

PATRIOT

EXHAUST PRODUCTS

A PerTronix Performance Brand ~ www.pertronixbrands.com ~ 909 599-5955

Installation Instructions & Warranty Information

H8048 ~ 1969-91 Chevrolet Blazer, Suburban, Yukon & 1 Ton Crew Cab
(2WD) 1969-87 Chevrolet 1/2, 3/4. And 1 Ton Pickup (2WD)
265-400 Small Block Engines
Long Tube Headers



3

PERTRONIX PERFORMANCE BRANDS EMISSIONS CODES

This Product is **LEGAL** for Closed Course Competition use or Pre-Emissions Controlled Vehicles **ONLY**. It is Not Legal for use on any Emissions Controlled Vehicle for Street or Off Highway use.

REV 3/2022

⚠ WARNING:

This product can expose you to chemicals including Lead, Nickel, Cadmium and Chromium which are known to the State of California to cause cancer and birth defects or other reproductive harm. For more information go to www.P65Warnings.ca.gov

REV. 6 5-16-22 DSL

PLEASE READ BEFORE PROCEEDING

PerTronix® thanks you for choosing a Patriot Exhaust Product. To realize the potential of Patriot's engineering and excellent fit, Please Read and Understand these instructions completely prior to starting the installation.

Check that you received all the parts listed on the parts list, if you have any concerns, please contact PerTronix before continuing. Headers will have the part number stamped in the flange.

Work Smart – Work Safe! Most Header and Exhaust Installation are best performed on a lift. If a lift is not available, raise the vehicle and support on quality Jack Stands on level ground. Do not rely on a jack!

Many factors affect the installation of exhaust headers, including worn or aftermarket motor mounts, previous accident damage, aftermarket cylinder heads that may have relocated port or spark plug locations, suspension and steering changes, sagging of original unibody structures due to age.

Coating Notes: Coatings can be marred during installation if you are not careful. If you are breaking in a new motor, the extreme heat can alter the appearance of the coating and this is not a warranty issue. We recommend breaking in new motors with stock manifolds or an old set of headers.

We use sealing beads on all our headers. The raised bead creates a better seal virtually eliminating leaks if installed properly. It is important to install all header bolts lightly snug and then tighten to factory torque specs starting in the center and working outward.

Before starting, allow the vehicle to cool, disconnect the battery, and spray a penetrating oil on all hardware and fittings that will need to be removed. Once you remove your manifold, clean the sealing surface on the head of any old gasket debris or carbon build up.

DISASSEMBLY

1. Remove bolts attaching head pipes stock manifolds and move the stock headpipes out of the way for header installation.
2. Remove the Oil Dipstick Tube, Starter, Clutch linkage (on std trans cars), Oil Filter, and Oil Filter Adapter.
3. Remove the Spark Plugs Wires and spark Plugs.
4. If the A/C Compressor, or Alternator are mounted to the manifolds, remove these items.
5. Remove the stock Exhaust manifolds.
6. Remove any remaining gasket or carbon deposits from the head surface. The use of a gasket scraper and or a gasket removal product may help.

INSTALLATION

1. Starting on the Driver's side, slip the header roughly into position from the bottom.
2. Using the supplied Header bolts, slip the gasket in place and start all of the header bolts, and tighten them evenly.
3. Replace the Oil Filter, the Oil Dipstick Tube, and Clutch Linkage
4. NOTE: 1967 Models, Modify the clutch linkage as shown in Illustration A.
Some models may need to modify the shift linkage per Illustration B.
Models with Alternator on the Driver's side may need to purchase Alt Bracket #H7606 and possibly #H7607.
Models with Power Steering Bracket on Driver's side may need to fabricate spacer as shown in Illustration C.
Models with A/C Compressor on Driver's side may need to purchase bracket part # H7608, see Illustration D.
5. Slip the Passenger side header into position from the bottom.
6. Using the supplied Header bolts, slip the gasket in place and start all header bolts, leaving them loose for access to the starter.
7. Slip the starter back in to place with the header loose, and tighten the starter bolts. Carefully reroute the wires to the starter ensuring that they are away from the header. Then tighten all header bolts evenly starting from the center.
8. Check transmission cooler lines and move away from header as necessary.
9. Re install spark plugs and wires, making sure the wires are clear of the header tubes.
10. If reusing the existing exhaust system cut and modify as necessary to connect to the headers using Patriot Reducers (sold separately)
11. Connect the negative battery cable.

IMPORTANT CHECK LIST

- Be sure that all brake lines, transmission lines, and fuel lines are clear of headers and/or connector pipes.
- All spark plug wires, battery cables, or other electrical components should be clear of headers and/or connector pipes.
- If dipstick tube was removed, make sure it is installed properly and that the dipstick has been replaced.
- Double-check the tightness of all bolts including brackets and accessories.

