



**PART # 69680 & 69686**  
 GM TRUCK 1999-04 4.8, 5.3 & 6.0L V8 w/ EGR ONLY  
**PART # 69681 & 66681**  
 GM TRUCK 1999-04 4.8, 5.3 & 6.0L V8 w/ EGR & AIR  
**INSTRUCTION SHEET**

**CAUTION!** This is a custom designed exhaust header system, designed for this particular application (s). Do not bend, bang, cut, dent, drill or heat any portion of this header! Any alteration other than those suggested in this instruction sheet will void the Hedman Lifetime Guarantee!  
 To prevent leaks, install your headers using Hedman Heddars exhaust gaskets ONLY and a spray copper gasket sealant.

**BEFORE STARTING INSTALLATION:**

It is necessary to raise the vehicle at least 36 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!**

**INSTALLATION INSTRUCTIONS:**

**DISASSEMBLY**

1. Disconnect the negative cable from battery to prevent damage to the electrical system.

**DRIVER'S SIDE**

1. Carefully remove the spark plug wires by the boot (not the wire.) It is a good idea to number the wires to prevent wires from being incorrectly reinstalled.
2. Pre-treat the exhaust manifold bolts, fittings etc. with a penetrating oil to make removal easier.
3. On air pump equipped models, remove the air tube from the driver's side manifold and the rubber hose at the rear of the engine.
4. Remove the thru-bolt from the steering shaft and separate the steering shaft.
5. Disconnect the stock manifold from the stock exhaust system.
6. Unbolt the driver's side manifold from the head and remove from engine compartment (six bolts).
7. Clean the mating surface on the head of all carbon deposits and gasket material. Use a wire brush or similar method. Be careful not to gouge or nick the head.
8. Prepare the new header bolts supplied in this kit using an anti-seize compound.
9. Bolt the new Hedman Driver's side hedder to the head using the header bolts with anti-sieze compound, new header gasket and lockwashers (all items supplied in this kit.) Tighten bolts in an alternating pattern starting from the center of the flange.
11. Fasten the new driver's side header to the stock exhaust system.

12. Reconnect the steering shaft and reinstall the air tube (if equipped) using the gasket and fasteners supplied in the kit.
13. Replace the spark plug wires.

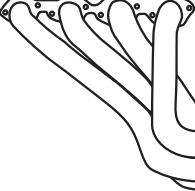
**PASSENGER'S SIDE**

1. Remove the air tube (on equipped models), then mark and remove the spark plug wires.
2. Disconnect the EGR tube from the manifold
3. Remove the bolt fastening the oil dipstick tube bracket to the head and remove the dipstick and the tube.
4. Unbolt the passenger's side manifold from the head and remove from engine compartment (six bolts).
5. Repeat steps 7, 8 and 9 to install the driver's side header.
6. Reconnect the EGR tube using the supplied gasket and fasteners.
7. Reposition the oil dipstick tube and fasten it to the head. Replace the dipstick.
8. Replace the air tube (if equipped and reattach the spark plug wires).
9. Connect the factory exhaust system to your new headers using the fasteners supplied in the kit. Apply a small amount of hi-temp silicone sealant to the passenger side collector dome.
10. Connect the battery, start the engine and listen for leaks or new noises.
11. Take the vehicle for a rest drive. Allow the engine to reach normal temperature. Turn engine off and allow the engine and heddars to cool. Re-tighten all header bolts.

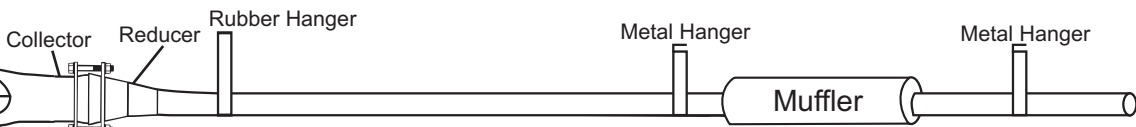
**SPECIAL INSTRUCTIONS!**

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".

**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".



Gaskets installed upside-down partially block exhaust ports causing leaks and void the warranty. A properly positioned gasket aligns perfectly with the port on the header.



**WARNING:** Removal of catalytic converters and other factory air pollution control devices is illegal. We recommend you adhere to your state's local laws. Our testing indicates performance is not significantly affected by these devices.