



**TUBULAR EXHAUST SYSTEM**  
**Vehicle Applications: See Below**  
**Catalog #68642, #68643**  
**#68652, #68653**  
**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)**. Please fill out and mail your warranty card.

**TUBULAR EXHAUST SYSTEM:** These components are designed as a system to improve the exhaust efficiency of the GM T.B.I. (Throttle Body Injection) V6 engine. A performance gain can be expected by the installation of the system. This system does not require welding for installation and retains all O.E.M. emissions equipment.

**APPLICATIONS:**

**Catalog #s 68642 / 68643** - 1987-1991 Chevy/GMC Suburban 1500/2500 Series with, 5.7L V8 T.B.I., 2 & 4 W.D., Auto and Standard Transmission without A.I.R.

**Catalog #s 68652 / 68653** - 1987-1991 Chevy/GMC Suburban 1500/2500 Series with, 5.7L V8 T.B.I., 2 & 4 W.D., Auto and Standard Transmission with A.I.R.

**Suggested Tools Needed for Installation:** This vehicle has some 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)

**NOTE:** Some models will require a special power steering pulley puller; K-D 2897 or equivalent.

**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. Lower vehicle to the ground.

### DISASSEMBLY LEFT SIDE

1. Remove air cleaner system (note position of line and hose connections).
2. Disconnect A.I.R. (air injection reactor) tube from exhaust manifold (#68652 & #68653 only).
3. Remove air conditioner compressor rear support bracket (if air conditioning equipped).
4. Remove power steering pump support bracket (if power steering is applicable).
5. Disconnect spark plug wires and remove spark plugs.
6. Remove O2 sensor, being careful not to rupture or destroy the unit.

**WARNING:** Do not clean this unit in any cleaning solvent and do not rupture wire.

7. Disconnect temperature sensor wire.
8. Remove bolts and exhaust manifold from top side.

### DISASSEMBLY RIGHT SIDE

1. Disconnect A.I.R. injection tube from exhaust manifold (#68652 & #68653 only).
2. Disconnect spark plug wires and remove spark plugs.
3. Remove bolts and exhaust manifold from top side.
4. Clean exhaust flange surfaces on cylinder heads at this time.

### ASSEMBLY LEFT 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 left side T.E.S. manifold from top side.
3. Install all but the front two bolts and washers on left side (do not tighten at this time).

4. Re-install rear power steering support bracket. Do not tighten at this time.
5. Re-install rear A/C support bracket with bolts, lock washers, and spacers supplied.
6. Align all parts and tighten left side bolts and nuts at this time.
7. Re-install spark plugs and re-connect wires on left side.
8. Re-install temperature sensor wire to temperature sensor.
9. Re-install O2 sensor. Use anti-seize on threads of sensor and torque to 30 ft./lbs. Re-route O2 sensor wire from wire loom to O2 sensor making sure all wires are clear of exhaust system (O2 sensor extension wire is included in kit).

### 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 remaining bolts, lock washers, and spacer tube for dipstick to clear exhaust flange.
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 hose supplied in kit, re-connect all A.I.R. injection hoses at this time ((#68652 & #68653 only).
7. Raise vehicle and support with jackstands.

### CROSSOVER PIPE ASSEMBLY

1. 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".
2. Install crossover pipe assembly on vehicle using four 3/8" x 2" bolts with lock washers and donut gaskets supplied.
3. Install U-clamps and position for maximum ground clearance, then tighten all nuts and bolts.

**KIT CONTENTS****Catalog #68642, Catalog #68643 (Ti-Tech Coated)**

Qty.	PN	Description
<input type="checkbox"/> 1	25-9431	Header left side (#68642)
<input type="checkbox"/> 1	25-9430	Header right side (#68642)
<input type="checkbox"/> 1	25-9028	Header left side (#68643)
<input type="checkbox"/> 1	25-9023	Header right side (#68643)

**KIT CONTENTS****Catalog #68652, Catalog #68653 (Ti-Tech Coated)**

Qty.	PN	Description
<input type="checkbox"/> 1	25-9429	Header left side (#68652)
<input type="checkbox"/> 1	25-9428	Header right side (#68652)
<input type="checkbox"/> 1	25-9028	Header left side (#68653)
<input type="checkbox"/> 1	25-9019	Header right side (#68653)

**KIT CONTENTS****Common to All Part Numbers**

Qty.	PN	Description
<input type="checkbox"/> 1	25-9526	Extension pipe left side
<input type="checkbox"/> 1	25-9527	Extension pipe right side
<input type="checkbox"/> 1	-	Pigtail O2 sensor; 12"
<input type="checkbox"/> 4	-	Flat washers; 3/8"
<input type="checkbox"/> 1	-	O2 Sensor plug
<input type="checkbox"/> 12	-	Hex header bolts; 3/8" x 1"
<input type="checkbox"/> 2	-	Ferry bolts; 3/8" x 2-3/4"
<input type="checkbox"/> 1	-	Flange connector
<input type="checkbox"/> 1	-	U-Clamp; 2-1/4"
<input type="checkbox"/> 1	-	U-Clamp; 3"
<input type="checkbox"/> 2	-	Chevy V6 port gaskets
<input type="checkbox"/> 2	-	Donut gaskets; 2-1/4"
<input type="checkbox"/> 1	-	Hose (A.I.R.); 5/8" x 30" (#68652 & #68653 only)
<input type="checkbox"/> 1	-	Hex bolt; 1/4"-20 x 1"
<input type="checkbox"/> 4	-	Hex bolt; 3/8"-16 x 2"
<input type="checkbox"/> 1	-	Adapter; catalytic converter
<input type="checkbox"/> 1	-	Spacer tube; 3/8" O.D. x 1/2" long
<input type="checkbox"/> 2	-	Spacer tube; 5/8" O.D. x 1-1/2" long
<input type="checkbox"/> 16	-	Lock washers; 3/8"

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