



## PART # 89130, 89136 INSTRUCTION SHEET

### ENGINE SWAP HEDDERS for 1954-72 FORD F100 with 352-427 FE

#### **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".

**DO NOT USE A BUMPER JACK!** SAFELY RAISE THE VEHICLE AT LEAST 36 INCHES FROM THE GROUND AND SOLIDLY SUPPORT THE VEHICLE USING JACK STANDS. NEVER WORK BENEATH A VEHICLE THAT IS NOT PROPERLY SUPPORTED BY JACK STANDS WITH SUFFICIENT LOAD CAPACITY.

#### **BEFORE STARTING INSTALLATION:**

These exhaust hedders are designed to fit a Ford 352-427 FE in 1954-72 F100 trucks, an engine that your classic truck was most likely not originally equipped with. Since each project will have some level of customization and individuality, these instructions should serve as a general guideline for installing them on your vehicle. Should you have interference issues, do not bend, bang, cut, dent, drill or heat any portion of this hedder! Any alteration other than those suggested in an official Hedman Hedders instruction sheet will void the Lifetime Guarantee!

Install hedders using the Hedman Hedder gaskets included in this kit, and the application of a quality copper gasket spray adhesive (not included).

#### **INSTALLATION INSTRUCTIONS:**

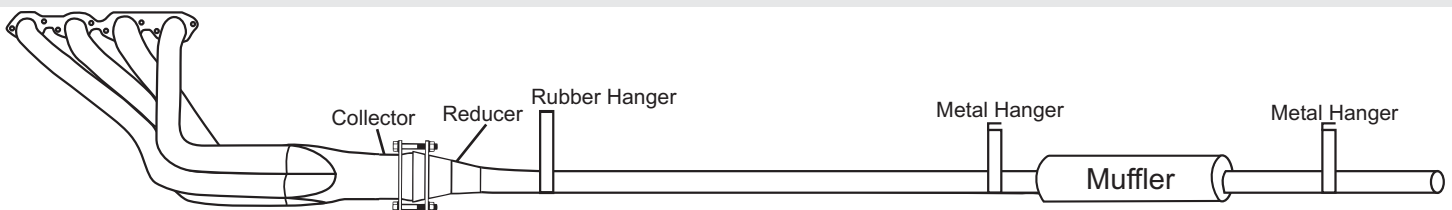
1. Disconnect battery.
2. Number wires and remove all spark plugs
3. Remove exhaust manifolds from engine (if installed).
4. Inspect the cylinder head's mating surface for damage, and thoroughly clean off any old gasket material and debris build-up, to ensure a good seal between the header flanges and cylinder head.
5. Working on one side at a time, spray a thin layer of copper gasket sealant to both sides of a gasket (follow manufacturer's instructions). Place gasket in position on the head, and install the header from below. Loosely install a supplied header bolt into the front and rear bolt holes. Install the remaining header bolts, and tighten each one beginning with the inner most bolts and working outward.
6. Bolt the supplied header reducers (exhaust adapters) to the header collectors.

*The following steps require that the vehicle's exhaust system be installed with the exhaust systems front in its final location.*

7. Measure and trim the front of the exhaust system's tube(s) so it can be butt-welded with the header reducers.
8. Tack weld the header reducers to your exhaust system.
9. Unbolt the exhaust system from the headers, and finish weld both header reducers to the exhaust system.
10. Using the supplied collector gaskets, bolts washers and nuts, bolt the headers to exhaust system.
11. Replace and reconnect the battery and all other parts previously removed or disconnected.
12. Closely inspect the entire system from header flange to tailpipe, making certain there is proper clearance for all fuel, brake lines and any shift linkage.
13. If coated, thoroughly clean the surface of the headers to remove any fingerprints and/or any other dirt or oil before proceeding to the next step.
14. Start engine and allow the engine to gain normal operating temperature. Check for leaks and new or unusual noises. Take vehicle for test drive, listening for new or unusual noises. Allow engine to cool and re-tighten all header bolts.

#### **IMPORTANT INSTRUCTIONS REGARDING YOUR VEHICLE'S EXHAUST SYSTEM!**

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".



**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.

ENJOY YOUR HEADERS WHILE COMBINING INCREASED FUEL EFFICIENCY WITH BETTER PERFORMANCE.

12438 Putnam Street, Whittier, CA 90602 • tel (562) 921-0404 • fax (562) 921-7515  
website: [www.hedman.com](http://www.hedman.com) • email: [techsupport@hedman.com](mailto:techsupport@hedman.com)