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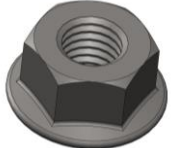
**Up Pipe Kit for Ford 6.4L**  
***Ford Powerstroke 2008-10 Models***






**P/N# 1041481**

**PLEASE READ ALL INSTRUCTIONS BEFORE INSTALLATION**

# **KIT CONTENTS:**

Please check to make sure that you have all the parts listed in this kit **before** you start the disassembly of your truck.

<b>1403116</b>		<b>1300131</b>		<b>1403115</b>	
					
<i>Up Pipe Passenger Side</i>		<i>Tie Wrap (Medium)</i>		<i>Up Pipe Driver Side</i>	
<b>Qty: 1</b>		<b>Qty: 2</b>		<b>Qty: 1</b>	
<b>MS19312</b>				<b>B32256</b>	
					
<i>Gasket Exhaust Manifold</i>				<i>Gasket (Turbo-Up pipe)</i>	
<b>Qty: 1</b>				<b>Qty: 2</b>	
<b>1130020</b>	<b>1403119</b>		<b>1403118</b>		
					
<i>1/4" NPT Plug</i>	<i>Hex Manifold Spacer Short</i>		<i>Hex Manifold Spacer Long</i>		
<b>Qty: 1</b>	<b>Qty: 16</b>		<b>Qty: 3</b>		
<b>1900013</b>		<b>FT-11116340</b>		<b>1900015</b>	<b>1900014</b>
					
<i>Flange bolt 60 mm Long</i>		<i>Flange bolt 25mm</i>		<i>Flange bolt 30mm</i>	<i>Flange nut</i>
<b>Qty: 4</b>		<b>Qty: 6</b>		<b>Qty: 1</b>	<b>Qty: 4</b>

<b>1403121</b>		<b>1403120</b>	
			
<i>A/C Tube</i>		<i>A/C Seal Kit</i>	
<b>Qty: 1</b>		<b>Qty: 1</b>	
<b>1401480-1</b>	<b>1401480-2</b>		<b>1200208</b>
			
<i>Passenger side manifold</i>	<i>Driver side manifold</i>		<i>1/8" NPT Brass Plug</i>
<b>Qty: 1</b>	<b>Qty: 1</b>		<b>Qty: 1</b>

**Required Tools**

- 10/12/13/15/16mm socket & Wrench
- 7/16" / 9/16" deep socket
- Pry Bar
- Scraper
- Torque Wrench
- Side Cutter

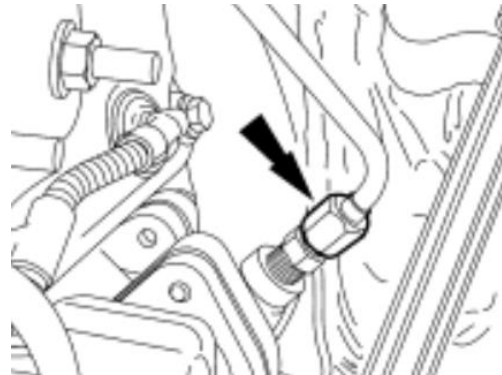
**Removal**

**VEHICLE SHOULD BE SAFELY SECURED BEFORE INSTALLATION.**

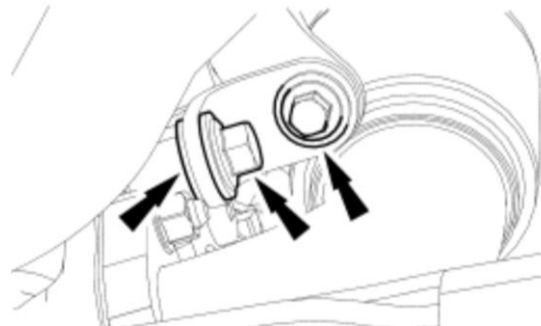
1. With the vehicle in NEUTRAL, position it on a hoist.

**LH Inlet Pipe Removal**

2. Disconnect the exhaust pressure (EP) sensor tube fitting.



3. Remove the EGR-oxidation catalytic converter (OC) pipe bracket-to-cylinder head bracket bolt and washer. Remove the EGR-OC pipe bracket-to-LH cylinder head bolt, washer and the bracket.



