

This instruction sheet is intended to provide assistance during installation of headers. For more detailed information and fitment recommendations for your specific application, please reference our website at: [www.ttiexhaust.com](http://www.ttiexhaust.com)

**\*\*\* PLEASE TAKE TIME TO READ THE INSTALLATION PROCEDURES BEFORE STARTING \*\*\***



TTi Performance Exhaust and Headers  
 Tube Technologies, Inc.  
 Corona, California 92880-1726  
 Product Info / Technical Help (951)371-4878  
 Phone Hours: Monday - Friday  
 8:00am - 4:00pm (Pacific Time)

Footnote #39

### FACTORY ENGINE LOCATIONS

K-members are not all identical and the dimensions must be checked to ensure proper fit. Check your engine location prior to installation of your TTI headers.

TTi headers were designed to fit with engines located to the factory specifications. If the engine is not located correctly in the chassis the headers will not fit properly. If necessary place shims between the insulator assembly and the K-frame mounting pad to achieve the proper factory dimensions. Shim kits and engine mounts can be purchased through Schumacher Creative Services of Seattle, Washington.

From the center of the crankshaft to the top of the K-frame the correct distance is **(A)**. The engine is also offset **(B)** towards the passenger-side. Measure from the center of the crankshaft to each frame rail, the difference should be **(C)**.

<b>Gen2 Hemi: 426, 472, 528</b>	<b>A (inches)</b>	<b>B (inches)</b>	<b>C (inches)</b>
67-76 A-body	6	1	2
62-65 B-body	5-1/4	1-1/2	3
66-74 B-body	5-1/4	1-1/4	2-1/2
70-74 E-body	5-1/4	1-1/4	2-1/2
<b>Small Block / Big Block</b>	<b>A (inches)</b>	<b>B (inches)</b>	<b>C (inches)</b>
63-66 A-body	4-3/4	5/8	1-1/4
67-76 A-body	5-1/4	1-1/4	2-1/2
62-65 B-body	5-1/4	1-1/2	3
66-74 B-body	5-1/4	1-1/4	2-1/2
65-73 C-body	5-1/4	1-3/4	3-1/2
70-74 E-body	5-1/4	1-1/4	2-1/2
<b>Gen3 Hemi: 5.7, 6.1, 6.4</b>	<b>A (inches)</b>	<b>B (inches)</b>	<b>C (inches)</b>
67-76 A-body	5-5/8	1-5/8	3-1/4
67-76 A-body (w/spool mounts)	5-7/8	1-3/16	2-3/8
62-65 B-body	6	1-1/4	2-1/2
62-65 B-body (w/spool mounts)	5-3/8	1-1/4	2-1/2
66-74 B-body	5-3/8	1-1/4	2-1/2
70-74 E-body	5-3/8	1-1/4	2-1/2



TTi Performance Exhaust and Headers  
Tube Technologies, Inc.  
Corona, California 92880-1726  
Product Info / Technical Help (951)371-4878  
Phone Hours: Monday - Friday  
8:00am - 4:00pm (Pacific Time)

## INSTALLATION INSTRUCTIONS

### Part No. TTI 636A

Due to the numerous engine configurations and suspension combinations, TTI cannot ensure headers and exhaust to fit all combinations, however we have done our best to accommodate both factory and aftermarket component combinations. e.g., Engine blocks, cylinder heads, starters, valve covers, etc.

**This instruction sheet is intended to provide assistance during installation of headers. For more detailed information and fitment recommendations for your specific application, please reference our website at: [www.ttiexhaust.com](http://www.ttiexhaust.com)**

**Warning!** We strongly suggest that you use an old set of headers or a set of cast iron manifolds for first engine runs / cam break-ins to avoid coating damage. Excessive heat damage to the ceramic coating will void all warranties.

Header coating damage usually occurs during the first engine run when the exhaust temperatures exceed 1200°F. Excess exhaust temperatures are normally caused by excessively lean or excessively rich air/fuel mixtures and/or incorrect ignition timing.

**Please take all under car safety precautions when** installing headers, including eye protection. When raising vehicle, use an appropriate lifting device and place on jack stands as a safety measure. Caution! Bumper jacks are intended for emergency use only and should not be used to support vehicle.

