



Corporate Office: PerTronix Inc. 440 E. Arrow Highway, San Dimas, California 91773 * Phone 909.599.5955 * FAX 909.599.6424 * www.doughsheaders.com

HEADER INSTALLATION INSTRUCTIONS

H8076

1967-69 Camaro, 1968-74 Nova
LS Engine Swap

Note: Requires LS1 adapter plate kit P/N SK100



This Product is **ILLEGAL** for Street or Off Highway use and is only intended for Closed Course Competition use, Except for 1965 and older US Manufactured, California Certified vehicles; 1967 and older US Manufactured, Federal Certified vehicles, or 1967 and older Foreign Manufactured vehicles, which may have this product installed as long as the vehicle still meets emissions standards for the year of the vehicle and retains any original or retrofit emissions control devices, including EGR, A.I.R and any NOx device required for the year of the vehicle.

PerTronix® thanks you for choosing **PATRIOT Exhaust Products**, the best value for the dollar of any brand in the industry. Please read and understand these instructions completely prior to starting work.

CHECK TO MAKE SURE YOU RECEIVED THE PROPER PARTS FOR YOUR APPLICATION. THE HEADER NUMBER WILL BE STAMPED ON THE ENGINE FLANGE. IF YOU ARE UNSURE YOU HAVE RECEIVED THE PROPER PARTS CALL BEFORE YOU START WORK.

BE SURE TO WORK SAFE! WHENEVER YOU WORK UNDER THE VEHICLE BE SURE THAT IT IS LOCATED ON LEVEL, SOLID GROUND AND IS SUPPORTED BY ADEQUATE SAFETY STANDS!
REMEMBER: HOT ASPHALT WILL NOT SUPPORT MOST JACK STANDS!

Many factors affect the installation of headers, some of which are broken or aftermarket motor mounts, accidents that impact the configuration of the frame, and/or the installation of different engines or aftermarket cylinder heads. Most installations require some welding. If you are uncomfortable with welding operations, we recommend that you contact a professional exhaust system specialist to install your new headers.

Attention Customers breaking in new engines: Due to the extreme heat generated during the break-in process, the appearance of the ceramic coating may be altered in certain areas. The protection characteristics and thermal barrier properties of the coating is never compromised. It is recommended that a cast iron manifold or old set of headers be used for this process.

Notice: The coating of these headers can be marred or scratched during installation. If the header needs to be returned and is damaged, you will be charged for recoat.

DISASSEMBLY / ASSEMBLY

1. Disconnect the negative battery cable from the battery.
2. If a car lift is not available, raise the vehicle 2 feet or higher and support it with adequate safety stands. Make sure the vehicle is on a flat solid surface and is stable.
3. Apply penetrating oil to all nuts and bolts to be removed.
4. Remove bolts from headpipe to exhaust manifolds.
5. Note the spark plug wire locations and remove them from the spark plugs. Use a twisting motion while pulling the spark plug boot off of the spark plug. Be very careful not to damage the spark plug boot and do not pull on the wire itself.

6. Remove spark plug wire looms, plugs and any brackets attached to the manifolds.
7. Disconnect the O² sensor wiring.
8. Remove the O² sensors.
9. Remove the oil dipstick and tube.
10. Remove both of the exhaust manifolds.
11. Remove the starter.
12. Replace the spark plugs finger tight so debris will not get into the cylinders while cleaning the head surface. We recommend the use of a gasket scraper, wire brush, and sanding block to adequately clean the surface.
13. After cleaning is complete remove the spark plugs again.
14. Remove the oil filter.

RIGHT SIDE:

1. Starting from below, work the header and gasket up through the chassis into position.
2. Apply anti-seize to all header bolts being used. Start all header bolts.
3. Tighten all header bolts evenly (most restricted first).
4. Reinstall the right side spark plugs, wire looms, starter and dipstick tube and dipstick.
5. Install the 3 bolt reducer with the provided nuts and bolts.
6. Cut the old exhaust pipe and weld as necessary to the new reducer.
7. Reinstall the O² sensor.

LEFT SIDE:

1. Starting from below, work the header and gasket up through the chassis into position.
2. Apply anti-seize to all header bolts being used. Start all header bolts.
3. Tighten all header bolts evenly (most restricted first).
4. Reinstall the oil filter.
5. Reinstall the left side spark plugs, wire looms and any brackets.
6. Install the 3 bolt reducer with the provided nuts and bolts.
7. Cut the old exhaust pipe and weld as necessary to the new reducer.
8. Reinstall the O² sensor.
9. Connect the negative battery cable.

START THE ENGINE

Start the engine and allow it to warm up to operating temperature. Check for any unusual noises or exhaust leaks. If every thing is OK, stop the engine and tighten all bolts while the engine is still warm.

NOTE: Check the bolts periodically to make sure they have not loosened. Re-tighten after the first 500 miles and then again at 1000 miles

IMPORTANT CHECK LIST

- Be sure that all brake lines and fuel lines are clear of headers and/or connector pipes.
- All spark plug wires, battery cables, or other electrical components should be clear of headers and/or connector pipes.
- If dipstick tube was removed, make sure it is installed properly and that the dipstick has been replaced.
- Double-check the tightness of all bolts including brackets and accessories.

PARTS LIST

Qty	Description
1	Left side header
1	Right side header
2	Header gasket
12	Bolt, header, M8-1.25 x 26
6	3/8-16 X1' Bolts
6	3/8" Nuts
6	3/8" Lock Washer
2	3" Collector Gaskets

WARNING:

This product can expose you to chemicals including Lead, Nickel, Cadmium and Chromium which are known to the State of California to cause cancer and birth defects or other reproductive harm. For more information go to www.P65Warnings.ca.gov