4. Remove the RH turbocharger inlet pipe-to-EGR-OC pipe bolts and the EGR-OC-to-turbocharger bracket bolts.



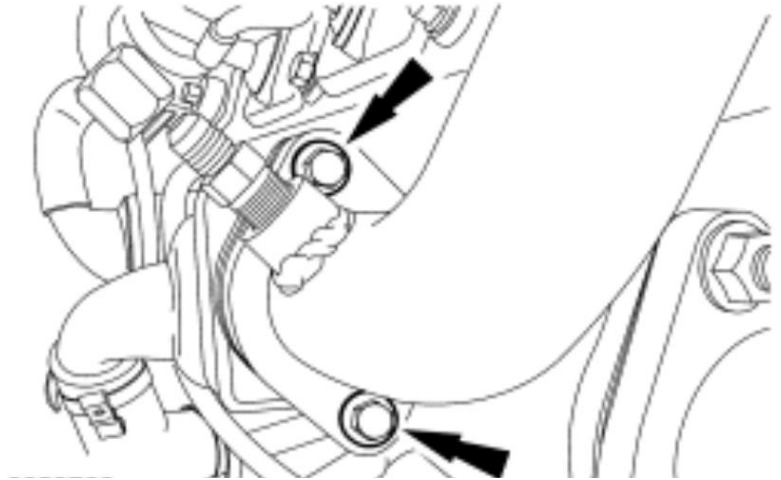
BD Engine Brake Inc.

Plant Address: 33541 MacLure Rd. Abbotsford, BC, Canada V2S 7W2

U.S. Shipping Address: 88-446 Harrison St, Sumas, WA 98295 U.S. Mailing Address: P.O. Box 231, Sumas, WA 98295

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5. Remove the EGR-OC-to-EGR cooler bolts and position the EGR-OC pipe to the left side of the vehicle and aside.



6. Remove the LH turbocharger inlet pipe-to-turbocharger bolts and remove the EGR-OC bracket.



7. Remove the LH turbocharger inlet pipe-to-turbocharger bolts and remove the EGR-OC bracket.

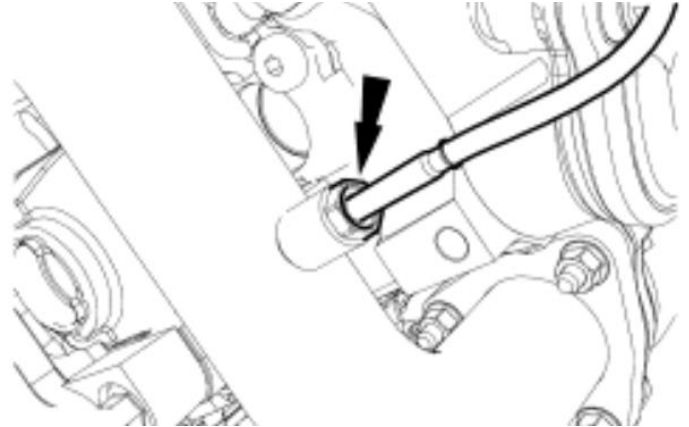
NOTE: On vehicles that have had previous service to the LH turbocharger inlet pipe, a service bolt will be in place of the upper exhaust manifold nut and stud.

8. Remove the LH turbocharger inlet pipe-to-exhaust manifold nuts and, if equipped, service bolt.

9. Remove the LH turbocharger inlet pipe from the vehicle.

### ***RH Inlet Pipe Removal***

1. Remove exhaust gas temperature (EGT) sensor from the RH turbocharger inlet pipe and position aside.
2. Remove the RH turbocharger inlet pipe-to-exhaust manifold nuts.
3. Remove the RH turbocharger inlet pipe-to-turbocharger bolts.



4. Remove the RH turbocharger inlet pipe from the vehicle. Discard the gaskets.

### ***Exhaust Manifold Removal***

1. Disconnect the alternator plug & battery cable. Remove the serpentine belt off the alternator and remove the alternator (x3) 15mm bolts.



