

# JBA<sup>®</sup> performance exhaust

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## Installation Instructions And Warranty Information

Chevrolet & GMC C/K Pickup & Suburban 7.4L  
1822S 1996-2000 w/o AIR inj, w EGR  
1822S-1 1992-95 2500/3500 C/K , All Suburban  
1823S 1996-2000 w AIR Inj, w EGR



The product accompanying this document has been granted a California Air Resources Board (CARB) exemption, an "E.O." number, or is a direct or consolidated replacement part. It is 50-state legal, when installed on the appropriate vehicles per the manufacturer's application guide.

**Down Pipes Part # 1821SY or 1822SY required for installation and to remain Emissions Compatibility (shown in Pic.)**

**Read all instructions carefully before attempting installation.**

**PerTronix® thanks you for choosing JBA HEADERS, the best fitting, highest quality header on the market. In order to realize the full potential of our good fit, please read and understand these instructions completely prior to starting work.**

**Check to make sure you received the proper parts for your application. The header number will be stamped on the engine flange. If you are unsure you have received the proper parts call before you start work.**

**Be sure to work safe! Whenever you work under the vehicle be sure that it is located on level, solid ground and is supported by adequate safety stands! Remember: Hot asphalt will not support most jack stands!**

**Many factors affect the installation of headers, some of which are broken or aftermarket motor mounts, accidents that impact the configuration of the frame, and/or the installation of different engines or aftermarket cylinder heads.**

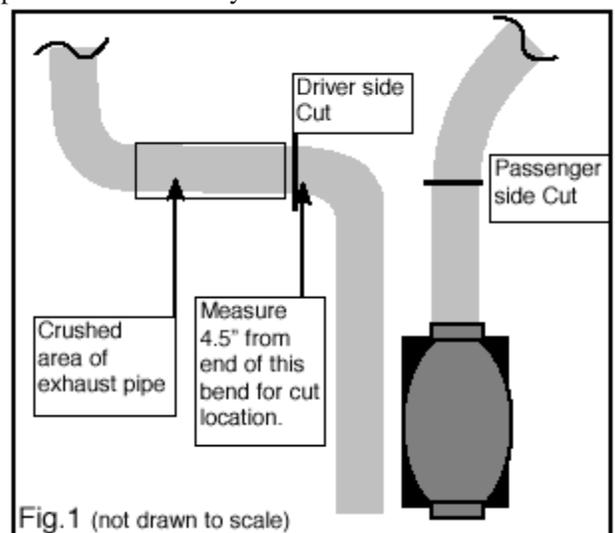
**Attention Customers breaking in new engines: Due to the extreme heat generated during the break-in process, the appearance of the ceramic coating may be altered in certain areas. The protection characteristics and thermal barrier properties of the coating is never compromised. It is recommended that a cast iron manifold or old set of headers be used for this process.**

**Notice: The coating of these headers can be marred or scratched during installation. If the header needs to be returned and is damaged, you will be charged for recoat.**

JBA uses sealing beads on all its headers. We have found that when installed correctly, the raised bead around each port increases the pressure exerted on the gasket directly adjacent to the port and effectively prevents leaking gaskets. It is normal for the flange to be raised off the cylinder head the thickness of the sealing bead. It is important when installing the header, to install all bolts loosely, then tighten evenly to ensure the flat installation of the flange. The torque sequence from one flange to another will vary, but generally every bolt on a header should be first fit snug, starting from the inside of the flange working out, alternating from top to bottom so that the bolt connects the flange to the manifold to the point where they barely touch. Second, using the same inside-out pattern, tighten each bolt until finished. This method will help prevent leakage and will give the user the best possible performance out of their pair of headers.

1. Place vehicle in a location where the floor is solid and flat, with adequate lighting. Do not attempt to work on a hot engine. Heat causes metal to expand and makes removal of fasteners difficult at best. If necessary, raise the front of the vehicle to obtain adequate access to the bottom exhaust manifold flanges. Use large-base jack stands to support the vehicle. Do not rely on the jack! Block the tires to prevent the vehicle from rolling off the jack stands.
2. Disconnect the negative battery cable from the battery. Apply penetrating oil on all accessible fasteners and fittings before attempting to remove them.
3. Unplug the (4) O<sub>2</sub> Sensors from the harnesses. Remove the exhaust connector pipe but unbolting from the stock manifolds and the flange just in front of the muffler. Set side and be careful not to bump the O<sub>2</sub> sensors.
4. Disconnect the spark plug wires by grasping and gently twisting the spark plug wire boots. Remove the spark plugs.
5. On CA A.I.R. equipped trucks, remove the A.I.R. tubes from the stock manifolds.
6. On the Driver's side disconnect the EGR tube from the rear of the exhaust manifold. Remove the bolts holding the manifold to the head and remove the manifold.

