



## TUBULAR EXHAUST SYSTEM

Vehicle Applications: See Below

**Catalog #68272, #68273**

## 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 1979-1980 Chev./GMC Pick-Up Trucks 1500 Series , 350 C.I.D. V8, 2 WD, Auto Transmission, with A.I.R.
- For 1981-1987 Chev./GMC Pick-Up Trucks & Suburban, 1500/2500 Series, 305 & 350 C.I.D. V8, 2 WD, Auto & Standard Transmission with A.I.R.

**TUBULAR EXHAUST SYSTEM:** These components are designed as a system to improve the exhaust efficiency of the GM 305/350 c.i.d. V8 engines. A performance gain can be expected by the installation of the system. This system retains all O.E.M. emissions equipment. This system requires welding an extension (supplied) to the heat riser valve actuating rod (1979-80 only). If welding equipment is not available, use the services of a professional for installation of the extension.

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

- ☐ 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.
- ☐ Liquid penetrant, (GM #1052627) anti-seize compound (GM #5613695)
- ☐ Gas welding equipment

**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.***

## INSTALLATION INSTRUCTIONS

### • DISASSEMBLY

1. Disconnect battery negative cable from battery.
2. Raise vehicle and support with jackstands.
3. Use penetrating oil on all nuts and bolts to be removed. This will prevent the possibility of broken or stripped nuts and bolts.
4. Making sure the converter is cool, remove the exhaust crossover pipe.
5. Remove Heat Riser valve from right side manifold. Put aside for re-use.
6. Remove exhaust pipes from manifold and catalytic converter.

### • LEFT SIDE

7. Remove air cleaner system (note position of line and hose connections).
8. Disconnect A.I.R. (air injection reactor) tube from exhaust manifold .
9. Remove air conditioner compressor rear support bracket (if air conditioning equipped).
10. Remove power steering pump support bracket (if power steering is applicable).
11. Disconnect spark plug wires and remove spark plugs.
12. Disconnect temperature sensor wire.
13. Remove bolts and exhaust manifold from top side.

### • RIGHT SIDE

14. Disconnect A.I.R. injection tube from exhaust manifold.
15. Disconnect spark plug wires and remove spark plugs.
16. Remove bolts and exhaust manifold from top side.
17. Clean exhaust flange surfaces on cylinder heads at this time.

### • ASSEMBLY - LEFT SIDE

1. Install O2 sensor plug in left side manifold (1979-80 only).
2. Install T.E.S. flange gasket and one 3/8"-16 x 1" bolt, lock washer, and flat washer at rearmost bolt hole (leave bolt loose enough to accept T.E.S.).
3. Install left side T.E.S. manifold from top side.
4. Install all but the front two bolts and washers on left side (do not tighten at this time).
5. Re-install rear power steering support bracket. Do not tighten at this time.

6. Install rear A/C support bracket with bolts, lock washers, and spacers supplied. Spacer required for long compressor only.
7. Align all parts and tighten left side bolts and nuts at this time.
8. Re-install spark plugs and re-connect wires on left side.
9. Re-install temperature sensor wire to temperature sensor.

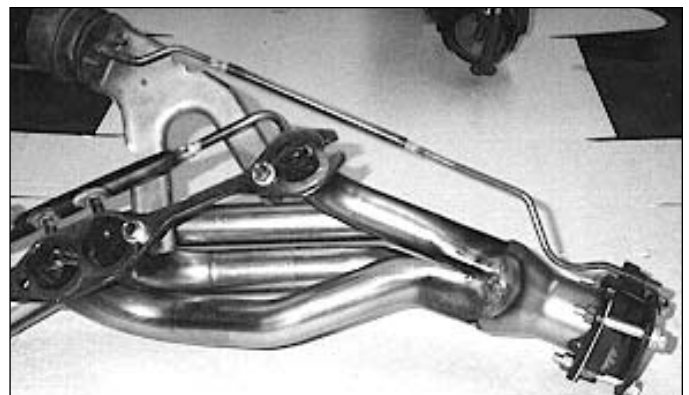
### • RIGHT SIDE PREPARATION (1979-80 applications only)

1. Prepare right side manifold prior to installation as shown in **Fig. 1 and Fig. 2**.
2. Cut the heat riser valve actuating rod with a hack saw about 5" from the bottom of the vacuum unit.
3. Install vacuum unit and bracket to T.E.S. manifold on bench. Use nuts, bolts and spacers supplied in kit (**See Fig. 1**).
4. Use extension supplied to connect the two halves of the actuating rod as shown in **Fig. 2**.



