



PART # 68640, 68646 & 68648 INSTRUCTION SHEET 1964-87 SB CHEVY 283-400 ENGINES (See Catalog for Applications)

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:

If vehicle has Air Conditioning, additional parts may be required to complete install. Read A/C section below before starting. 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!**

- #### BEFORE INSTALLATION:
1. Disconnect battery and all wires to temperature sending unit and oil dipstick tube.
 2. Remove all spark plugs (Number Wires), factory manifolds, stock head pipes and air cleaner assembly.
 3. Remove clutch linkage (Bell Crank), or Hydraulic slave unit.

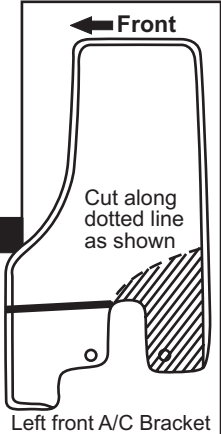
INSTALLATION INSTRUCTIONS:

LEFT SIDE: (If equipped with A/C, see "VEHICLES EQUIPPED WITH A/C" below)

1. It may be necessary to lift the left side of the engine approximately 1" to achieve adequate space to install left side Header.
2. With gasket in place, carefully manoeuver hedder from below, over water sensor (In Cylinder Head) up to head. Start all bolts. **DO NOT TIGHTEN BOLTS AT THIS TIME!**
3. If engine was raised in step 1, lower engine and replace motor mount bolts and tighten.
4. Install clutch linkage, or Hydraulic slave unit previously removed.
5. Tighten all bolts on left side header.

- RIGHT SIDE:**
1. With gaskets in place, from top, install header and start all header bolts and tighten evenly. With A/C, install from below.

- #### AFTER INSTALLATION:
1. With the reducers in place, cut factory exhaust pipes so that the system may be secured by welding the exhaust system to the right and left side header reducers.
 2. Replace and reconnect battery and all other parts previously removed or disconnected. Make special notice to have proper clearance of all fuel, brake lines and any shift linkage.
 3. Start engine, test drive vehicle, allowing engine to gain normal operating temperature. Check for leaks and new or unusual noises. After test drive allow engine to cool and re-tighten all header bolts.



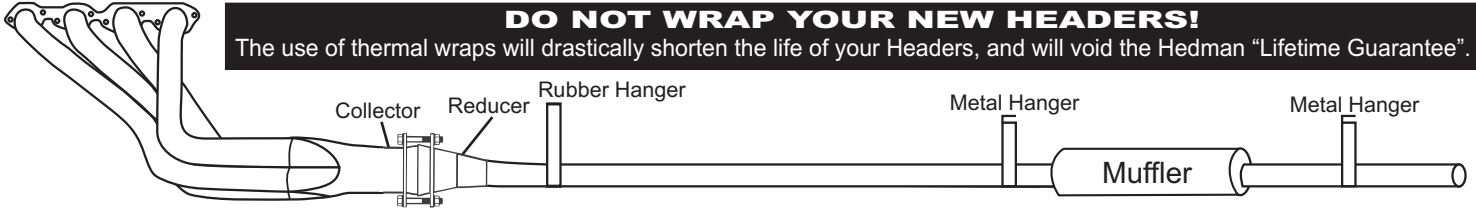
VEHICLES EQUIPPED WITH AIR CONDITIONING

When you remove the stock bracket (late model rotary type compressor short) see diagram to the right. This shows you how to cut the stock bracket away at the second hole location to clear the header tube for a clean installation. You will have sufficient strength when using the front hole with a simple spacer equal to the thickness of the original cast iron manifold that was removed. You will need to mount the air-conditioner bracket and the power steering bracket to the same bolt with spacer. When your vehicle is equipped with a long round type (piston type) air conditioning compressor unit, you may have to use Hedman air conditioner bracket part #20110, which can be purchased at your local dealer.

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.

68640-Instructionsheet-111605.cdr