



## TUBULAR EXHAUST SYSTEM

**Applications: See Below**

**Catalog #66002, #66003**

## INSTALLATION INSTRUCTIONS

Please study these instructions carefully before installing your new *Tubular Exhaust System* (TES). If you have any questions, please contact our **Technical Hotline at : 1-800-416-8628** from 7 am - 5pm, Monday-Friday, Pacific Standard Time or e-mail us at **[Edelbrock@Edelbrock.com](mailto:Edelbrock@Edelbrock.com)**.

**APPLICATIONS:** For 1999-2001 GM Pick-Up 1500/2500 Series, 1999-2001 Suburban, Tahoe, Yukon, 4.8L/5.3L L-V8 without A.I.R., 2WD & 4WD.

**TUBULAR EXHAUST SYSTEM:** These components are designed to improve the exhaust efficiency of the GM C.P.I. (Central Port Injection) V8 engine. A performance gain can be expected by the installation of the system. **This system does require welding for installation** and retains all O.E.M. emissions equipment.

**Suggested Tools Needed for Installation:** This vehicle has metric fasteners.

- ☐ Mig welder (recommended) or gas welder—Professional welding is highly recommended
- ☐ 3/8" ratchet socket set with extensions and universal 13mm and 15mm swivel sockets
- ☐ Combination set of open-end wrenches
- ☐ Jackstands, screwdrivers, pliers, crescent wrench, etc.
- ☐ Hacksaw or Sawz-all
- ☐ Liquid penetrant, (GM #1052627) anti-seize compound (GM #5613695)

**SPECIAL NOTICE:** This Edelbrock Tubular Exhaust System has received an Executive Order number (E.O.#) from the California Air Resources Board (C.A.R.B.) making it legal for street use in all 50 states. To assist you with emission equipment certification, we have included a silver fan shroud decal to help testing personnel verify the this part is a legal replacement on the vehicle for which it is cataloged. The adhesive-backed decal should be affixed next to the existing emission and engine specifications decal. Do not cover any part of your original emission decal.

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

**NOTE:** High temperature spark plug wires and boots are recommended to withstand heat from T.E.S.

### IMPORTANT NOTE:

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

### KIT CONTENTS

**Catalog #66002 (Ceramic-Coated), #66003 (Ti-Tech Coated)**

Qty.	Description
<input type="checkbox"/> 1	Header left side #25-9433 (#66002)
<input type="checkbox"/> 1	Header right side #25-9434 (#66002)
<input type="checkbox"/> 1	Header left side #25-9031 (#66003)
<input type="checkbox"/> 1	Header right side #25-9032 (#66003)
<input type="checkbox"/> 1	Extension pipe left #25-9529
<input type="checkbox"/> 1	Extension pipe right #25-9530
<input type="checkbox"/> 12	Hex header bolts; 8mm x 1.25 x 30mm
<input type="checkbox"/> 2	Port gaskets

Qty.	Description
<input type="checkbox"/> 2	Donut gaskets; 2-1/4"
<input type="checkbox"/> 4	Hex capscrews; 2-1/4"
<input type="checkbox"/> 4	Lock washers; 3/8"
<input type="checkbox"/> 4	Flat washers; 3/8"
<input type="checkbox"/> 1	E.G.R. gasket
<input type="checkbox"/> 12	Lock washers; 5/16"
<input type="checkbox"/> 12	Hardened washers

## INSTALLATION INSTRUCTIONS

### • DISASSEMBLY

1. Disconnect negative battery cable.
2. Raise vehicle and remove front two O2 sensors, being careful not to damage. **NOTE:** Before cutting exhaust pipes from catalytic converter on both sides, determine the position of catalytic inlet for re-installation. Use chalk line on bottom of floorboard to show position of catalytic converters and measure height from floorboard.
3. Cut both exhaust pipes approximately 1/2" in front of weld on catalytic converters (**See Fig. 1**).
4. Unbolt and remove exhaust pipes from exhaust manifolds.

### • RIGHT SIDE

1. Disconnect and remove spark plug wires.
2. Disconnect E.G.R. flange.
3. Unbolt dipstick tube.
4. Unbolt and remove manifold.
5. Install T.E.S. flange gasket and TES manifold from top. Install header bolts supplied and leave loose enough to ensure proper alignment. **NOTE:** Use flat washers and lock washers on all bolts.
6. Install E.G.R. flange using supplied gasket.
7. Re-install spark plug wires.
8. Re-fasten dipstick tube.

