

# 2019+ SILVERADO / SIERRA

## HEADER INSTALLATION INSTRUCTIONS

Thanks for purchasing a Stainless Works Header system for your 2019+ Chevy Silverado / GMC Sierra. Our team has worked to ensure that this product is the premium in performance, quality, and fitment. We are proud to say that this system will unleash the true character of your vehicle. We encourage you to read through the following steps, and check the included Bill of Materials before beginning. Please follow these steps to ensure that your installation goes as planned.



**2019+ Silverado / Sierra**  
(CT19H)

**a.** Stainless Works recommends the use of Hi-Temp RTV sensor safe silicone gasket maker as an option or in conjunction with the use of factory gaskets. The recommended Oxygen Sensor Safe RTV is either Valco All-in-One Aluminum or Permatex Copper P/N 101BR available at NAPA, Autozone and other retailers.

**b.** Disconnect the battery before starting to work on the exhaust system for your vehicle. Reconnect the battery when the job is completed.

**c.** Your exhaust system can be installed by a weekend warrior, but the use of a lift is recommended for ease of installation. If using a jack, the vehicle must be placed on a hard level surface. Jack stands are required for safety.

**d.** You will assemble the components together as specified below, but only snug the clamps as you move along from front to back. After aligning all the components in the vehicle, you will tighten all the clamps working from front to back of the vehicle.



*Detail a*

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## DISASSEMBLY

1. Disconnect the battery.
2. Raise and support the vehicle.
3. Loosen the clamp at the factory stepped ball connection point.
4. Disconnect and remove all (4) O<sub>2</sub> sensors.
5. Unloom the wiring harness from the crossmember.
6. Support the transmission and remove (2) 15mm nuts from the transmission crossmember mount.
7. Remove (4) 21mm nuts and bolts from the crossmember and remove the crossmember.
8. Remove (2) 10mm bolts holding the heat shield on the Y-pipe.
9. Remove (6) 15mm nuts, (3) per side, from the OEM Y-pipe flange and remove the Y-pipe from the vehicle.
10. Re-install the crossmember.
11. Remove the vent hoses from the left and right valve covers and remove the plastic coil covers.
12. Remove all (8) spark plugs and wires.
13. Remove (6) 10mm bolts from the manifold heat shields, (3) bolts per side. Remove the heat shields from the vehicle.

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Detail 1: OEM manifolds and leads.



Detail 3: OEM ball clamped connection point.

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**14.**  
Remove (10) 13mm bolts, (5) per side, from the exhaust manifolds and remove manifolds from vehicle.

**15.**  
To gain clearance for headers, we recommend moving a few wires. Locate the wire harness from the starter to the battery, on the passenger side wheel well. Remove the harness from the looms and secure it to the adjacent harness using zip ties.

### **ASSEMBLY**

**16.**  
Use the provided RTV to create a seal on the header flanges.

**17.**  
Install the headers using (10) 8mm bolts, (5) per side.

**18.**  
Install left and right lead pipes using (2) 3" clamps.

**19.**  
Install either the X-pipe or Y-pipe depending on which system you purchased. Use (2) 3" clamps to secure.

**20.**  
Secure the connection to the catback.

**21.**  
Adjust and tighten from front to back.

**22.**  
Reinstall the O<sub>2</sub> sensors. Use the provided extensions for the driver side rear and passenger side front O<sub>2</sub>'s.

**23.**  
Check that all components have been reinstalled.



*Detail 15: Wire harness to move. Locations for unlooming marked with tape.*



*Detail 18: Driver side header - lead pipe connection.*

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**24.**

Be sure to have adequate clearance around all wires, hoses, and lines. If anything is in contact with the exhaust system it will melt. Make sure to have at least 1/2" of clearance and wrap any suspect areas with DEI thermal barrier wrap.

**25.**

After double checking for clearance and making sure all lines, wires and hoses are secured, drive the vehicle for 10-20 miles and re-check all clamps and clearances. Your system may be tack welded at the joints/ clamps to reduce shifting of the system during heating and cooling cycles. Make certain to disconnect the battery before performing any welding.

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*Detail 16: Headers and leads installed*

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