



# Installation Instructions

#70-2213 #72C2213 94-01 Dodge RAM 1500, 2/4WD, 5.2/5.9L, Long Tube

Before installation, read and make sure you understand all instructions, and have necessary equipment at hand.

**WARNING:** Before working on the vehicle, make sure that it is well supported by jack stands or ramps of sufficient load capacity for the weight of the vehicle. NEVER work on any vehicle which is supported only by its service jack.

1. Disconnect battery
2. Raise vehicle on lift (preferred), or on jack stands or ramps. Do not work on vehicle supported only on a service jack.
3. From underneath vehicle, disconnect pre-cat and post-cat O2 sensor connections and unhook connectors from chassis clips. Remove sensors and save for re-installation on new system.
4. Remove U-clamps from both ends of primary pipe. Unhook rubber hangers from hooks on primary pipe.
5. Slide muffler back and separate primary pipe from Y-pipe. If pipes are deformed from U-clamps, it may be necessary to make horizontal cuts in ends of pipes to release them.
6. Un-bolt and remove Y-pipe. Remove starter and oil filter.
7. Remove spark plug wires and tie them up out of harm's way. Remove spark plugs to avoid breakage during assembly. Use rolled up paper towels to plug holes. Remove spark plug wire/heater hose holder from valve cover stud.
8. Remove exhaust manifolds. Remove 4 remaining manifold studs from cylinder heads. On two wheel drive models, remove the drive belt and unbolt the power steering pump bracket and lower the pump and bracket assembly down as far as possible.
9. Clean gasket surfaces.
10. Headers will be installed from top of engine. Use header type gaskets which are supplied with kit. A high temp gasket sealer such as Permatex Ultra-Copper is recommended.
11. Install and torque new manifold bolts in stages and evenly, to a final torque of 24 ft.lbs.
12. Check clearance on passenger side between outer header tube and frame rail, and driver side outer tube and motor mount bracket. If clearance is insufficient, check condition and alignment of motor mounts and trans mount.
13. Install pre-cat O2 sensor in right header using copper anti-seize compound. Be careful not to get anti-seize compound on sensor tips. Re-connect wires, and attach to chassis clips in original locations.
14. Re-install starter and oil filter. Re-install spark plugs and wires. Re-install spark plug wire/heater hose holder. Re-install power steering pump and drive belt.
15. If PACESETTER PERFORMANCE PRODUCTS Y-pipe is to be installed, it can be installed at this time. Refer to Y-pipe instructions.
16. Re-install primary pipe hangers. WD40 will ease installation.
17. Remove vehicle from stands, reconnect battery.
18. Start engine and check for exhaust leaks and rattles. Raise engine rpm with brake on and transmission in drive, and then in reverse. Listen or watch for clearance issues. Test drive.

It is recommended that all header bolts and clamps be re-torqued after the first hot-cold cycle, and periodically thereafter.

## NOTE:

There may be some lubricant left in the tubes from the mandrel bending process. You may smell this lubricant burning off for the first few days of using your new headers. This is normal and will cause no harm and will disappear. After a few days of operation, check all fasteners and clamps. Retorque as necessary.

2841 W. Clarendon • Phoenix, AZ 85017 • Phone (602)266-1964 • Fax (602) 650-1136

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