2. Remove a/c discharge tube from compressor by removing nut. (13mm socket). Cut zip ties to free heat shielding.

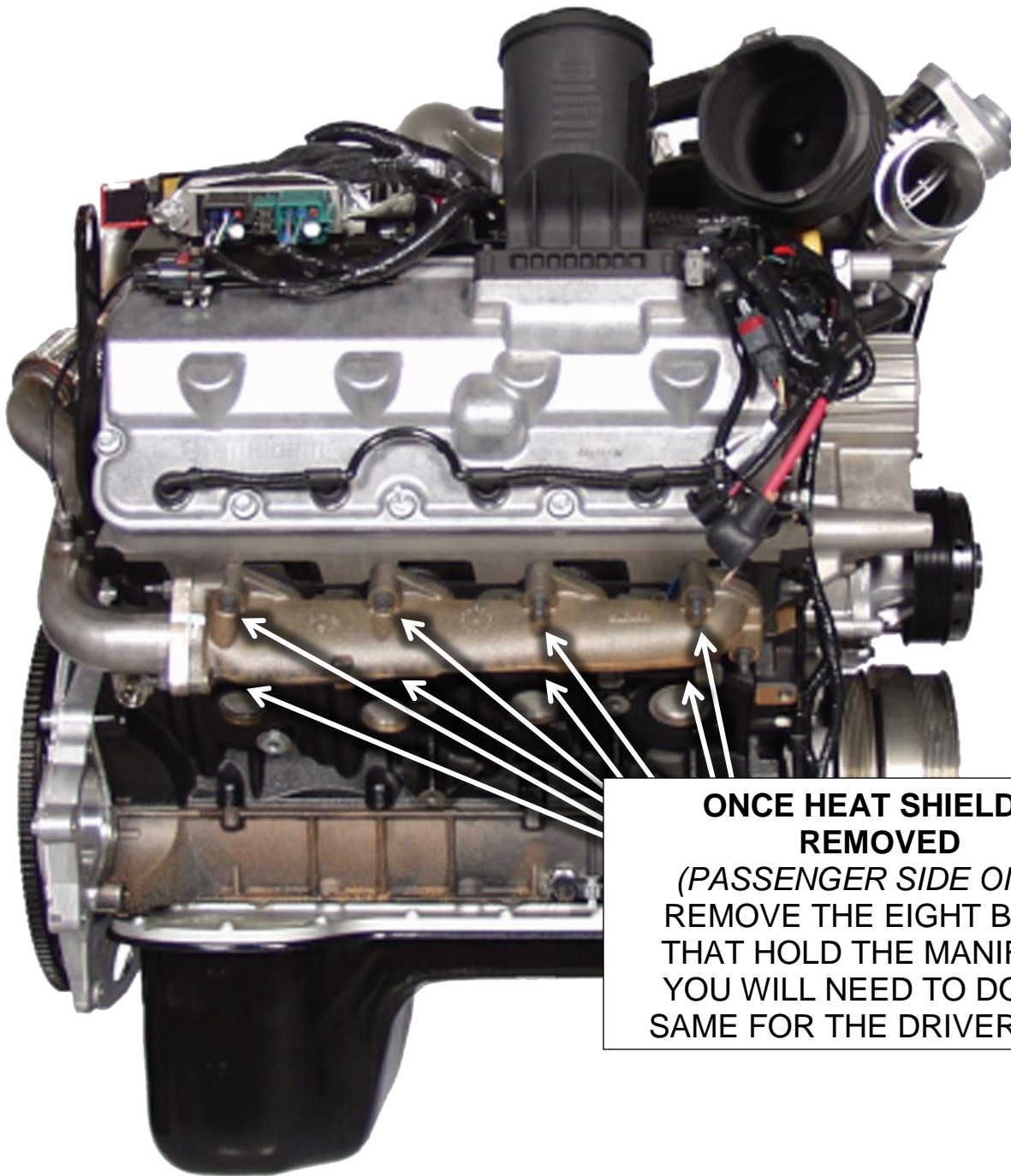


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**ONCE HEAT SHIELD IS REMOVED (PASSENGER SIDE ONLY). REMOVE THE EIGHT BOLTS THAT HOLD THE MANIFOLD. YOU WILL NEED TO DO THE SAME FOR THE DRIVER SIDE.**

