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HEADER INSTALLATION INSTRUCTIONS

D603

1965-1976 Ford F-100, F150, F250 2WD 352-427 FE

NOTE:

**Will Only fit factory Low Riser Truck 8 bolt cylinder heads.
May leak on passenger car heads**



This product is Legal for use on 1974 and older non catalyst equipped vehicles and is considered a "replacement part" per California Air Resources Board regulations, as long as ALL emissions sensitive components are retained, including A.I.R., EGR, Heat Risers etc. Failure to retain any of these components, or use on any 1975 or newer catalytic converter equipped car would render this product Illegal for Street or Off Highway Use in California, or in states that have adopted California Emissions regulations and may only be used for Closed Course Competition.

PerTronix® thanks you for choosing **Patriot Headers**, 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.

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 with adequate safety stands. Make sure the vehicle is on a flat solid surface and is stable.
3. Remove the exhaust crossover pipe from the manifolds if so equipped. Disconnect the exhaust pipes from the manifolds. Remove the hot air hose from the manifolds to the air cleaner. Remove the manifolds from the motor.
4. Clean the cylinder heads of any leftover gasket material or built up carbon.
5. On stick shift trucks, remove the clutch cross shaft.
6. On 65-66 trucks remove the bolt in crossmember under the bellhousing.
7. Remove the starter. Remove the A/C compressor brace to the manifold if equipped.

INSTALLATION

1. Starting from below, raise the driver's side header into position. It MAY be necessary to unbolt the motor mount and raise the engine 1-2".
2. Using the supplied gasket, header bolts and washers, bolt the header to the head. Tighten the bolts to 35 ft/lbs evenly starting from the center and working out.
3. Place a jack with a wood block under the oil pan. Remove the Passenger side motor mount bolt and lift the right side of the motor at least 2".
4. Some 65-67 trucks had a Water Cooled transmission. If yours has this, you may need to modify the coolant lines to clear the headers.
5. From below, slide the passenger side header into place. Depending on your year, you may have to remove the motor mount stand from the frame if the header won't slide in.
6. Install two header bolts very loosely and reinstall the starter motor.
7. If removed, replace the motor mount stand, then lower the motor and tighten up the motor mount bolt.
8. With the gasket in place install the header bolts and washers. Tighten the bolts to 35 ft/lbs evenly starting from the center and working out.
9. C6 transmission equipped trucks MAY need the shift linkage arm on the trans bent inward to clear the header.
10. Connect the negative battery cable.

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.
- Double-check the tightness of all bolts including brackets and accessories.

STARTING 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.

PARTS LIST

<u>Qty</u>	<u>Description</u>
1	Left Side Header
1	Right Side Header
2	Header Gaskets
2	Reducers
2	Collector Gaskets
16	3/8 X 1" Header Bolts
6	3/8-16 x 1 1/4" Hex Head Bolts
6	3/8-16 Hex Nuts