



**PART # 89360, 89366 & 89368  
INSTRUCTION SHEET  
FORD F-100, F-150, F-250, BRONCO  
(FENDERWELL) 351-400M 4 W/D ONLY  
FEDERWELL EXIT-OVERSIZE TIRES MAY INTERFERE**

**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 Hedders 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!**

**WARNING!** Breaking in an engine with ceramic-coated headers **WILL** result in damage to the coating and will **VOID** all warranties. Ceramic-coated headers require several heat cycles to fully cure before they will withstand extreme heat. Hedman Hedders recommends using a cast-iron exhaust manifold or an old header to break in new engines to avoid coating damage.

**INSTALLATION INSTRUCTIONS:**

1. Disconnect battery cable to avoid damage to the electrical system.
2. Disconnect exhaust head pipes and remove from work area, remove stock exhaust manifolds.
3. It is necessary to remove and discard brake line brace. Re-position brake, fuel, vacuum and electrical lines as necessary to clear the header. **NOTE:** On some models it may be necessary to trim or bend the edge of the fender panel slightly for the added clearance.
4. With steering turned off to the right, install drivers side header through opening between frame and fender panel. Position gasket and start all bolts.
5. With steering turned off to the left, install passenger side header through opening between frame and fender panel. Position gasket and start all bolts.
6. Tighten all bolts securely. **NOTE:** It is important that you start tightening header bolts from the center and work outward.
7. If one of the collectors make contact with the frame when tightening the header bolts, it will be necessary to level the engine. This is done by loosening the motor mount bolts and prying up on the lower side, twisting the engine on the slotted mounts. Re-tighten the motor mount bolts.
8. Re-tighten all bolts after running for a short period of time.

**NOTE:** On vehicles equipped with exhaust emission cannister (on passenger side of frame) re-locate unit to allow installation of exhaust system.

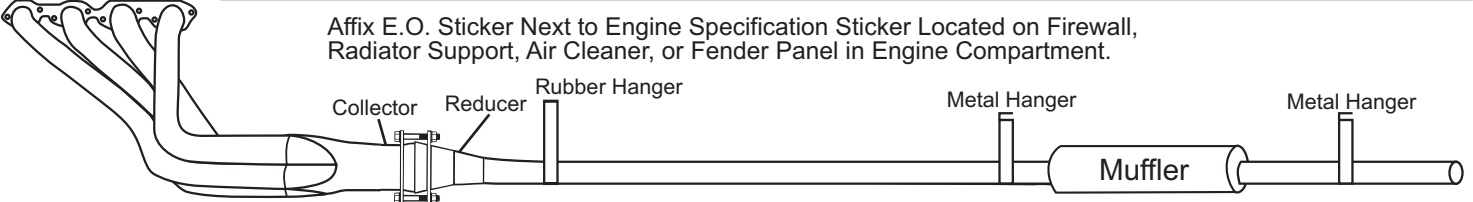
9. Make sure all brake and fuel lines and electrical wiring have sufficient clearance.
10. Connect battery.
11. Start engine, test drive vehicle, allowing engine to gain normal operating temperature. Check for leaks and new or unusual noises and after test drive, re-tighten all header bolts.

**ENJOY YOUR HEADERS WHILE COMBINING INCREASED FUEL ECONOMY WITH BETTER PERFORMANCE.**

**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".



Affix E.O. Sticker Next to Engine Specification Sticker Located on Firewall, Radiator Support, Air Cleaner, or Fender Panel in Engine Compartment.

**WARNING:** Not applicable or intended for street or highway use. Legal only for racing vehicles which may never be used upon a public highway.