

Installation Instructions

**05-09 4.6L, 3V, Ford Mustang GT
Stainless Steel longtube headers**

S4605R



**Please check Parts List below
to insure that all parts
are included in the product box !**



**Note: anti-seize
should be applied
to all fastener
threads and pipe
slip joints**

***Coated shown, No longer
available.**

Parts List and Description

- (A) -left side header assembly
- (B) -right side header assembly
- (C) -oxygen sensor harness extensions Part# 4604EK (4) - not shown

Hardware List

- (16) header bolts
- (4) 1/4" x 1" bolts
- (4) 1/4" nuts
- (1) anti-seize
- (2) oxygen sensor bungs

Attention! Proper installation of these headers requires the use of Permatex Ultra Copper high-temp silicone sealer, which is NOT included in this kit due to unpredictable shelf life. You need to purchase this sealer at an automotive parts reseller near you.

Installation instructions:

- 1.) Open hood and disconnect negative battery cable from battery.
- 2.) Remove air box assembly from driver side of engine compartment to provide needed space to install header tubes.
- 3.) Raise and support vehicle on a suitable lift as per lift instructions.
- 4.) Disconnect all four oxygen sensor electrical harness connectors and remove sensors from exhaust system with a 7/8 wrench. Mark each sensor so as to enable reinstallation in the same location.
- 5.) Remove all fasteners and clamps attaching stock H-pipe to exhaust manifolds and over-axle pipes. Remove H-pipe from vehicle.
- 6.) Remove all fasteners (nuts and studs) attaching exhaust manifolds to cylinder heads and remove manifolds from engine.
- 7.) Loosely assemble passenger side header on the ground or bench top to obtain a mental picture of the relationship of the header tubes to each other and the collector.
- 8.) Disassemble header assembly and load passenger side header tubes into the car from bottom of engine. Do not bolt any tube to cylinder head until you are able to get all four into approximate position. Exercising patience during this step will help to prevent scratching the header coating.

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Installation instructions continued for S4605R headers:

- 9.) Attach passenger side header tubes to cylinder head using stock gaskets and supplied 8mm header bolts but do not fully tighten until last step. Be sure to use supplied anti-seize compound on bolt threads.
- 10.) Apply a thin coat of Permatex Ultra Copper high-temp silicone to inside of collector slip joints $\frac{3}{4}$ of the way to the bottom and install collector over ends of header tubes with oxygen sensor bung facing driveshaft. Use your finger to evenly spread sealant.
- 11.) Install supplied 1/4" hardware into tabs on collector and corresponding header tubes. Do not tighten fasteners until last step of installation.
- 12.) Proceed to driver side.
- 13.) Loosely pre-assembly header assembly as before to obtain a mental picture of tube positions relative to each other then disassemble.
- 14.) Feed the number 2 header tube between steering column and frame and into its approximate installed position. You will need the assistance of a pry bar to accomplish this as the flange is slightly too large to pass through this point without doing so.
- 15.) Working through the top of engine compartment, install the number 1 header tube into position with the number two header tube. Now attach both header tubes to cylinder head with stock gaskets and supplied fasteners but do not fully tighten until last step.
- 16.) Install number 3 and number 4 tubes into position from underneath vehicle and attach to cylinder head with supplied fasteners; do not fully tighten until last step.
- 17.) Apply a thin coat of Permatex Ultra Copper high-temp silicone to inside of collector slip joints $\frac{3}{4}$ of the way to the bottom and install collector over ends of header tubes with oxygen sensor bung facing driveshaft. Use your finger to evenly spread sealant.
- 18.) Install pre-catalyst oxygen sensors into header collectors and connect to electrical harness with supplied harness extensions.
- 19.) If you are installing headers with a Bassani "X" style crossover pipe, install the crossover pipe as per the included instructions. The two oxygen sensor bungs included with these headers can be used to install these headers with any custom fabricated mid-pipe assembly if you choose to not install a direct fit, Bassani off-road or catalyzed "X" style crossover pipe.
- 20.) Connect rear oxygen sensors installed in Bassani crossover pipe to electrical harness with supplied extensions. It will be required to trim off index lugs from male side of O2 sensor connectors to enable insertion into mating female connector of extension.
- 21.) Tighten all fasteners on left and right header assemblies.
- 22.) Reinstall air filter housing assembly and reconnect negative battery cable.



Passenger side header assembly

Driver side header assembly

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