



SWS PART # 440-0091, 440-0093, & 440-0094

Fits all models with standard and automatic transmissions, power brakes, power steering, and air conditioning.

NOTE: Will fit GM angle plug heads.

NOTE: Modification to stock exhaust required to retain stock catalytic converter.

NOTE: The transmission safety lock may have to be altered or removed on some models.

READ THESE INSTRUCTIONS CAREFULLY BEFORE STARTING:

For the ease of installation, your vehicle must be raised a minimum of 36". Warning: Should you decide to install any exhaust product yourself, be warned that the original equipment jack that came with the vehicle is intended for emergency use only. The use of a frame jack, in conjunction with a floor jack, as the main support is highly recommended to minimize the accidental dropping of a vehicle while the installation proceeds. Never go under a vehicle that is supported by only a bumper jack!

A. PREPARE THE VEHICLE FOR INSTALLATION:

1. Disconnect the negative cable of the battery.
2. Remove the air cleaner and hoses.
3. For trucks with A.I.R., disconnect the A.I.R. tubes at the exhaust manifold.
4. Remove the spark plugs and spark plug shields.
5. For trucks with the driver's side oxygen sensor, unclip the oxygen sensor from the wiring harness and remove it from the exhaust manifold.
6. Remove the dipstick and dipstick tube, if necessary.
7. Remove the exhaust manifolds and exhaust pipes.
8. Remove the A.I.R. valve.

B. CHECK THE CONDITION OF THE ENGINE MOUNTS:

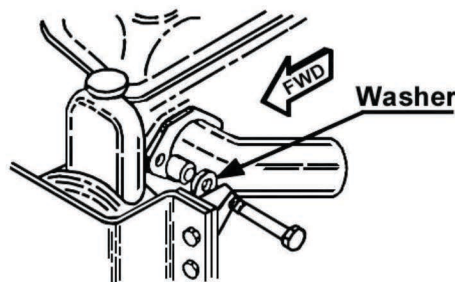
INSTALLATION NOTE: It is recommended that new engine mounts be installed before installing the headers.

C. PREPARE THE HEADERS FOR INSTALLATION:

1. For trucks with air injection, drill 1/2" diameter holes through the air injection fittings into the header pipes.
2. For trucks with an oxygen sensor, drill 9/16" diameter holes through the fitting in the header collector. Install the oxygen sensor into the header and tighten.

C. LEFT SIDE HEADER INSTALLATION FROM ABOVE (DRIVER'S SIDE):

1. Hold the header and gasket in position and install the front and rear header bolts. DO NOT tighten at this time.
2. Install the balance of the header bolts. DO NOT tighten at this time.
3. If equipped with power steering, use one of the original manifold bolts and cut a piece of spacer material to the exact size and install as shown below.
4. Tighten the header bolts from the center outward like a cylinder head to maximize the flange gasket seal.
5. Connect the air injection tube to the header.
6. Plug the oxygen sensor back into the wiring harness.



D. RIGHT SIDE HEADER INSTALLATION FROM ABOVE (PASSENGER'S SIDE):

1. Hold the header and gasket in position and install the front and rear header bolts. DO NOT tighten at this time.
2. Tighten the header bolts from the center outward like a cylinder head to maximize the flange gasket seal.
3. Reinstall the A.I.R. valve and connect the air injection tube to the header.
4. Reinstall the spark plugs, wires, shields, dipstick, and dipstick tube.
5. Reinstall the air cleaner and hoses.
6. Reconnect the battery cable.

E. AFTER HEADERS ARE IN PLACE:

1. Before connecting the headers to the exhaust pipes, inspect all points with limited clearance. Relocate any points that have direct contact with the header. All engines are not mounted exactly the same at the factory, and it is sometimes necessary to loosen the motor mounts and move the engine slightly to one side or the other for maximum clearance. **If the motor mounts are worn or broken, they should be replaced.**

F. CONNECT THE EXHAUST SYSTEM:

1. Bolt the reducer adapters and gaskets to the collectors.
2. Attach the exhaust system by either welding or clamping the exhaust pipes to the reducer adapters.
3. Start the engine and let it idle until it reaches normal operating temperature and tighten all header bolts again. Periodically check the tightness of all header bolts.