### Installation

- 1 Disconnect the negative cable from the battery terminal.
- 2 Raise the front of the vehicle with an appropriate lifting device and place on jack stands.
- 3 Disconnect the plug wires and remove all of the spark plugs. Remove the cast iron manifolds and the stock exhaust pipes. If you are installing the complete TTI Exhaust System, then remove and discard your entire stock exhaust system, including hangers.
- 4 Remove the 90° oil filter and the starter motor. Passenger-side, remove and discard the brace between the engine and the transmission.
- 5 Now is a good time to check the condition of your engine mounts. If they are worn or deteriorated, replace them now. When the engine is mounted correctly the headers will fit correctly.
- 6 **Drivers-side Header:** Use a pickle-fork to disconnect the ball joint on the tie rod at the center link and swing away.
  - **Power Steering** – Disconnect the center link from the pitman arm and swing the center link away. Disconnect the steering wheel shaft from the steering box. (Refer to a shop manual for the proper procedure) Disconnect the power-steering hoses and remove the power-steering box. The steering wheel shaft will pass through the header when re-installed.
  - **Manual Steering** – Disconnect the center link from the pitman arm and swing the center link away. Disconnect the steering wheel shaft from the steering box. (Refer to a shop manual for the proper procedure) The steering wheel shaft will pass through the header when re-installed.
  - **Torsion Bar** – Remove the torsion bar. The torsion bar will pass through the header when re-installed. (Refer to a shop manual for the proper procedure)
  - **Standard Transmission** – Remove the Z-bar. The casting ear on the drivers-side will need to be trimmed shorter by 3/8" for header clearance. [Ref. FN #21]
  - Remove the nut from the lower side of the engine mount rubber insulator. Using a floor jack and a block of wood under the oil pan, raise the engine up on the drivers-side approximately 1". Check the cylinder head sealing surface of the exhaust ports to insure they are clean.

**Recommendation when installing header gaskets:** Use a very thin layer of High-Temp Silicone Sealer on each side of gasket.

- Place the supplied header gasket onto position on the studs. Insert the header into position from under the car and let it hang loose by one header bolt. Before bolting to the cylinder head, place the steering box into place and attach with the (3) bolts. Lower the engine and place the header into position on the cylinder head. Use the original studs & nuts or the provided header bolts to secure the header to the cylinder head. Tighten the center bolts first, then the end ports. Torque the bolts to 25ft. lbs. evenly to insure a proper seal.
7. In reverse order, re-install all of the disassembled components. Be extremely careful to re-install all nuts, bolts and pins that were removed. Install motor mount nuts.
  8. **Starter Installation** - Install the starter and connect the wiring. Adjust the wiring to insure that there is absolutely no contact with the header.
  9. **Brake Lines** – Due to variations in the routing of brake lines, it may be necessary to re-position a brake line to achieve adequate clearance from a header tube. A minimum clearance of 1/2" from a header tube is required.
  10. **Passenger-side Header:** Using a pickle fork, disconnect the tie rod at the center link and swing away. Remove the torsion bar. (Refer to a shop manual for the proper procedure) The torsion bar will pass through the header when re-installed.
    - Check the cylinder head sealing surface of the exhaust ports to insure they are clean. Place the supplied header gasket onto position on the studs. Insert the header into position from under the car and let it hang loose on the studs.
    - Place the 90° oil filter adapter onto position and attach with a 3/4" hex head bolt or a modified 1-3/16" hex bolt. [Ref. FN #21]
    - Use the original studs & nuts or the provided header bolts to secure the header to the cylinder head. Check for clearance between the header tubes and the 90° filter adapter hex head bolt. Tighten the center ports header bolts first, then the end ports. Torque the bolts to 25ft. lbs. evenly to insure a proper seal.
    - Now, install the Oil Filter.
  11. Attach the pre-bent designed header adapter/reducers to the header collectors with the nuts, bolts and gaskets provided. The adapter / reducers supplied will only fit 63-66 A-body applications with the modified transmission crossmember. [Ref. FN #29]
  12. In reverse order, re-install all of the disassembled components. Be extremely careful to re-install all nuts, bolts and pins that were removed.
  13. Now that your headers are installed, wipe down the tubes with hot soapy water or an environmentally safe Orange Cleaner Degreaser and a soft cloth to remove any grease or skin oils (finger prints) from the header tube surface. **Never use abrasive cleaners.**
    - It is normal for Chrome plated headers to discolor almost immediately after firing-up engine.
    - To insure years of service from your ceramic-coated headers it is suggested to follow our Header Maintenance & Care procedures.
  14. Re-connect the negative battery cable. Start the engine and check for leaks.

**Note: Re-torque all of the header bolts after approximately 50 miles of driving.**

Coupled with a TTI Exhaust Systems these headers become even more efficient! Visit our website for more information.

Qty.	Parts List
(2)	Header Gaskets
(12)	Header Bolts 5/16-18x1
(2)	Header Reducer Adapters (aluminized tubes with welded 3-bolt flanges)
(2)	3-bolt Collector Gaskets
(6 sets)	Reducer Adapter Hardware (3/8" bolts, nuts & washers)



TTI Performance Exhaust and Headers  
Tube Technologies, Inc.  
Corona, California 92880-1726  
Phone (951) 371-4878

