

HEADER INSTALLATION INSTRUCTIONS

Part # D3330

APPLICATION

92-96 CORVETTE, 5.7 LT-1/LT4

1

The product accompanying this document has been granted a California Air Resources Board (CARB) exemption, an "E.O." number, or is a direct or consolidated replacement part. It is 50-state legal, when installed on the appropriate vehicles per the manufacturer's application guide.

PerTronix® thanks you for choosing **DOUG'S HEADERS**, the best fitting, highest quality header on the market. In order to realize the full potential of our good fit, 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. Remove bolts from headpipe to exhaust manifolds.
4. 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.
5. Remove spark plug wire looms, plugs and any brackets attached to the manifolds.

6. Apply a **THIN** film of Ultra Copper Hi-Temp Sensor-Safe Silicone Sealer to header side of the header gaskets and stick the gaskets to the header flanges. Masking tape can be used to help hold the gasket to the header.

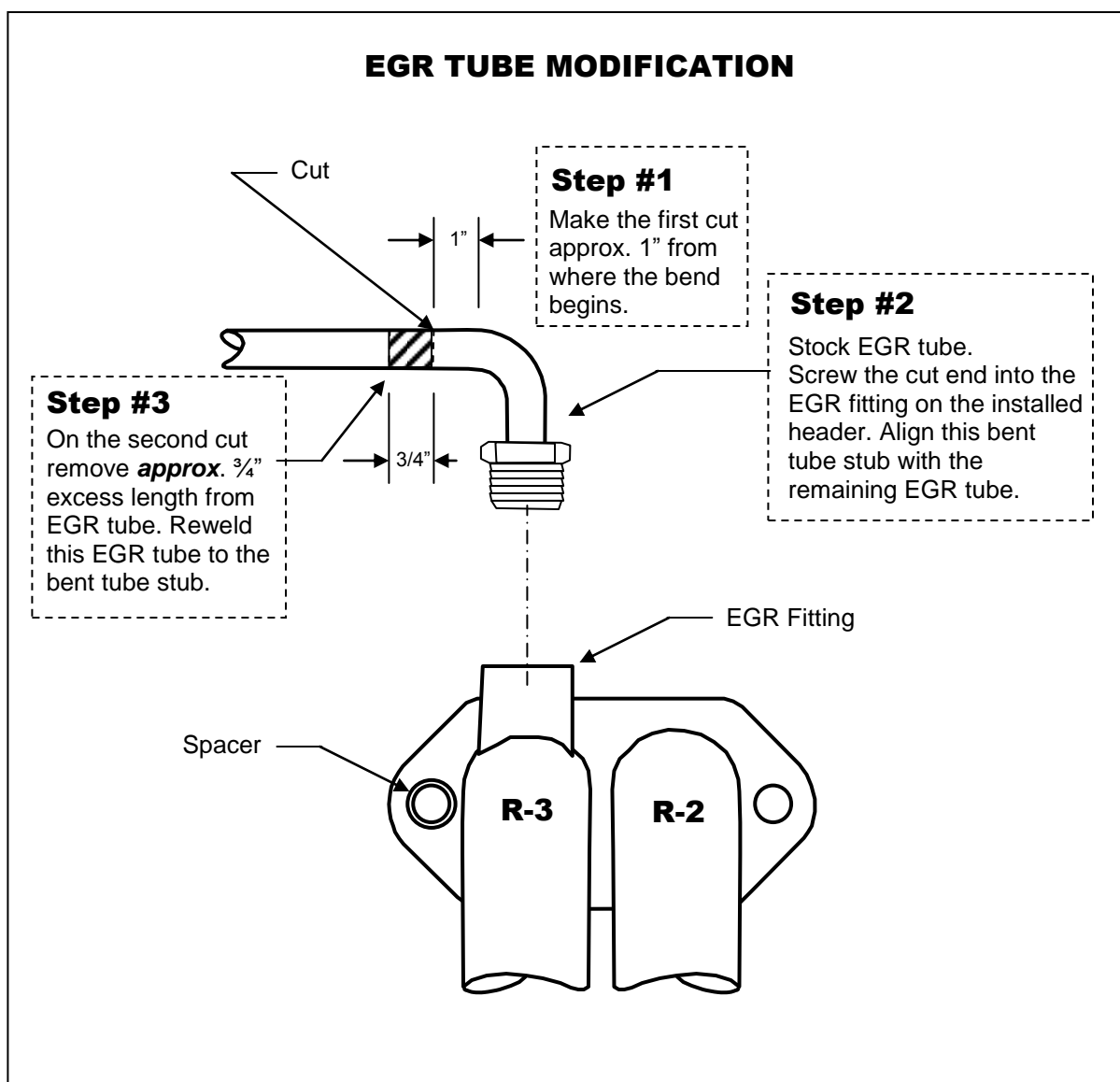
7. Right Side:

1. Remove the bolt in back of the right side cylinder head holding the EGR tube brace.
2. Remove the bolts on the intake manifold holding the EGR tube.
3. Loosen the nut holding the EGR tube to the intake manifold and remove the tube.
4. Remove the oil dipstick and tube.
5. Remove the exhaust manifold bolts and remove the manifold.
6. 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.
7. After cleaning is complete remove the spark plugs again.
8. Apply a **THIN** film of Ultra Copper Hi-Temp Sensor-Safe Silicone Sealer to engine side of the header gasket.
9. From above, install R/S header and gasket. Start header bolts.
10. Note: Some of the tubular spacers welded to the header flange may be used in your application to hold accessories. If this is the case, re-use your stock exhaust manifold bolts/studs. Those spacers not used may be removed and the supplied bolts and lock washers used.
11. The EGR tube must be cut and a $\frac{3}{4}$ " section removed and the tube rewelded for proper fit. Heli-arc welding is recommended (see Fig. 1).
12. Start all remaining bolts, including the collector to exhaust bolts and install the modified EGR tube. Do not tighten completely at this time.

8. Left Side:

1. Remove the serpentine belt.
2. Unbolt and remove the A/C compressor from the bracket.
3. Remove speed control and diverter valve assembly.
4. Loosen nut and remove air injection tube from the exhaust manifold.
5. Remove manifold bolts and remove manifold.
6. 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.
7. After cleaning is complete remove the spark plugs again.
8. Apply a **THIN** film of Ultra Copper Hi-Temp Sensor-Safe Silicone Sealer to engine side of the header gasket.
9. Install header and gasket from above. Start bolts (most restricted first) but do not tighten completely at this time.
10. Reinstall air injection tube, speed control, and diverter valve assembly.
11. Reinstall A/C compressor and brace using stock hardware.
12. Start collector to exhaust system bolts using supplied hardware.
13. Tighten all fasteners on both sides evenly.
14. Replace spark plugs and wires on both sides. Replace serpentine belt.
15. Connect the negative battery cable.

Fig. 1



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, 3/8"-16 x 1"
12	Lock washer, 3/8"
6	Bolt, 7/16"-14 x 1-1/4"
6	Lock washer, 7/16"
1	Sticker (C.A.R.B., E.O., D-57-19)



440 E. Arrow Hwy.
San Dimas, CA 91773
(909) 599-5955

This vehicle is equipped with:
Dougs Headers # D33XX
JBA Headers # 18XXS

Legal for sale and installation in California

CARB EXECUTIVE ORDER
D-57-19 & D-57-25

WARNING

This label is required to aid in passing the California smog check program. This label must be installed in an underhood location that is readily visible.