



# INSTRUCTION SHEET PART # 68530 & 68536

## Chevy 409 Block Hugger

**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.

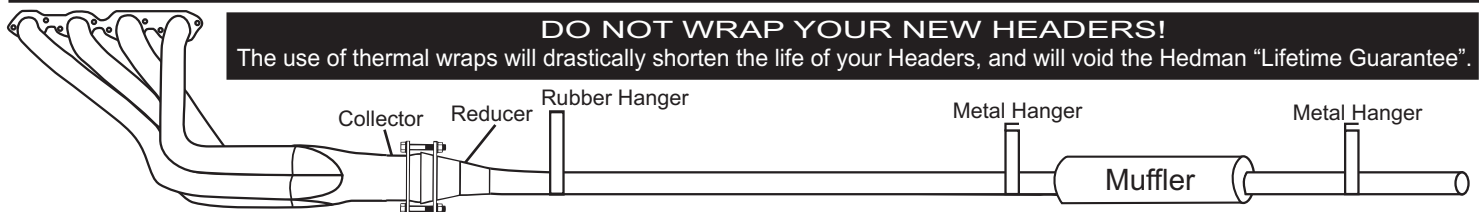
### INSTALLATION INSTRUCTIONS:

1. Remove any existing hedder or manifold from the engine.
2. Check to make sure the hedder mounting surfaces around the ports on the cylinder heads are clean and free of old gasket material.
3. Hedman recommends using a copper spray sealant on both side of your new hedder gasket.
4. Once gaskets have been prepped, using the easiest method possible, slide hedders and gaskets into the engine compartment.
5. Loosely install hedder bolts into the cylinder head, making sure to apply anti-sieze on all bolts.
6. Once all bolts are installed loosely into the heads, tighten them to factory torque specs. (Make sure to start with the the bolts that are in the center of the flange and work your way towards the outside.)
7. Use the reducers supplied to re-attach your exhaust system to your new hedman hedders.
8. Check that there is sufficient clearance between your new hedder and any existing brake lines, wires, cables, etc.
9. Start the vehicle to check for leaks. If everything is satisfactory allow the engine to reach normal operating temperature before shutting it off. Once the engine is cooled down, re-torque all bolts to factory specs.

### 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".



**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.