

HEADER INSTALLATION INSTRUCTIONS

D3324

APPLICATION

1993-1997 CAMARO & FIREBIRD LT-1



WARNING: These headers are legal for Off Highway use (except in California or states that have adopted California emission standards) or Racing use (which may never be used on a Highway), or for use on pre emission controlled motor vehicles/motor vehicle engines (pre 1966 domestic vehicles certified to California standards, pre 1968 domestic vehicles certified to Federal standards and all pre 1968 Foreign vehicles) **Only**.

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

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. Unbolt stock head pipes from the exhaust manifolds and push aside.
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 the spark plug wire looms and dipstick tube bracket bolt, and any brackets attached to the exhaust manifolds.
6. Remove the spark plugs.

7. Remove the engine oil dipstick tube bolt and remove the tube by using a twisting motion while gently pulling up on the tube.
8. If applicable, carefully remove O² sensors and hang out of the way.
9. Remove the exhaust manifold bolts and remove the exhaust manifolds.
10. 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.
11. After cleaning is complete remove the spark plugs again
12. Remove the starter.

ASSEMBLY

1. Apply a **THIN** film of Ultra Copper Hi-Temp Sensor-Safe Silicone Sealer to each 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.
2. Slide the driver side header (without L1 tube) in from underneath the vehicle, but do not install any bolts yet.
3. Apply a small amount of anti-seize to the header bolts and install the driver side header utilizing the star washers with the header bolts. Do not tighten the bolts at this time.
4. Apply a liberal film of Ultra Copper Hi-Temp Sensor-Safe Silicone Sealer to the slip joint of the L1 tube.
5. From above, install the L1 slip tube around the steering shaft and into the main body of the header.
6. Install the passenger side header with gasket attached using the star washers and header bolts supplied, but do not tighten at this time. (It may be necessary to raise the engine a couple of inches to install the header on this side).
7. Reinstall the starter.
8. If applicable, reinstall the O² sensors using a very small amount of Ultra Copper Hi-Temp Sensor-Safe Silicone Sealer on the threads.
9. Install the dipstick tube in the block and install the header bolt into the bracket.
10. Tighten all the header bolts on both sides of the engine to a final torque of 35 ft. lbs.
11. Install the spark plugs and attach the appropriate wire to the spark plug and reattach the spark plug wire looms. It may be necessary to reroute wires to clear the headers.
12. Connect the negative battery cable.

Note 1: Doug's offers a factory bolt up Y pipe, Part No. D920.

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 gaskets
2	Collector gaskets
12	3/8"-16 x 1" header bolts
18	3/8" lock-washers
6	Nut, hex, 3/8"-16
6	Screw, cap, hex head, 3/8"-16 x 1-1/4"
1	Spacer