



INSTRUCTION SHEET

PART #89660, 89663, 89666

'99-04 FORD F150, F250, F350 (Light-Duty)
6.8L V-10 2WD & 4WD
(AUTOMATIC TRANSMISSION ONLY)

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 Hedderts 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:

1. Disconnect battery to prevent electrical system damage.
2. Unclip O2 sensor wires in stock Y-pipe. Remove stock assembly from end of cast iron exhaust manifold up to catalytic converter. Set aside, being careful not to damage O2 sensors.

LEFT SIDE:

3. Removing air cleaner allows easier access to remove nuts from studs that hold stock manifolds in place, use nuts (previously removed) and washers provided to install new headers.
4. Remove oil dipstick tube and set aside.
5. Remove stock cast iron exhaust manifold leave stock studs in place carefully clean head surface.
6. Carefully remove O2 sensors from stock Y-pipe. Sparingly use anti-sieze compound and install O2 sensor at header collector area.
7. With gasket in place, install header from bottom of engine. Start all header nuts (previously saved) and washers provided in kit and tighten evenly from center out. Re-clip O2 sensor wire to computer.

NOTE: Must cut gasket to install oil dipstick tube between last two ports and front four ports (approximately 2", be careful to not cut port or bolt hole area).

8. Re-install dipstick tube.

RIGHT SIDE:

9. Remove starter, remove bolt that holds brake line bracket and move back.
10. Remove stock cast iron exhaust manifold leave stock studs in place carefully clean head surface.
11. Carefully remove O2 sensors from stock Y-pipe. Sparingly use anti-sieze compound and install O2 sensor at header collector area.
12. Loosen motor mount nuts, raise the engine, and with gasket in place, install header. Start all header nuts (previously saved) and washers provided in kit and tighten evenly from center out. Replace removed brake line bracket. Carefully re-route brake line. Lower engine down into place, replace motor mount nuts and install starter. Re-route computer wire for length and clip into O2 sensor wire on header.
13. Check all lines, wires, hoses, etc. for sufficient clearance.
14. Install new ball and socket Y-pipe to catalytic converter using stock gasket at converter and attach bracket on Y-pipe to bottom center flywheel dust cover bolt. Secure 3 bolt ball & socket connection. Be careful to tighten both sides evenly. Do not over tighten.
15. Replace previously removed air cleaner assembly.
16. Connect battery and replace all components taken off vehicle.
17. Start engine, test drive vehicle, allowing engine to gain normal operating temperature, check for leaks or unusual noises. After test drive is complete, re-tighten all header bolts and all fasteners previously loosened or removed.

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

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".

C.A.R.B. E.O.#D167-32

4/1/16: Excludes 89663. E.O. inclusion in process call for current E.O. status.

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.

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