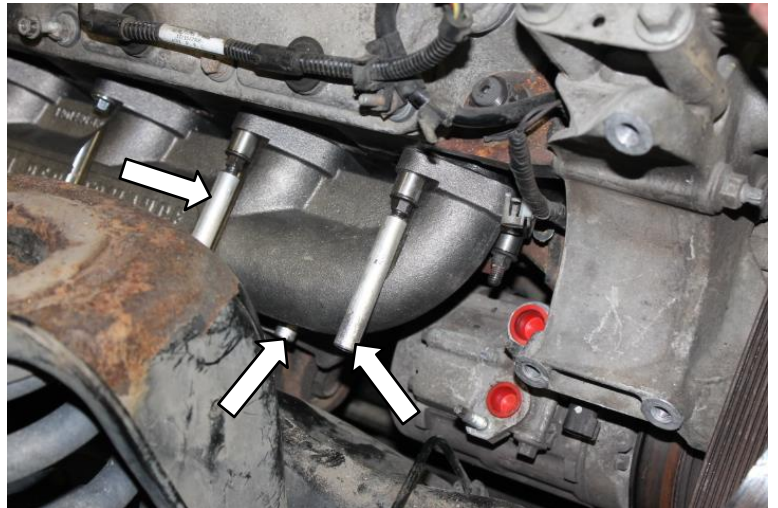
## Installation

- 1) Install BD exhaust manifolds (1401480-2) driver side and (1401480-1) passenger side using OE hardware and (1403119) spacers (M10 socket). Torque to 18 ft/lbs.



### Passenger side only

- 2) Install the provided threaded heat shield spacers (1403118) onto 2 upper forward exhaust manifold bolts and 1 lower 2<sup>nd</sup> from the front (M10 socket). Torque to 18 ft/lbs.



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- 3) Trim and modify OE heat shield to resemble picture and install using OE hardware (M10 Socket). Torque to 18 ft/lbs. Modification is to add clearance for a/c adapter.



- 4) Install the a/c tube (1403121) with new seal & o-ring (1403120) onto the compressor port and receiver dryer with OE nut (M13 socket). Torque to 11 ft/lbs. Install OE a/c discharge tube to adapter using M8 bolt (1900015) (M10 socket). Torque to 11 ft/lbs. Slide heat shield down over adapter fitting to compressor and secure either end with zip ties (1300131).

***NOTE: Do not attempt to bend the BD supplied extension.***

- 5) Install 1/4" NPT plug (1130020) (9/16" socket) into front port of driver side exhaust manifold. If not installing a thermocouple the 1/8" NPT plug (1200208) can be installed into the rear port (7/16" socket).

**NOTE:** The dipstick tube may need to be reformed for clearance around the manifold.



- 6) Clean up feed port mating surface on turbo assembly. Install driver side up pipe (1403115) with new gasket (8C3Z-6N640-A) and 3 M8 bolts (FT-11116340) (M10 socket) at turbo then 2 M8 bolts (1900013) and nuts (1900014) (M10 and M13 sockets) at manifold. Torque to 18 ft/lbs. **Repeat for passenger side.**



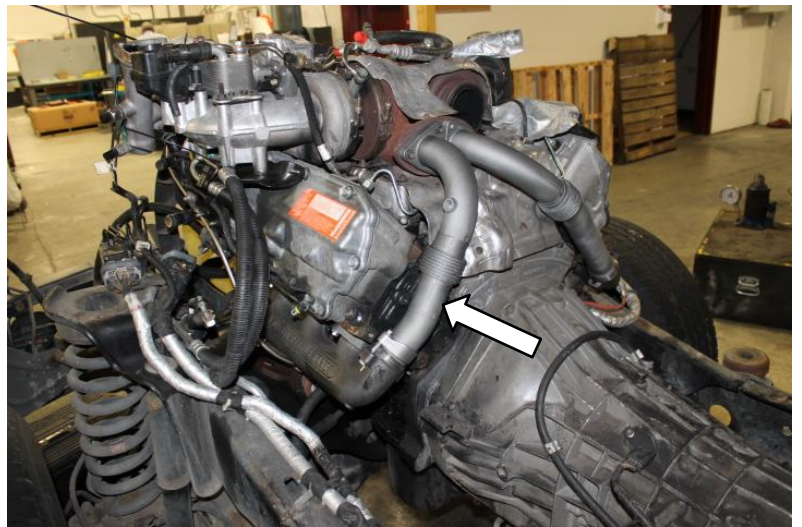
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- 7) At this point please remove the Exhaust Back Pressure (EBP) sensor, tube and fitting from the OE driver side manifold. Install the fitting into the driver side feed pipe port (9/16" socket). Now connect EBP tube and adjust position to line up with original mounting bracket. Mount with OE M6 nut (M10 socket). Torque nut to 80 in/lbs and tube to 180 in/lbs. Now connect sensor plug.



- 8) Remove the OE thermocouple from the OE passenger side up pipe and install it in the BD passenger side up pipe (13mm wrench).  
Torque to 28 ft/lbs.



- 9) Refer to the removal procedure in reverse for installation.

If you have any technical difficulties, concerns, comments, or complaints, please phone our Technical Support hotline at (800) 887-5030 between 8:30am-5:00pm PST (Pacific Standard Time) Monday to Friday.