



GM 3800 HEADER INSTALLATION INSTRUCTIONS

1. Disconnect battery
2. Remove brace going from left strut tower to core support.
3. Remove strut tower brace.
4. Remove air box lid and hose.
5. Remove 2 screws on top of air box and remove front half of air box.
6. Remove cross over pipe
7. Remove all 6 spark plugs
8. Remove dipstick tubes.
9. Remove lifting tabs on front end back of motor that are held on by exhaust manifold nuts.
10. Remove metal bracket on back of motor that holds spark plug wires and O2 wires in place. It is also held on by the manifold bolts.
11. Unbolt and remove head pipe and catalytic converter, you can cut head pipe off of converter at the weld holding the two pieces together at this time, or do it later.
12. Remove O2 sensor and air tube from rear exhaust manifold.
13. Remove all nuts holding manifolds to head; both manifolds come out from the top side of engine compartment.
14. Put high temp RTV on flanges, install rear header first (drops in from top) install air tube, and O2 sensor and tighten everything up.
15. Use high temp RTV on flange again and install and tighten front header.
16. Put high temp RTV on flange, making sure flange is slid up the pipe to the flare. Using a twisting motion, install pipe from topside between cylinder head and transmission dipstick tube.
17. Install 2 bolts, 4 washers, 2 lock washers, and 2 nuts in the 2 bolt flange of header and crossover tube, finger tight.
18. Take Y-pipe and slide it up onto rear header and crossover pipe.
19. If you didn't cut converter off head pipe earlier, do it now.
20. Slide converter onto Y-pipe and with complete exhaust on car, align exhaust left to right and make sure it is up high enough for ground clearance but not too high that rear O2 sensor hits the floor, about a 1/2" is good.
21. Tack weld converter to Y-pipe and remove from car.
22. Weld up pipe fully, slide 2 clamps onto y-pipe and put it back up in place, and tighten clamps.
23. Tighten 2 bolt flange up
24. Reinstall, lifting tabs front and rear, also metal plate on rear of motor that holds spark plug wires in place.
25. Reinstall dipstick tube, spark plug and wires, O2 sensors, air box and inlet tube, strut tower brace and strut tower to radiator core support brace.
26. Hook up battery.