

PART NO. 30164, 30165, 30166, & 30167

2004 GTO Long-Tube Headers

PACKING LIST

Item #	Check	Quantity	Part Number	Description
1.	☐	1	301600602C	Full Length Header, Driver Side, Coated
			OR	
		1	301600602	Full Length Header, Driver Side, Uncoated
2.	☐	1	301600603C	Full Length Header, Pass Side, Coated
			OR	
		1	301600603	Full Length Header, Pass Side, Uncoated
3.	☐	2	301600604	Front Intermediate Pipe
4.	☐	1	301600605	Intermediate Pipe, Driver Side Rear
5.	☐	1	301600606	Intermediate Pipe, Pass Side Rear
6.	☐	2	813000001	High Flow Catalytic Converter
			OR	
		2	310500103	Race Pipe
7.	☐	2	12558573	Exhaust Manifold Gasket
8.	☐	2	020402400	12" Rear O2 Sensor Extension
9.	☐	2	020402401	12" Front O2 Sensor Extension
10.	☐	6	308940020	3" Torca Exhaust Clamp
11.	☐	2	92033230	Gasket, Muffler Assembly
12.	☐	4	300080104	Bolt, 3/8-16 x 1.5"
13.	☐	4	30000R	Nut, 3/8-16
14.	☐	8	605742869	3/8" Flat Washer
15.	☐	4	30033B	3/8" Lock Washer
16.	☐	1	11517031	Nut, Steering Coupling, M8-1.25
17.	☐	1	*****	Instructions

Warning: SLP recommends wearing safety glasses for the complete installation.

Warning: SLP recommends allowing the vehicle to cool (not running) for five hours before beginning the installation. SLP recommends wearing safety glasses for the complete installation.

Warning: Too avoid the chance of electrical shock or damage to your vehicle's electrical system, disconnect both the negative and positive battery leads (in that order) at the battery.

INSTALLATION INSTRUCTIONS

1. Disconnect the negative battery cable.
 2. Raise and support the vehicle. A vehicle lift is highly recommended for this installation.
 3. Unplug all four (4) oxygen sensors from the vehicles wire harness and remove them, so they do not get damaged during the installation of SLP's midlength headers and set them aside. Label the front and rear sensor for later reinstallation.
 4. Remove the nuts from the brace on the transmission holding the stock catalytic converters in place.
 5. Support the muffler assy (CAT-BACK) with a jackstand just behind the two muffler assembly inlet flanges.
 6. Remove the four (4) bolts on the muffler assembly inlet flanges.
 7. Separate the catalytic converter and muffler assemblies and remove both flange gaskets from the flange joints.
 8. Support the rear of the catalytic converter assemble with a jackstand, then remove the catalytic converter to exhaust manifold flange retaining nuts.
 9. Remove both the drivers' side and pass side catalytic converter assemblies from the vehicle.
 10. Remove the exhaust bracket mounted to the rear of the transmission. This will not be reused with the new SLP exhaust.
 11. Remove all spark plug wires from both the coils and the spark plugs.
 12. Remove all eight (8) spark plugs from the engine.
 13. Remove the passenger side and driver's side stock exhaust manifold.
 14. Drain the power steering reservoir with a siphon as much as possible. This will keep fluid spillage to a minimum
 15. Disconnect the power steering lines from the steering rack, some fluid will drain out.
 16. Turn the steering wheel slightly to the left so you can access the bolt & nut that attaches the steering coupling to the steering rack. Remove the ignition key to lock the steering wheel in place.
- WARNING:** Once the steering shaft has been disconnected DO NOT TURN THE STEERING WHEEL. Turning the wheel with the shaft disconnected can cause damage to the steering column's internal components.
17. Remove the nut from the steering coupling retaining bolt and discard it. Then remove the bolt from the coupling retainer and separate the retainer from the coupling.
 18. Separate the coupling from the pinion on the steering rack.
 19. Unbolt the rack from the crossmember and swing it down out of the way.

20. Apply a .2" wide band of threadlock (GM P/N 12345493) or equivalent to the threads of all the exhaust manifold bolts.
21. Slide the SLP GTO Full length Headers along with the new gaskets up into place and start a couple bolts to hold them in place.
22. Start all exhaust manifold bolts by hand.
23. Tighten the exhaust manifold bolts beginning with the center two bolts. Alternate from side-to-side, and work toward the outside bolts.
24. Tighten the exhaust manifold bolts a first pass to 12 ft-lbs.
25. Tighten the bolts a final pass to 18 ft-lbs.
26. Next reinstall the spark plugs and wires.
27. Bolt the steering rack back onto the crossmember. Torque the nuts to 44.3 lb/ft then turn them an additional 45 degrees.
28. Reconnect the power steering lines to the steering rack.
29. Reconnect the steering shaft coupling to the pinion on the steering rack and install the retainer onto the coupling.
30. Insert the retaining bolt into the retainer and thread the new retaining nut provided in the kit onto it. Torque the retaining nut to 20.28 lb/ft. DO NOT REUSE THE OLD RETAINING NUT.
31. Next, slide a torca clamp onto the front of one of the front intermediate-pipes (they are both the same) and slide it onto a header collector. Loosely tighten the clamps just enough to hold it in position. Repeat this procedure for the other side.
32. Next install the SLP High Flow Catalytic Converters or Race Pipes onto the rear of the front intermediate-pipes. Make sure that you slide the torca clamps onto the front of the cats first. Repeat this step for both the driver and passenger side.
33. Place the two rear intermediate pipes next to each other. One of them has a slightly tighter bend than the other. This one goes on the passenger side. They should also be marked "P" and "D" for passenger and driver side. Slide a torca clamp onto the front of the passenger side rear intermediate pipe and slide it onto the catalytic converter outlet with the oxygen sensor bung facing the center of the vehicle. Loosely tighten the clamp to hold it in position. Repeat this procedure for the driver side.
34. Use the new two bolt gaskets provided and loosely bolt the rear of the intermediate pipes to the muffler assembly using the 3/8-16 X 1-1/2" bolts 3/8 nuts, washers, and lock washers provided.
35. Make sure all pipes clear and are in the proper position then tighten all the torca clamps. Tighten the clamps starting at the front and working towards the rear.
36. Tighten the four bolts on the flanges (25 ft/lbs).

37. Next install the four oxygen sensor extensions to the stock wire harness. Identify the proper locations for each by matching the connectors to the harness and sensors.
38. Install all four front and rear oxygen sensors into the new SLP pipes. Use some oxygen sensor safe anti-seize lubricant on the threads of the oxygen sensors before installing them into the new SLP pipes. Connect the sensors to the harness and make sure the wires are clear of the exhaust. Use wire ties to hold them away if necessary.
39. Refill the power steering reservoir and replace the reservoir cap.
40. Next install the negative battery terminal.
41. Start the vehicle and inspect for leaks.
42. Before test driving turn the steering wheel back and forth several times to work any air out of the system. Make sure you keep the reservoir topped off during this, but do not ever run the engine with the power steering fluid reservoir cap removed. It may make some noise during this procedure, but this is normal and will stop once the air is all out of the system. Top off the reservoir when all the air is removed.
43. Double check all fasteners and clearances after test driving. Adjust as necessary.
44. The installation is complete.