START THE ENGINE

Start the engine and allow it to warm up to operating temperature. Check for any unusual noises or exhaust leaks. If everything is OK, stop the engine and tighten all bolts while the engine is still warm. **NOTE:** Check the bolts periodically to make sure they have not loosened. Re-tighten after the first 500 miles and then again at 1000 miles

Parts List

1 Left side header	1	Right side header
2 Header gaskets	12	3/8-16X3/4", Header Bolts
6 3/8-16 x1" Collector Hex head bolts	6	3/8-16 Hex Nuts
6 3/8" Lock washers	2	Collector gaskets

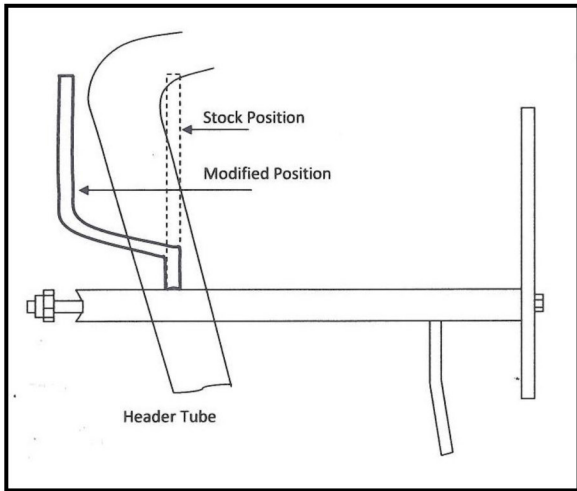


Illustration A

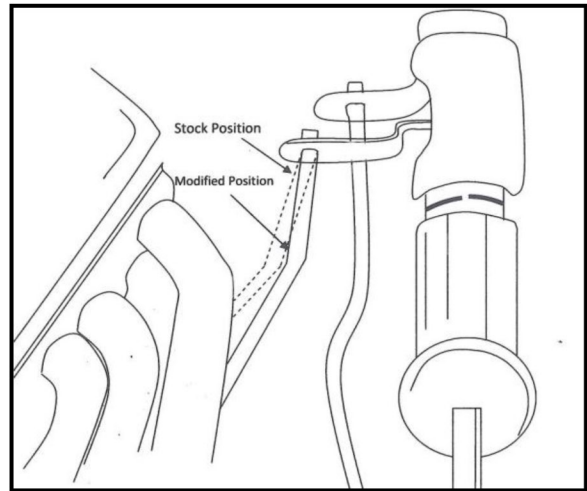


Illustration B

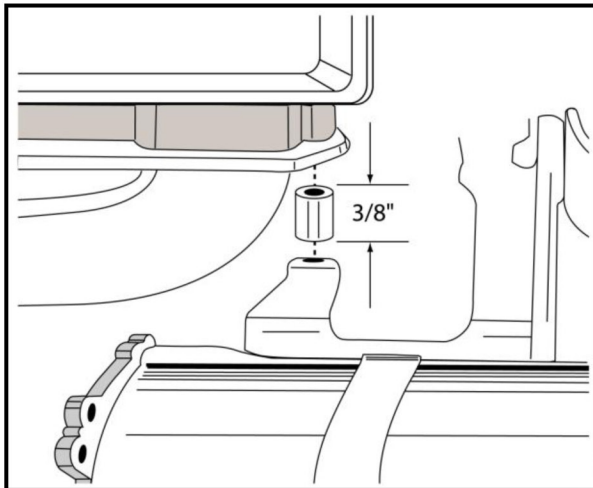


Illustration C

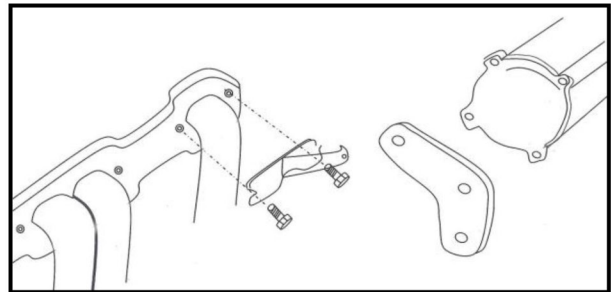


Illustration D

PATRIOT EXHAUST LIMITED WARRANTY

All Patriot Headers and Exhaust products are guaranteed, to the original purchaser, to be free of defects in material and workmanship for one year from date of purchase. This warranty covers the replacement or repair of the product and does not cover the cost of removal and installation, customer applied coatings, or Any discoloration or corrosion of finished surfaces.

Damage or product failure resulting from collision, improper installation, off road use, road hazards, the use of exhaust insulating wrap, or rust occurring after installation is not covered by the warranty. This warranty extends only to the original purchaser.

Should a part be deemed defective, it should be returned to the original selling retailer and must be accompanied by the sales receipt. If there is no retailer in your area, contact PerTronix direct for a return authorization and return the part prepaid to the factory for inspection. PerTronix reserves the right to replace or repair the alleged defective part and return the part freight collect.