



TUBULAR EXHAUST SYSTEMS
For 1981 to 1986 Chevrolet/GMC K-10 Pickup truck,
carbureted 5.0/5.7L V8, 4 W.D., auto transmission, with A.I.R.
Catalog #68282, 68283

INSTALLATION INSTRUCTIONS

PLEASE study these instructions carefully before beginning this installation. Most installations can be accomplished with common tools and procedures. However, you should be familiar with and comfortable working on your vehicle. If you do not feel comfortable performing this installation, it is recommended to have the installation completed by a qualified mechanic. If you have any questions, please call our **Technical Hotline at: 1-800-416-8628**, 7:00 am - 5:00 pm, Pacific Standard Time, Monday through Friday or e-mail us at edelbrock@edelbrock.com.

IMPORTANT NOTE: Proper installation is the responsibility of the installer. Improper installation will void your warranty and may result in poor performance and engine or vehicle damage.

DESCRIPTION: These components are designed as a system to improve the exhaust efficiency of GM 305/350 C.I.D. V8 engines. A performance gain can be expected by the installation of the system. This system retains all O.E.M. emissions equipment.

WARNING: The use of "Thermal Wrap" or any aftermarket coating process will void the warranty on your Tubular Exhaust System. Those products can cause excessive heat and moisture buildup resulting in corrosion and early failure of the system.

KIT CONTENTS:

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| 1- Manifold left side #25-9061 (Ti-Tech Coated Only) | 12- Hex header bolts; 3/8" x 1" |
| 1- Manifold right side #25-9062 (Ti-Tech Coated Only) | 2- Ferry bolts; 3/8" x 2-3/4" |
| 1- Manifold left side #25-9443 (Ceramic Coated Only) | 1- Hose connector; 3/4" |
| 1- Manifold right side #25-9442 (Ceramic Coated Only) | 2- Spacer tubes; 5/8" x 1-1/2" long |
| 1- Extension Y-pipe #25-9555 | 3- Hex nuts; 3/8"-16 |
| 1- Extension crossover pipe #25-9581 | 2- Hex bolts; 3/8" x 2" |
| 1- Extension adapter pipe #25-9577 | 3- Hex bolts; 3/8" x 3-1/4" |
| 2- Chevy V8 port gaskets | 17- Lock washers; 3/8" |
| 1- Donut gasket; 2-1/4" | 1- Vacuum Hose; 1/4" x 15" |
| 1- Heat riser gasket | 1- Hose (A.I.R.); 3/4" x 23" |
| 1- U-clamp; 3" | 1- Brass pipe fitting; 1/4", 90° |
| 1- U-clamp; 2-1/4" | 1- Adapter; 1/4" straight |
| 4- Flat washers; 3/8" | |

BEFORE BEGINNING INSTALLATION

WARNING: EXPOSED FUEL AND OIL MAY BE PRESENT DURING THIS INSTALLATION. WHEN WORKING AROUND GASOLINE OR OIL, ALWAYS WORK IN A WELL VENTILATED AREA, AND KEEP ALL OPEN FLAMES, SPARKS, AND OTHER SOURCES OF IGNITION AWAY FROM THE WORK AREA. FAILURE TO DO SO CAN RESULT IN A FIRE OR EXPLOSION.

WARNING: SOME PROCEDURES IN THIS INSTALLATION MAY REQUIRE THE VEHICLE TO BE RAISED ON JACKSTANDS OR A LIFT. WHEN RAISING A VEHICLE, MAKE SURE THE VEHICLE IS ON LEVEL GROUND AND SUPPORTED SECURELY BY JACKSTANDS. NEVER WORK UNDER A VEHICLE THAT IS SUPPORTED BY A JACK ONLY!

BEFORE BEGINNING: Someone who has a basic knowledge of automobile repair and modification and is familiar with and comfortable with working on their vehicle can accomplish the mechanical installation of this kit using common tools and procedures. However, keeping a service manual for your vehicle on hand for reference is helpful. *Be sure to verify you have all parts listed in the "Kit Contents" section before starting your installation.*

SUGGESTED TOOLS FOR INSTALLATION: This vehicle has some metric fasteners.

- 3/8" ratchet socket set with extensions and universal 13mm and 15mm swivel sockets
- Combination set of open-end wrenches
- Hack saw
- Jackstands, screwdrivers, pliers, crescent wrench, etc.
- Liquid penetrant, (GM #1052627) anti-seize compound (GM #5613695)

INSTALLATION PROCEDURE

DISASSEMBLY

1. Disconnect battery negative cable from battery.
2. Raise vehicle and support with jackstands.
3. Use penetrating oil on all nuts and bolts to be removed. This will prevent the possibility of broken or stripped nuts and bolts.
4. Making sure the catalytic converter is cool, remove the exhaust crossover pipe.
5. Remove Heat Riser valve from right side manifold. Put aside for re-use.
6. Remove exhaust pipes from manifold and catalytic converter.

