

# FLOWTECH™

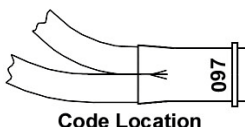
A Holley Performance Brand

## 11508FLT—FLOWTECH I STANDARD HEADERS 31508FLT—FLOWTECH II CERAMIC HEADERS

Chevy / GMC 2WD & 4WD

### Installation Instructions for Header Code Number: 097

1985-95 Chevy / GMC Pickup 2WD & 4WD  
Fits 305-350 CID Engine



Fits all models with standard and automatic transmissions, power brakes, power steering, and air conditioning.

**NOTE:** The transmission safety lock may have to be altered or removed on some models.

**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. FLOWTECH® & Hooker® recommend using cast iron exhaust manifolds or old headers to break in new engines to avoid coating damage. Please call tech service at 270-781-9741 for additional information regarding ceramic-coated exhaust products.

### READ THESE INSTRUCTIONS CAREFULLY BEFORE STARTING:

For the ease of installation, your vehicle must be raised a minimum of 36". **Warning:** Should you decide to install any exhaust product yourself, be warned that the original equipment jack that came with the vehicle is intended for emergency use only. The use of a frame jack, in conjunction with a floor jack, as the main support is highly recommended to minimize the accidental dropping of a vehicle while the installation proceeds. Never go under a vehicle that is supported by only a bumper jack!

#### A. PREPARE THE VEHICLE FOR INSTALLATION:

1. Disconnect the negative cable of the battery.
2. Remove the air cleaner and hoses.
3. For trucks with A.I.R., disconnect the A.I.R. tubes at the exhaust manifold.
4. Remove the spark plugs and spark plug shields.
5. For trucks with the driver's side oxygen sensor, unclip the oxygen sensor from the wiring harness and remove it from the exhaust manifold.
6. Remove the dipstick and dipstick tube, if necessary.
7. Remove the exhaust manifolds and exhaust pipes.
8. Remove the A.I.R. valve.

#### B. CHECK THE CONDITION OF THE ENGINE MOUNTS:

**INSTALLATION NOTE:** It is recommended that new engine mounts be installed before installing the headers.

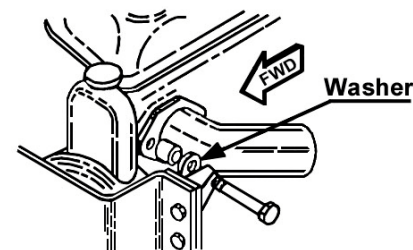
#### C. PREPARE THE HEADERS FOR INSTALLATION:

1. For trucks with air injection, drill 1/2" diameter holes through the air injection fittings into the header pipes.

2. For trucks with an oxygen sensor, drill 9/16" diameter holes through the fitting in the header collector. Install the oxygen sensor into the header and tighten.

#### C. LEFT SIDE HEADER INSTALLATION FROM ABOVE (DRIVER'S SIDE):

1. Hold the header and gasket in position and install the front and rear header bolts. DO NOT tighten at this time.
2. Install the balance of the header bolts. DO NOT tighten at this time.
3. If equipped with power steering, use one of the original manifold bolts and cut a piece of spacer material to the exact size and install as shown below.
4. Tighten the header bolts from the center outward like a cylinder head to maximize the flange gasket seal.
5. Connect the air injection tube to the header.
6. Plug the oxygen sensor back into the wiring harness.



#### D. RIGHT SIDE HEADER INSTALLATION FROM ABOVE (PASSENGER'S SIDE):

1. Hold the header and gasket in position and install the front and rear header bolts. DO NOT tighten at this time.
2. Tighten the header bolts from the center outward like a cylinder head to maximize the flange gasket seal.
3. Reinstall the A.I.R. valve and connect the air injection tube to the header.
4. Reinstall the spark plugs, wires, shields, dipstick, and dipstick tube.
5. Reinstall the air cleaner and hoses.
6. Reconnect the battery cable.

#### E. AFTER HEADERS ARE IN PLACE:

1. Before connecting the headers to the exhaust pipes, inspect all points with limited clearance. Relocate any points that have direct contact with the header. All engines are not mounted exactly the same at the factory, and it is sometimes necessary to loosen the motor mounts and move the engine slightly to one side or the other for maximum clearance. **If the motor mounts are worn or broken, they should be replaced.**

#### F. CONNECT THE EXHAUST SYSTEM:

1. Bolt the reducer adapters and gaskets to the collectors.
2. Attach the exhaust system by either welding or clamping the exhaust pipes to the reducer adapters.
3. Start the engine and let it idle until it reaches normal operating temperature and tighten all header bolts again. Periodically check the tightness of all header bolts.

When you have finished installing your FLOWTECH® headers, take the vehicle for a road test. Listen carefully for any exhaust leaks or other strange noises and make corrections. When the vehicle has been driven for a few days, retighten the header bolts.

P/N 11508-3901FLT Revised 7-10-02



How did we do? Your questions and comments are always welcome at FLOWTECH®. Our technical service department is open Monday through Friday, during the hours of 8:30 a.m. until 4:30 p.m. Central Time. We can be reached at:

**1801 Russellville Road • Bowling Green, KY 42102**  
**PHONE: 270-781-9741 • FAX: 270-781-9772**  
**EMAIL: [flowtech@support.holley.com](mailto:flowtech@support.holley.com)**

**IMPORTANT!** Unless certified or exempted by the California ARB, Headers are not legal for sale in California on 1975 or later model vehicles, except for racing vehicles, which are not legal for use or operation on any highway. Pre-Catalyst vehicles must utilize original air injection system, if so equipped. It is the responsibility of the customer to reinstall the air injection device to his vehicle.

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