

Pro R Head Pipe Instructions

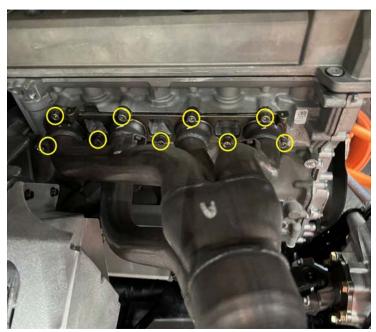
- **Tighten 2nd O2 Bung Bolt on RPM Head Pipe if not utilizing.
- 1. Remove the manifold heat shield by removing the 4 10mm bolts that hold it in place.
- 2. Remove the 2 spring loaded header pipe to muffler bolts.



3. Unplug the O2 sensor from the harness and remove it from the exhaust pipe. .



- 4. Remove the 9 6mm allen headed manifold bolts.
- *A 6mm wobbler is best for the tight spots.



- 5. Leave the top center two bolts in for last, but extremely loose.
- 6. Once completely loose, remove the remaining two bolts holding the manifold up.
- 7. If replacing the manifold gasket, scrape the cylinder head surface clean of any residual gasket material.
- 8. The new manifold will come with 9 new Grade 8 manifold bolts and loctite.
- 9. Loctite the 9 bolts, and place one inside the manifold flange and hang the gasket from it.
- 10. Attach muffler gasket.
- 11. Loosely attach the manifold to the cylinder head and then begin loosely installing all 8 remaining manifold bolts.
- 12. Once all 9 are installed you may start tightening and eventually torquing them to the factory 20ft-lb.
 - (All bolts must me tightened to this spec otherwise gasket loss and header warp may occur)
- 13. Attach the 2 spring loaded muffler side bolts.

- 14. Reinstall the O2 sensor and plug it back into the factory harness.
- 15. If using a 2nd O2 Sensor install this now. <u>Tighten the O2 sensor or O2 plug if not using a 2nd sensor to prevent loss.</u>
- 16. Apply loctite to the 4 exhaust shield bolts and reinstall the shield.



16. Wipe the entire header pipe clean of and oils from handling the pipe in order to prevent stains once heated up.