DISASSEMBLY - LEFT SIDE

7. Remove air cleaner system (note position of line and hose connections).
8. Disconnect A.I.R. (air injection reactor) tube from exhaust manifold.
9. Remove air conditioner compressor rear support bracket (if air conditioning equipped).
10. Remove power steering pump support bracket (if power steering is applicable).
11. Disconnect spark plug wires and remove spark plugs.
12. Disconnect temperature sensor wire.
13. Remove oil pressure sensor on block just above oil filter.
14. Install 90° brass fitting and 1/4" straight adapter in oil pressure sensor hole. Angle towards front of vehicle and install oil pressure sensor in fitting.
15. Remove bolts and exhaust manifold from top side.

DISASSEMBLY - RIGHT SIDE

16. Disconnect A.I.R. injection tube from exhaust manifold.
17. Disconnect spark plug wires and remove spark plugs.
18. Remove bolts and exhaust manifold from top side.
19. Clean exhaust flange surfaces on cylinder heads at this time.

ASSEMBLY - LEFT SIDE

1. Install T.E.S. flange gasket and one 3/8"-16 x 1" bolt, lock washer, and flat washer at rearmost bolt hole (leave bolt loose enough to accept T.E.S.).
2. Install left side T.E.S. manifold and the supplied exhaust gasket from top side.
3. Install all but the front two bolts and washers on left side (do not tighten at this time).
4. Re-install rear power steering support bracket. Do not tighten at this time.
5. Install rear A/C support bracket with bolts, lock washers, and spacers supplied. Spacer required for long compressor only.
6. Align all parts and tighten left side bolts and nuts at this time.
7. Re-install spark plugs and re-connect wires on left side.
8. Re-install temperature sensor wire to temperature sensor.

ASSEMBLY - RIGHT SIDE

1. Install T.E.S. flange gasket and one 3/8"-16 x 1" bolt, lock washer and flat washer at rearmost bolt hole (leave bolt loose enough to accept T.E.S.).
2. Install right side T.E.S. manifold and the supplied exhaust gasket from the top side.
3. Install remaining bolts & lock washers.
4. Align all parts and tighten all right side bolts at this time.
5. Re-install spark plugs and re-connect wires.
6. Remove A.I.R. check valves from original manifolds and re-install them on T.E.S. With 3/4" hose supplied in kit, re-connect all A.I.R. injection hoses at this time.
7. Prepare right side heat riser tube prior to installation as shown in **Figure 1**. Cut tube and use 1/4" vacuum hose (supplied) to connect to heat riser vacuum pod.

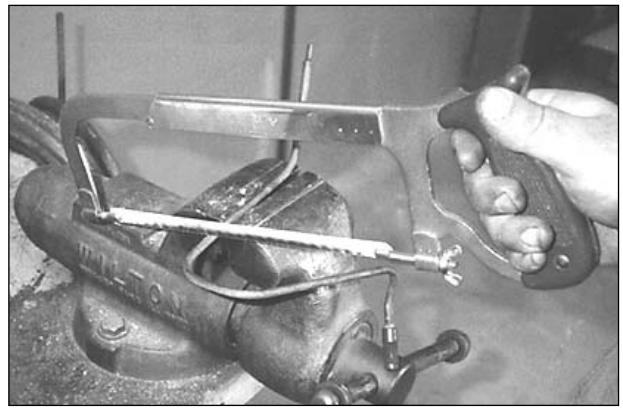


Figure 1 - Cut heat riser tube as shown. Use with 1/4" vacuum hose.

CROSSOVER PIPE ASSEMBLY

1. Install heat riser valve and 1/4" vacuum hose (supplied).
2. Carefully align and tap adapter tube into converter using a piece of wood or a mallet to protect the end of the adapter.

NOTE: Be sure adapter goes all the way in, approximately 2-1/2".

3. Install crossover pipe assembly on vehicle using four 3/8" x 2" bolts with lock washers and donut gaskets supplied.
4. Install U-clamps and tighten all nuts and bolts.

FINAL INSPECTION

1. Check all hydraulic, vacuum, and fuel lines to ensure there is adequate clearance to T.E.S. components.
2. Replace air cleaner assembly and connect battery.
3. At this point it is a good idea to look everything over and make sure that nothing was missed in assembly.
4. Start vehicle and bring up to normal operating temperature. Check for possible leaks.
5. Turn engine off and let cool. Tighten all bolts again.

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