

2020+ FORD F250 7.3L

HEADER INSTALLATION INSTRUCTIONS

Thanks for purchasing a Stainless Works Header system for your 2020 + Ford F250 7.3L. Our team has worked to ensure that this product is the premium in performance, quality, and fitment. We are proud to say that this system will unleash the true character of your vehicle. We encourage you to read through the following steps, and check the included Bill of Materials before beginning. Please follow these steps to ensure that your installation goes as planned.

a.

Stainless Works recommends the use of Hi-Temp RTV sensor safe silicone gasket maker as an option or in conjunction with the use of factory gaskets. The recommended Oxygen Sensor Safe RTV is either Valco All-in-One Aluminum or Permatex Copper P/N 101BR available at NAPA, Autozone and other retailers.

b.

Disconnect the battery before starting to work on the exhaust system for your vehicle. Reconnect the battery when the job is completed.

c.

Your exhaust system can be installed by a weekend warrior, but the use of a lift is recommended for ease of installation. If using a jack, the vehicle must be placed on a hard level surface. Jack stands are required for safety.

d.

You will assemble the components together as specified below, but only snug the clamps as you move along from front to back. After aligning all the components in the vehicle, you will tighten all the clamps working from front to back of the vehicle.



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(FT220188/2202HCAT)



Detail a

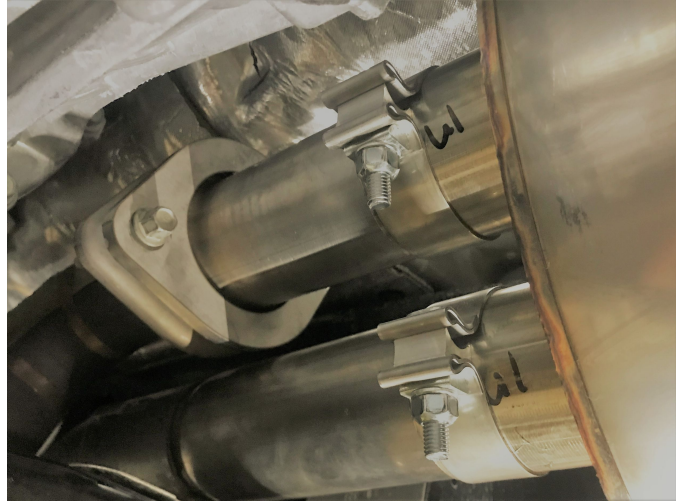
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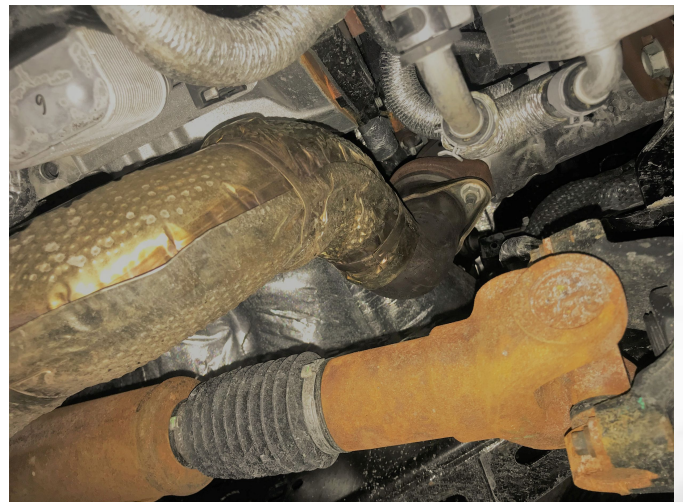
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1. Disconnect the battery.
2. Raise and support the vehicle.
3. Starting behind the catalytic converters, unbolt the exhaust at the 2-bolt flange on the left pipe and loosen the wide clamp on the right side pipe (shown attached to SW catback).
4. Unplug and remove all (4) O₂ sensors.
5. Unbolt the right and left converter pipes from the manifolds. There are (4) 15mm nuts - 2 per side. This will require you to slide the exhaust towards the rear of the vehicle.
6. Remove (16) 15mm nuts - 8 per side - from the left and right manifolds and remove the manifolds from the vehicle.
7. Remove the (8) studs from each side using an E8 socket.
8. Remove the nuts that connect the motor mount to the cross member and raise the motor. On 2011-16 models there are (4) 22mm nuts. On 2017+ models there are (3) 24mm nuts.
9. Apply the RTV sealant to the headers and install each, using the 10mm bolts included in the kit.



Detail 3



Detail 6

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10. Lower the engine and reinstall the motor mount nuts.
11. Install the left side lead pipe using (1) 3" clamp at the header. Assemble the supplied gasket #31556 onto the outlet end.
12. Install the right side lead pipe using (1) 3" clamp at the header.
13. Connect the left side lead pipe to the catback using the 10mm hardware set included in the kit.
14. Connect the right side lead pipe to the catback using the factory clamp (or the clamp supplied from new catback).
15. Install all O₂ sensors.
16. Tighten all clamps and bolts in your header system.
17. Reconnect the battery.



Detail 19: Headers and leads installed



Detail 22: O₂ sensor installed

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18.

Be sure to have adequate clearance around all wires, hoses, and lines. If anything is in contact with the exhaust system it will melt. Make sure to have at least ½" of clearance and wrap any suspect areas with DEI thermal barrier wrap.

19.

After double checking for clearance and making sure all lines, wires and hoses are secured, drive the car for 10-20 miles and re-check all clamps and clearances. Your system may be tack welded at the joints/ clamps to reduce shifting of the system during heating and cooling cycles. Make certain to disconnect the battery before performing any welding.

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