



TUBULAR EXHAUST SYSTEM
Catalog #s 68342, 68343, 68362, 68363, 68542, 68543,
68552, 68553, 68562, 68563,
Vehicle Applications - See Below
INSTALLATION INSTRUCTION

Please study these instructions carefully before installing your new *Tubular Exhaust System* (TES). If you have any questions, please contact our **Technical Hotline at : 1-800-416-8628** from 7 am - 5pm, Monday-Friday, Pacific Standard Time or e-mail us at **Edelbrock@Edelbrock.com**. Please fill out and mail your warranty card.

VEHICLE APPLICATIONS: All with 4.3L V6 T.B.I. or C.P.I.

Standard Transmission	Auto Transmission	Description
#68342, #68343	#68542, 68543	1988-1995 Chev./GMC S-10/S-15 Pick-Up Truck, 2WD
-	#68552, 68553	1988-1995 Chev./GMC S-10/S-15 Pick-Up Truck, Blazer & Jimmy, 2WD
#68362, #68363	#68562, 68563	1988-1995 Chev./GMC S-10/S-15 Pick-Up Truck, Blazer & Jimmy, 4WD

IMPORTANT NOTE:
Proper installation is the responsibility of the installer. Improper installation will void warranty and may result in poor performance and engine or vehicle damage.

TUBULAR EXHAUST SYSTEM: These components are designed as a system to improve the exhaust efficiency of the GM T.B.I. (Throttle Body Injection) or C.P.I. (Central Port Injection) 4.3L V6 engine. A performance gain can be expected by the installation of the system. This system requires no welding for installation and retains all O.E. M. emissions equipment.

Suggested Tools Needed for Installation: This vehicle has some metric fasteners.

- 3/8" ratchet socket set with extensions and universal 13mm and 15mm swivel sockets
- Combination set of open-end wrenches
- Jackstands, screwdrivers, pliers, crescent wrench, etc.
- Liquid penetrant, (GM #1052627) and anti-seize compound (GM #5613695)

NOTE: Special power steeling puller required: Use K-D 2897 or equivalent.

SPECIAL NOTICE: This Edelbrock Tubular Exhaust System has received an Executive Order number (E.O.#) from the California Air Resources Board (C.A.R.B.) making it legal for street use in all 50 states. To assist you with emission equipment certification, we have included a silver fan shroud decal to help testing personnel verify that this part is a legal replacement on the vehicle for which it is cataloged. The adhesive-backed decal should be affixed next to the existing emission and engine specifications decal. Do not cover any part of your original emission decal.

WARNING: The use of "Thermal Wrap" or any aftermarket coating process **will void the warranty** on your Edelbrock Tubular Exhaust Systems. Those products can cause excessive heat and moisture buildup resulting in corrosion and failure of the system.

INSTALLATION INSTRUCTIONS

DISASSEMBLY

1. Disconnect negative battery cable from battery.
2. Raise vehicle and support with jackstands.
3. Use penetrating oil on all nuts and bolts to be removed. This will prevent the possibility of broken or stripped nuts and bolts.
4. Remove O2 sensor and unbolt exhaust crossover pipe from manifolds.
5. Lower vehicle and remove air cleaner assembly.
7. Unbolt and remove right side exhaust manifold.
8. Unbolt dipstick bracket from cylinder head, but do not remove dipstick.
9. Unbolt vacuum reservoir and move aside (this will allow easy installation of the right side T.E.S. manifold).
10. Remove upper portion of the fan shroud.
11. Remove serpentine accessory drive belt.
12. Place a piece of cardboard or similar material behind radiator to protect from damage when removing power steering pump pulley.
13. Remove power steering pulley with special puller.
14. Remove the three bolts behind the pulley which hold the power steering pump in place.
15. Remove the bolt which holds the support bracket to the back of the alternator.
16. Unbolt and remove left exhaust manifold.
17. Remove cross bolt from steering shaft and slide lower.
18. Raise the vehicle and remove the nuts which attach the transmission to the crossmember.
NOTE: Removal of crossmember is necessary only when O.E.M. crossover pipe is tack-welded to catalytic converter or if removal of pipe is easier done on the bench.
19. If crossmember removal is necessary, raise the engine/transmission up slightly off the crossmember.
20. Unbolt the crossmember from the frame and remove.
21. Unbolt and remove catalytic converter and crossover pipe assembly.
22. Remove catalytic converter from crossover pipe.
23. Replace crossmember and fasten securely at this time.

ASSEMBLY - LEFT SIDE

1. Start rear manifold bolt with gasket, lock and flat washer in place, and screw in leaving just enough space to slide manifold into position. NOTE: Be sure spark plug clips do not interfere with manifold surface.
2. Slide manifold into position and start the fourth bolt back from the front, then start bolts number three and five using lock washers on all bolts (**Do not tighten**).

NOTE: T.B.I. vehicles will require use of the heat stove assembly provided in this kit. Using 3/8"-16 x 1" header bolts, lock washers and 3/8" AN washers provided, start bolts in second port on left side (cylinder #3) and slip heat stove down over bolts between header flange and AN washers. After all header bolts are in place, tighten securely.

3. Place power steering pump and bracket assembly into position, then use spacers and 3/8" x 2-3/4" ferry bolts to attach bracket to front two holes on manifold (**Do not tighten**).
4. Replace the three mounting bolts in the front of the power steering pump.
5. Tighten all bolts at this time.
6. Replace serpentine belt and upper fan shroud.

