



## 1997-2010 CORVETTE C5/C6 STAINLESS FULL LENGTH HEADERS PART#'S 16435/16445/16455/16465

### INSTALLATION INSTRUCTIONS

**TOOLS REQUIRED**-8, 10, 15, 18mm sockets, 10, 15mm wrenches, 5/8 spark plug socket, extensions, ratchet. 7/8 wrench.  
Anti-seize.

- STEP 1** Disconnect negative battery terminal.
- STEP 2** Remove decorative coil covers. Lift up and they will unsnap from the fuel rails.
- STEP 3** Disconnect o2 sensor plugs at the coil brackets.
- STEP 4** Remove spark plug wires and spark plugs.
- STEP 5** Remove bolt that holds dipstick tube to passenger side head. Pull tube up to slide out of hole in bottom of engine block.
- STEP 6** Jack up and support vehicle.
- STEP 7** Unplug o2 sensor wiring for rear sensors.
- STEP 8** Remove the nuts at the mid-pipes and cat back to remove the x pipe section.
- STEP 9** Remove the nuts at the exhaust manifolds for the catalytic converter and remove.
- STEP 10** Remove the bolts on the exhaust manifolds that bolt them to the heads
- STEP 11** Connect the supplied o2 extensions to the stock plug at the top of the engine and route down the back of the engine along side the bellhousing on both sides.
- STEP 12** **SEE PHOTO 4.** Remove the shield that covers the torque tube/driveshaft and layout two holes to be made in shield for the rear o2 sensor wiring. Measuring from the first mounting hole back 17½" to the rear for the driver side and 19" back for the passenger. Then measure in from the side 3" and holesaw a 1" hole on each side. Install the o2 sensors in the holes and connect the gray extension wire to the sensors. Lift shield back in place and connect the extension wires to the stock plugs. Reinstall and tighten the shield bolts letting the sensors hang until the mid pipe installation.
- STEP 13** **SEE PHOTOS 2 AND 3.** Remove the shield and layout holes as shown. Front holes will be even with the first rib in shield. Rear holes will be centered between 3<sup>rd</sup> and 4<sup>th</sup> rib in shield. Install the o2 sensors through the holes and as you lift shield back in place, reconnect sensor plugs back into loom plugs. Install the bolts for the shield and tighten. Let sensors hang until you install the mid pipes.
- STEP 14** Remove the shields from the stock exhaust manifolds and remove the o2 sensors.
- STEP 15** Install the driver side header with supplied gasket and bolts.
- STEP 16** **SEE PHOTO 1.** On automatic equipped cars, the cooler lines need to be moved up slightly by removing clamp bolt at oil pan (near starter) and lifting lines up. Use the supplied flat washer under bolt to secure the clamp.
- STEP 17** On the passenger side the engine will need to be raised to install the header. Remove the nut on the stud that points down and carefully lift engine for clearance. Install the header, supplied gasket with supplied bolts.  
Lower engine and reinstall the motor mount nut.



- STEP 18** Install the o2 sensors in the collectors and connect plugs to the extensions.
- STEP 19** Install the collector studs in the flanges with a little anti-seize on the threads.
- STEP 20** Install the o2 sensor into one of the midpipe sections and then connect to the collector with supplied nuts and washers. The driver side sensor will go into the passenger side midpipe and the passenger side sensor into the driver side midpipe. With both mid-pipes loosely installed, install the X pipe section to the mid-pipes with supplied clamps. On C5's use supplied bolts to bolt X pipe to stock over axle pipes. On C6's use the stock barrel connector clamps. Install nuts on rear X-pipe mount and tighten.
- STEP 21** Position o2 sensors so they point at holes in shield and tighten all nuts and clamps.
- STEP 22** Reinstall dipstick tube and dipstick.
- STEP 23** Reinstall the spark plugs, wires and coil covers.
- STEP 24** Reconnect the battery and start engine to check for leaks. Bolts should be rechecked for tightness after a few hundred miles.

**Photo 1**

**Automatic transmission lines clamp at oil pan with washer (shown)**

**Photo 2**

**C5 Oxygen sensor hole layout (rear holes) 2" in from edge**

**Photo 3**

**C5 Oxygen sensor holes (front holes) 1 3/4" in from edge**

**Photo 4**

**C6 Oxygen sensor holes shown**