



## HEADER INSTALLATION INSTRUCTIONS

### SWS PART # 440-2619, 440-2620, 440-2621, & 440-2622

**NOTE:** As a result of the restricted room available in some engine compartments, you may experience a close fit to some body and chassis components. This is a normal condition. If this is your first time installing a set of headers, it may be time consuming. While not particularly complex, stick with it, for as soon as you start your engine, the reward of additional horsepower and performance will be well worth your efforts. Proper installation and periodical maintenance will result in the maximum performance and life from your headers.

**CAUTION: READ THESE INSTRUCTIONS CAREFULLY BEFORE BEGINNING INSTALLATION.**

**WARNING:** For the ease of installation, your vehicle must be raised a minimum of 24". **DO NOT USE YOUR ORIGINAL EQUIPMENT JACK. IT IS INTENDED FOR EMERGENCY USE ONLY.** We suggest the use of a frame jack in conjunction with a floor jack (as the main support). This will minimize the possibility of the vehicle dropping during installation. **NEVER GO UNDER ANY VEHICLE THAT IS SUPPORTED ONLY BY A BUMPER JACK.**

**INSTALLATION NOTE:** If it is required that you retain the heat stove connection to the air cleaner (TAC), purchase a hot air kit.

**INSTALLATION NOTE:** Power steering equipped vehicles will need to purchase **SWS # 150-1218** power steering bracket.

#### **PREPARE THE VEHICLE FOR INSTALLATION:**

1. Disconnect the battery to prevent accidental damage to the electrical system.
2. Remove the spark plugs and clutch linkage (if equipped). Disconnect the power steering arm where it bolts to the frame.
3. Unbolt the headpipe from the exhaust manifold and move aside. Remove the manifold.

#### **CHECK THE CONDITION OF THE ENGINE MOUNTS:**

It is recommended that you install new engine mounts before installing the headers.

#### **LEFT SIDE HEADER INSTALLATION:**

1. Starting from below, work the header into position over the exhaust ports.

**NOTE:** On Comets, it may be necessary to raise the engine 2". This may be done by removing the center engine mount bolt and using a floor jack under the oil pan. **CAUTION! Use a board between the jack and oil pan to prevent damage.**

2. While the header is still loose, replace the clutch linkage (if necessary).
3. Place the gasket into position. Install the front and rear header bolts. Do not tighten.
4. Install the balance of the bolts. Do not tighten.

**NOTE:** Some applications will need to trim the engine mount for clearance.

**NOTE:** 1969 vehicles may require bending the firewall for clearance if the back left side tube is in contact.

**NOTE:** Vehicles equipped with Cobra oil pans may need to modify the header tube for clearance to the pan.

5. Tighten all header bolts progressively and evenly until they are tight.
6. Install the power steering bracket (**SWS # 150-1218** purchased separately) to the frame. Reconnect the power steering ram. Reroute the power steering hoses for clearance.

**NOTE:** For 1970-73 Comets, check the tubes for clearance to the power steering arm. Dent tubes if necessary.

7. On vehicles equipped, with automatic transmissions, check the kickdown linkage. It may be necessary to bend it toward the engine, until it works properly. Also, check the steering column lockout rod, which may also require bending for proper fit.
8. Replace the engine mount bolt and tighten.

#### **RIGHT SIDE HEADER INSTALLATION:**

1. Starting from below, work the header into position over the exhaust ports.

**NOTE:** Check the automatic transmission cooling lines and start cables for clearance. Reroute, if necessary.

2. Place the gasket into position. Install the front and rear header bolts. Do not tighten.
3. Install the balance of the bolts. Do not tighten.
4. Tighten all header bolts progressively and evenly until they are tight.

**NOTE:** Check the emergency brake cable clearance between it and the collector. If the cable hits the collector, it is necessary that you relocate the cable hanger at the frame for clearance.

#### **AFTER HEADERS ARE IN PLACE:**

1. Inspect all points with limited clearance. Relocate any points that have direct contact with the headers. Make sure there is adequate clearance around all lines (transmission, brake, fuel, and electrical wires). Reroute if necessary. **REPLACE ANY FLUIDS THAT YOU MAY HAVE REMOVED OR LOST.** Reconnect the battery cable.
2. When you have finished installing your headers, take the vehicle for a road test. Listen carefully for any exhaust leaks or other strange noises and make corrections. When the vehicle has been driven for a few days, retighten the header bolts. We find that periodically checking the bolts will prevent the flange from warping and the burning out of the header gaskets.