



**PART # 69640, 69646 & 69648**  
**INSTRUCTION SHEET**  
SB CHEVY CONVERSION TO 1987-95 WRANGLER

(Fits Square Port & Round Port) (Straight & Angle Plug Heads, Chevy Aluminum LT1 Profile Only)

**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 Heddert 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!**

**INSTALLATION INSTRUCTIONS:**

- 1. Disconnect battery and remove spark plugs (Number Wires).
- 2. Remove factory manifolds, and if necessary the starter.

**LEFT SIDE**

- 1. With gasket in place, install left header, starting all bolts.
- 2. Tighten all header bolts evenly.

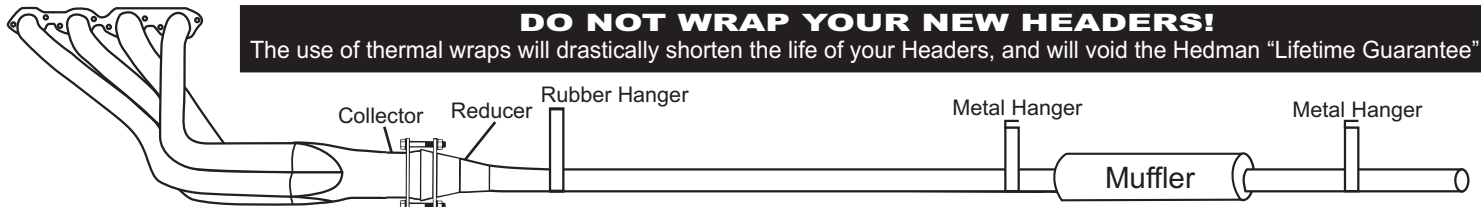
**RIGHT SIDE**

- 1. With gasket in place, install right header, starting all bolts. **DO NOT SECURE BOLTS!**
- 2. Replace starter, if removed.
- 3. Tighten down all header bolts evenly.
- 4. Fabricate exhaust and attach to headers.
- 5. Replace and re-connect all parts that have been removed or disconnected. Make sure that there is adequate clearance between the headers and the transmission cooling hoses, brake and fuel lines, and electrical wire. Re-route as necessary.
- 6. Start engine, test drive vehicle allowing engine to gain normal operating temperature. Check for leaks and new or unusual noises. After test drive is completed, re-tighten Header bolts.

**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:** Not applicable or intended for street or highway use. Legal only for racing vehicles which may never be used upon a public highway.

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