



**PART # 89140, 89146 & 89840**  
**PART # 89200, 89206 & 89820**  
**INSTRUCTION SHEET**  
**FORD 429-460 ENGINES**

**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:**

**DISASSEMBLY**

1. Disconnect battery and remove spark plugs.
2. Use penetrating oil on all nuts and bolts to be removed. This will prevent the possibility of broken or stripped nuts and bolts.
3. Making sure the converter is cool, remove the exhaust crossover pipe.
4. Remove fresh air duct to air cleaner along with hot air hose from exhaust manifold to air cleaner air horn.
5. Remove old exhaust manifolds.

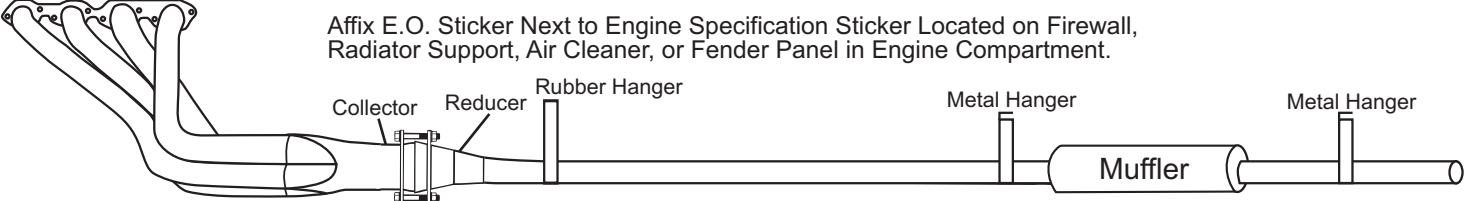
**ASSEMBLY**

1. Install headers from bottom of engine compartment area. With gasket in place, start all header bolts, most restricted first.
2. Tighten all header bolts, starting at center and working towards the end.
3. Install reducers using bolts and gaskets supplied.
4. Cut and re-connect head pipes to reducers and weld.
5. Replace hot air hose with adapter kit supplied. Re-connect fresh air duct to air cleaner.
6. Re-connect any emission parts removed during installation process.
7. Replace spark plugs and re-connect battery.
8. Check all lines, linkage, and hoses for adequate clearance.
9. 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".

**DO NOT WRAP YOUR NEW HEADERS!**  
 The use of thermal wraps will drastically shorten the life of your Headers, and will void the Hedman "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.

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