### • LEFT SIDE

1. Disconnect and remove spark plug wires.
2. Unbolt and remove manifold.
3. Unbolt and separate steering shaft at mid-section.
4. Install T.E.S. flange gasket and T.E.S. manifold from top.
5. Install header bolts supplied to ensure proper alignment and tighten bolts.
6. Re-connect steering shaft.
7. Re-install spark plug wires.
- **NOTE:** Below are specific instructions for the installation of the extension pipes provided in this system. Be sure you are following the instruction steps that apply to the vehicle you are working on.

### • ASSEMBLY OF EXTENSION PIPES ON GM PICK-UP

1. Install extension pipes to headers with donut gaskets, 3/8" x 2" bolts and lock washers supplied in kit. Be sure to locate donut gasket with equal space all around for best seal (**See Fig. 2**). **NOTE:** Be sure to have the correct pipe on each side of the catalytic assembly, or it will not set right. I.D. stamped on part: 25-9530-right, 25-9529 left.
2. Align catalytic converters with extension pipes.
3. With everything in its place, weld pipes to catalytic converters.
4. Re-install O2 sensors.

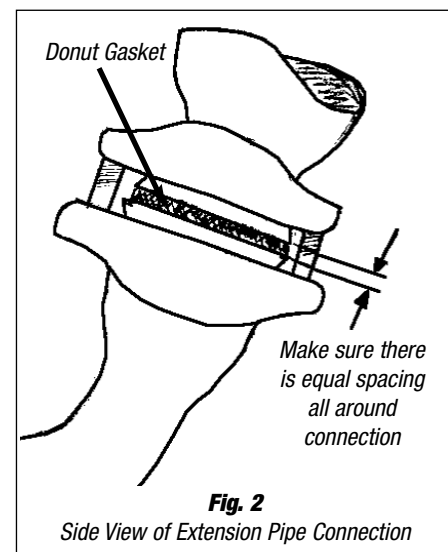
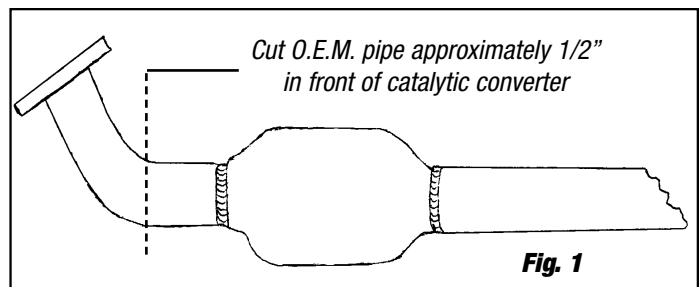
### • ASSEMBLY OF EXTENSION PIPES ON SUBURBAN, TAHOE AND YUKON

1. Locate the right side extension pipe (#25-9530), cut approx. 1" to 1-1/4" off the outlet end. Bolt the extension pipe to the right side header with the donut gasket. Two 3/8" x 2" bolts and lockwashers supplied in kit (**See Fig. 2**).

2. Align the right side catalytic converter up with the extension pipe. Check for clearance between transmission crossmember and exhaust system approx. 1" to 1-1/2".
3. Locate the left side extension pipe (#25-9529), cut approx. 1/2" to 3/4" off of the outlet end. Bolt the extension pipe to the left header with 3/8" x 2" bolts and lock washers supplied in kit. (**See Fig. 2**).
4. Align the left side cat converter up with the extension pipe.
5. Re-check the alignment of both sides. In addition re-check the clearance between exhaust system crossmember, frame, etc. **NOTE:** A good way to check that the installation was done properly is to look at the rubber exhaust system hangers which suspend the exhaust system under the vehicle. These rubber hangers should hang relatively straight down.
6. Once everything mentioned above has been done, weld the extension pipes to the inlet of the catalytic converters. Weld completely around the pipe.
7. Re-install O2 sensors, use antiseize.

### • FINAL INSPECTION

1. Check all lines (hydraulic, vacuum, air conditioning and fuel) to ensure there is adequate clearance to T.E.S. components.
2. Re-connect battery.
3. At this point is 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.



Edelbrock Corporation, 2700 California St., Torrance, CA 90503

Tech Line: 1-800-416-8628

E-Mail: Edelbrock@Edelbrock.com