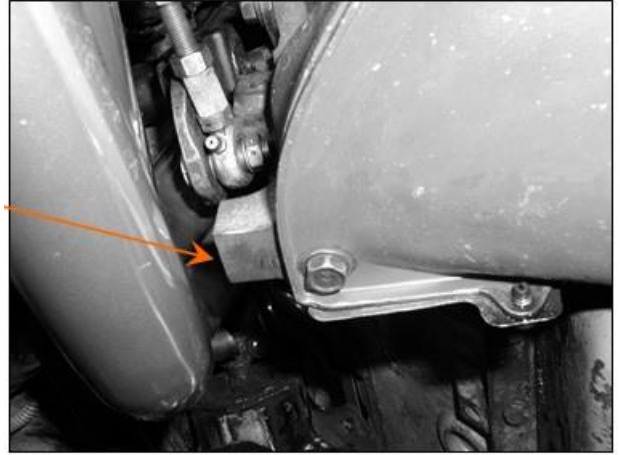
[www.ttiexhaust.com](http://www.ttiexhaust.com)

Footnote #21

## 63-66 A-BODY APPLICATIONS CASTING EAR / HEX BOLT MODIFICATIONS

### a. Casting Ear: Standard Trans applications

The drivers-side casting ear will require trimming by 3/8" for header tube clearance.



### b. Hex Bolt: 90° Oil Filter Adapter bolt

Oil filter adapters are supplied with either a 3/4" or a 1-3/16" hex head mounting bolt. If your adapter came with the 1-3/16" bolt, modification will be required by machining bolt head to .175 thickness.



3/4" - OK



1-3/16" (Machining Required)



Machine to .175 thickness



TTI Performance Exhaust and Headers  
Tube Technologies, Inc.  
Corona, California 92880-1726  
Phone (951) 371-4878

[www.ttiexhaust.com](http://www.ttiexhaust.com)

Footnote #29

## 63-66 A-BODY TRANSMISSION CROSSMEMBER

Modification will be required to the stock transmission crossmember to accommodate a dual exhaust system.



Stock crossmember



Dimensions for modifying a stock crossmember



Modified crossmember

- Modified crossmember available (limited quantities) ÷ call for pricing
- We can modify your stock crossmember ÷ see Transmission Crossmember Modification Request Form



TTi Performance Exhaust and Headers  
 Tube Technologies, Inc.  
 Corona, California 92880-1726  
 Phone (951) 371-4878

[www.ttiexhaust.com](http://www.ttiexhaust.com)

**63-66 A-BODY  
 Transmission Crossmember  
 Modification Request Form**

Modification is required to my stock transmission crossmember to accommodate a dual exhaust system.

Price: \$110.00 (US residents) / \$125.00 (International).

Prices include modification, HP black enamel paint and returning shipping.

Mail this completed form along with your stock crossmember and a Check or Money Order to:

Tube Tech Inc.  
 Dept. CM-Mod  
 1555 Consumer Circle  
 Corona, CA 92880-1726

PLEASE PRINT

Name:

Company/Care Of:

Address:

City:

State/Province:

Zip/Postal Code:

Country:

Phone Number:

\*Email Address:

\*Email address required to receive an Order Confirmation and Shipment Notification.

- Enclosed is a Check or Money Order – Payable to: TUBE TECH INC
- Bill me by emailing me a link to pay through PayPal

Note: TTi will not be responsible for parts damaged in transit due to insufficient packaging.

**Packaging Guidelines and Procedures**

Here are some general packaging guidelines that will help you prepare your package for shipping. You can help make sure that your package arrives safely and on time with these good packaging guidelines and procedures.

- Step 1. Use a Corrugated Box: Whenever possible, use a new box. The more times a box is used, the more it loses its original protective qualities, so a previously used box may not adequately protect your shipment. If you must reuse a box, make sure it is rigid and in excellent condition with no punctures, tears, rips, or corner damage, and that all flaps are intact. Remove any labels and all other shipment markings from the box.
- Step 2. Provide Internal Protection: It's important that you cushion the contents of your package properly. Please be sure that you wrap each item separately. Fragile articles need both suitable separation from each other and clearance from the corners and sides of the box. Each item should be surrounded by at least two inches (5cm) of cushioning and be placed at least two inches (5cm) away from the walls of the box. This will protect your items from product-against-product damage and shield them from the shock and vibration that can be conducted from the exterior of the box to its contents in transit.
- Step 3. Close Your Container Securely: Proper closure of your container is just as important as proper cushioning for the safety and security of your shipment. To close a box securely, do not use masking tape, cellophane tape, duct tape, string, or paper over-wrap. Instead, use a strong tape - two inches (5cm) or more in width, such as Pressure-sensitive plastic or nylon-reinforced tape. Apply three strips to both the top and bottom of the box.
- Step 4. Use Proper Labeling: For fast and efficient delivery, keep these points in mind when labeling your package:
  - Always include the recipient's postal code with the complete street address. For international shipments, include a contact name, telephone number, and postal code.
  - Place the shipping label on the top of the package. To avoid confusion, place only one address label on the package. If you are using a packing slip, place it on the same surface of the package as the address label.
  - Remove or cross out old labels or markings on a used box.
  - Always include your complete return address, including full street address and postal code. For international shipments, include a contact name, telephone number, and postal code.
  - Place a duplicate label or other form of identification inside your package.