ASSEMBLY - RIGHT SIDE

1. Start rear manifold bolt with gasket, lock and flat washers in place, then screw in leaving just enough space to slide manifold into position. NOTE: Be sure spark plug clips do not interfere with manifold surface.
2. Place manifold into vehicle with dipstick between first and second exhaust tube, slide manifold into position and start all bolts using lock washers provided (lock and flat washers on slotted ends).
3. Re-attach dipstick to cylinder head using 1/4" bolt and 1/2" long spacer tube provided.
4. Tighten all bolts at this time.
5. Raise vehicle and replace catalytic converter (Do not tighten bolts.).
6. Replace O2 sensor and attach wire.
7. Install extension pipes, start all bolts, check clearance between catalytic converter and crossmember (Blazers and Jimmys and 4 W.D. trucks). It should be approximately 1/2".
8. With converter in position, tighten all bolts.
9. Lower vehicle and replace all spark plugs.
10. Replace all spark plug wires.
11. Check all hydraulic and fuel lines making sure there is adequate clearance.
12. Replace air cleaner assembly and connect battery.
13. At this point, it would be a good idea to look everything over and make sure nothing was missed in assembly.
14. Start vehicle and bring up to normal operating temperature and check for possible leaks.
15. Turn engine off and let cool. Tighten all bolts again.

KIT CONTENTS - #68342, #68343

Qty.	Part #	Description
<input type="checkbox"/> 1	25-9449	Left Manifold (#68342)
<input type="checkbox"/> 1	25-9064	Left Manifold (#68243)
<input type="checkbox"/> 1	25-9446	Right Manifold (#68342)
<input type="checkbox"/> 1	25-9078	Right Manifold (#68343)
<input type="checkbox"/> 1	25-9534	Left Side Extension Pipe
<input type="checkbox"/> 1	25-9533	Right Side Extension Pipe

KIT CONTENTS - #68362, 68363

Qty.	Part #	Description
<input type="checkbox"/> 1	25-9450	Left Manifold (#68362)
<input type="checkbox"/> 1	25-9065	Left Manifold (#68363)
<input type="checkbox"/> 1	25-9446	Right Manifold (#68362)
<input type="checkbox"/> 1	25-9078	Right Manifold (#68363)
<input type="checkbox"/> 1	25-9536	Left Side Extension Pipe
<input type="checkbox"/> 1	25-9535	Right Side Extension Pipe

KIT CONTENTS - #68542, #68543

Qty.	Part #	Description
<input type="checkbox"/> 1	25-9327	Left Manifold (#68542)
<input type="checkbox"/> 1	25-9064	Left Manifold (#68543)
<input type="checkbox"/> 1	25-9328	Right Manifold (#68542)
<input type="checkbox"/> 1	25-9078	Right Manifold (#68543)
<input type="checkbox"/> 1	25-9521	Left Side Extension Pipe
<input type="checkbox"/> 1	25-9524	Right Side Extension Pipe

KIT CONTENTS - #68552, #68553

Qty.	Part #	Description
<input type="checkbox"/> 1	25-9327	Left Manifold (#68552)
<input type="checkbox"/> 1	25-9064	Left Manifold (#68553)
<input type="checkbox"/> 1	25-9328	Right Manifold (#68552)
<input type="checkbox"/> 1	25-9078	Right Manifold (#68553)
<input type="checkbox"/> 1	25-9521	Left Side Extension Pipe
<input type="checkbox"/> 1	25-9522	Right Side Extension Pipe

KIT CONTENTS - #68562, #68563

Qty.	Part #	Description
<input type="checkbox"/> 1	25-9329	Left Manifold (#68562)
<input type="checkbox"/> 1	25-9065	Left Manifold (#68563)
<input type="checkbox"/> 1	25-9328	Right Manifold (#68562)
<input type="checkbox"/> 1	25-9078	Right Manifold (#68563)
<input type="checkbox"/> 1	25-9523	Left Side Extension Pipe
<input type="checkbox"/> 1	25-9522	Right Side Extension Pipe

KIT CONTENTS - Common to All Part Numbers

Qty.	Part #	Description
<input type="checkbox"/> 1	-	Heat Stove Assembly
<input type="checkbox"/> 1	46-1060	Flange Connector
<input type="checkbox"/> 2	-	Power Steering Spacers - 5/8" O.D. x 1.53"
<input type="checkbox"/> 1	-	Dipstick Spacer; 3/8" O.D. x 1/2"
<input type="checkbox"/> 2	-	Manifold Port Gaskets
<input type="checkbox"/> 2	-	Donut Connector Gaskets
<input type="checkbox"/> 1	-	2-1/4" U-Muffler Clamp
<input type="checkbox"/> 10	-	3/8"-16 x 1" Hex Header Bolts
<input type="checkbox"/> 2	-	3/8"-16 x 2-3/4" Ferry Bolts (12 pt. Head)
<input type="checkbox"/> 1	-	1/4"-20 x 1" Hex Bolts
<input type="checkbox"/> 4	-	3/8"-16 x 2" Hex Bolts
<input type="checkbox"/> 8	-	3/8" Flat Washers
<input type="checkbox"/> 2	-	3/8" AN Washers
<input type="checkbox"/> 16	-	3/8" Lock Washers

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