7. On the Passenger Side remove the dipstick. The dipstick bolts to the head on the topside and press-fits into the oil pan on the bottom side. Unbolt the dipstick bracket and gently wiggle the dipstick tube upward out of the pan. Remove the flexible hot air tube attached to the heat riser tube. Unbolt the heat riser tube. Unbolt the manifold from the head and remove.
8. Remove the gaskets and any gasket material or any carbon deposits that remain on the head surface. The use of a gasket removal agent or scraper will ease the removal of any gasket material. Use care not to get debris into ports or spark plug holes.
9. Test fit the passenger side header. On some models, the heat shield under the passenger floor pan comes close to the collector flange. If necessary, clearance the heat shield slightly.
10. Using the gasket and hardware supplied, bolt both headers to the head. Torque the fasteners to factory specifications. (30-35 ft. Lbs.)
11. Install the EGR tube at the back of the header. On CA models with A.I.R. reinstall the Air Injection tubes.
12. Re-install the heat riser tube so that the tube is allowed to draw hot air from around the header.
13. On vehicles equipped with factory spark plug wires, 4 spark plug boots and terminals must be changed using the supplied parts. On the driver's side, the 3 forward boots must be changed. On the passenger, the second boot back must be changed.
14. Reinstall the plug wires. Reinstall the dipstick tube.
15. Check the clearance of all battery cables and wiring looms to insure that they are not too close to the headers.
16. JBA down pipes are required to complete the exhaust installation, part #1821SY / 1822SY sold separately. Refer to the illustration below. Temporarily install down pipes on headers, carefully measure the distance from the rear converter flange (ahead of muffler) to the end of the passenger side down pipe. Add 2 inches to this measurement. Now cut the converter pipe ahead of the catalytic converter using the measurement taken (+2"). On the passenger side measure approximately 4 1/2 inches from bend and make cut. Install the converter assembly by sliding the expanded pipes over the down tubes. Check for clearance on everything. If clearance is good weld the pipes into place using MIG process. (Converter pipes are stainless steel, oxyacetylene welding is NOT recommended!) Install the converter assembly using the supplied hardware and gaskets. Reconnect all 4 O2 sensor plugs.
17. Check to make sure that all the wiring, fuel lines, transmission cooler lines, brake lines, hoses, etc. are clear of the headers or any exhaust components and reroute or relocate those components as necessary.
18. Reconnect the negative battery cables.
19. Start the engine and let it warm up, test drive. Check for leaks. Shut engine off and let it cool down. Check to make sure all fasteners are tight.
20. Periodically check and retighten the header bolts.



Parts List:

- (1) Driver's Side Header Assembly
- (1) Passenger's Side Header Assembly
- (16) 3/8 "x 1 "header bolts & lock washers
- (2) Header gaskets (Header to Head flange)
- (4) Spark plug boots and terminals

1821SY / 1822Y Down pipes (Required, sold separately)

- (1) Passenger side down pipe
- (1) Driver side down pipe

 440 E. Arrow Hwy. San Dimas, CA 91773 (909) 599-5955	This vehicle is equipped with: <b>Dougs Headers # D33XX</b> <b>JBA Headers # 18XXS</b>
	Legal for sale and installation in California <b>CARB EXECUTIVE ORDER</b> <b>D-57-19 &amp; D-57-25</b>

**WARNING**

This label is required to aid in passing the California smog check program. This label must be installed in an underhood location that is readily visible.

**LIMITED ONE YEAR WARRANTY**

All JBA HEADERS and exhaust products are guaranteed, to the original purchaser, to be free of defects in materials and workmanship for one year. This warranty covers the replacement or repair of the product only and does not cover the cost of removal and installation, customer applied aftermarket coatings or any discoloration or corrosion of finished surfaces.

Damage or product failure resulting from collision, improper installation, off-road use, road hazards, the use of exhaust insulating wrap or like products or rust occurring after installation, is not covered by the warranty. The warranty extends only to the original purchaser.

Should a part become defective it should be returned to the original selling retailer and must be accompanied with the sales receipt. If there is no retailer in your area, call the factory for a return authorization and return your part prepaid to the factory for inspection. PerTronix reserves the rights to replace or repair the alleged defective part and return the part freight collect.