**Fig. 1**

**Assemble heat riser valve vacuum pod and bracket to manifold (1979 - 1980 Only)**



**Fig. 2**

**Cut and extend actuating rod as shown (1979-1980 Only)**

5. Bend rod/extension as necessary so that rod comes straight out of vacuum pod with no binding.
6. Weld extension to actuating rod.
7. Disassemble components and continue installation.

#### • ASSEMBLY - RIGHT SIDE

1. Install T.E.S. flange gasket and one 3/8"-16 x 1" bolt, lock washer and flat washer at rearmost bolt hole (leave bolt loose enough to accept T.E.S.).
2. Install right side T.E.S. manifold from top side.
3. Install vacuum pod and bracket using bolts and 1-1/8" spacers supplied (1979-80 only). For 1981 and later, cut heat riser metal tube as shown in **Fig. 3**. Install remaining bolts and lock washers.
4. Align all parts and tighten all right side bolts at this time.
5. Re-install spark plugs and re-connect wires.
6. Remove A.I.R. check valves from original manifolds and re-install them on T.E.S. With 3/4" hose supplied in kit, re-connect all A.I.R. injection hoses at this time (1979-80). For 1981-1986 applications, remove OEM formed hose from left side and use on the right side TES manifold; use 5/8" hose supplied on left side TES manifold.
7. Raise vehicle and support with jackstands.

#### • CROSSOVER PIPE ASSEMBLY

1. Install heat riser valve and extended actuating rod (1979-80 only). On 1981-1986, connect heat riser vacuum pod using 1/4" vacuum hose supplied.
2. Carefully align and tap adapter tube into converter using a piece of wood or a mallet to protect the end of the adapter. **NOTE:** Be sure adapter goes all the way in, approximately 2-1/2".
3. Install crossover pipe assembly on vehicle using four 3/8" x 2" bolts with lock washers and donut gaskets supplied.
4. Install U-clamps and tighten all nuts and bolts.



**Fig. 3**

**Cut heat riser tube as shown for use with extended hose (1981 & Later only)**

#### KIT CONTENTS

**Catalog #68272 (Ceramic-Coated), #68273 (Ti-Tech Coated)**

Qty.	Description
☐ 1	Header left side #25-9443 (#68272)
☐ 1	Header right side #25-9442 (#68272)
☐ 1	Header left side #25-9061 (#68273)
☐ 1	Header right side #25-9062 (#68273)
☐ 1	Extension Y-pipe #25-9565
☐ 1	Extension crossover pipe #25-9567
☐ 1	Extension adapter pipe #25-9566
☐ 2	Chevy V8 port gaskets
☐ 1	Donut gasket
☐ 1	Heat riser gasket
☐ 1	O2 Sensor plug
☐ 1	U-clamp; 3"
☐ 1	U-clamp; 2-1/4"
☐ 4	Flat washers; 3/8"
☐ 9	Hex header bolts; 3/8" x 1"

Qty.	Description
☐ 2	Hex header bolts; 3/8" x 2"
☐ 1	Hose connector; 3/4"
☐ 1	Spacer tube; 5/8" O.D. x 3/4" long
☐ 3	Spacer tubes; 5/8" O.D. x 1-1/8" long
☐ 3	Hex nuts; 3/8" - 16
☐ 2	Hex bolts; 3/8" x 2"
☐ 2	12-point head bolts
☐ 1	Vacuum hose; 1/4" x 15"
☐ 1	Hose (A.I.R.); 5/8" x 16"
☐ 1	Hose (A.I.R.); 3/4" x 13"
☐ 3	Hex bolts; 3/8" x 3-1/4"
☐ 3	Hex bolts; 3/8" x 2-1/2"
☐ 1	Air conditioning bracket
☐ 1	Heat riser extension tube; 3/8" x 6"
☐ 17	Lock washers; 3/8"

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