header reducers included with these headers to the ball collectors on the headers. These reducers (collector adapters) will need to be welded to your vehicle's exhaust system.
14. Once the exhaust system is complete, tighten all collector and exhaust bolts. Reinstall and tighten all parts previously removed or disconnected, then reconnect the battery. Closely inspect headers and system to ensure there is proper clearance for all fuel lines, brake lines, wiring, steering components and shift linkage.
15. Start engine and allow it to reach normal operating temperature. Check for leaks. If you are installing 69200 uncoated headers without first removing the temporary protective black paint, the coating will begin to smoke when the engine heats up. The coating is non-flammable and the smoke will stop after a few minutes, once the coating burns off. Test drive vehicle and listen for any new or unusual noises. After test drive allow engine to cool then re-torque all header bolts.

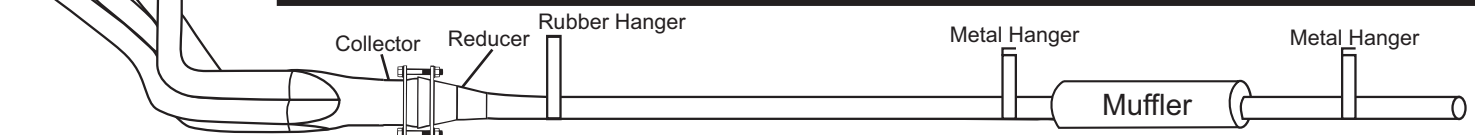
**IMPORTANT:** Refer to your local state or county emission laws regarding engine swaps before performing this installation.

#### DO NOT WRAP YOUR NEW HEADERS!

The use of thermal wraps will drastically shorten the life of your Headers, and will void the Hedman "Lifetime Guarantee".

#### PROPER SUSPENSION OF YOUR ENTIRE EXHAUST SYSTEM IS EXTREMELY IMPORTANT!

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".



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