



TUBULAR EXHAUST SYSTEM

For 1993-1995 Chevy/GMC Pick-Up, 1500 Series, 2 & 4 WD,
Auto & Standard Transmission with 4.3L V6 T.B.I. without A.I.R.
Catalog #68982, #68983

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**. Please fill out and mail your warranty card.

TUBULAR EXHAUST SYSTEM: These components are designed 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 require welding for installation and retains all O.E.M. emissions equipment.

Suggested Tools Needed for Installation: This vehicle has some 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.
- ☐ Hacksaw.
- ☐ 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.

KIT CONTENTS

Catalog #68982 (Ceramic-Coated), #68983 (Ti-Tech Coated)

Qty.	PN	Description
☐ 1	25-9439	Header left side (#68982)
☐ 1	25-9438	Header right side (#68982)
☐ 1	25-9051	Header left side (#68983)
☐ 1	25-9052	Header right side (#68983)
☐ 1	25-9586	Extension pipe left side
☐ 1	25-9587	Extension pipe right side
☐ 10	36-0710	Hex header bolts; 3/8" 16 x 1
☐ 2	36-6438	Ferry bolts: 3/8" x 2-3/4"
☐ 1	46-1060	Flange connector
☐ 3	-	Flat washers; 3/8"

Qty.	PN	Description
☐ 1	52-8097	O2 Sensor plug
☐ 1	68-1330	Hex cap screw 1/4-20 x 1
☐ 4	68-8550	Hex cap screw 3/8"-16 x 2"
☐ 1	25-9604	Spacer tube; 3/8" O.D. x 1-1/2" Long
☐ 2	25-9605	Spacer tube; 5/8" O.D. x 1-1/2" Long
☐ 14	82-5590	Lock washers; 3/8"
☐ 2	54-0262	Gasket manifold port
☐ 2	54-0414	Donut gaskets 2-1/4"
☐ 1	46-5183	U-clamp; 2-1/4"
☐ 2	-	Spark plug connector boots
☐ 2	-	Spark plug terminal ends

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, unbolt cat. rear flange and remove crossover pipe flange bolts. Remove the exhaust crossover/cat. assembly.

DISASSEMBLY - LEFT SIDE

1. Remove air cleaner system (note position of line and hose connections).
2. Remove air conditioner compressor rear support bracket (if air conditioning equipped).
3. Remove power steering pump support bracket (if power steering is applicable). In order to remove the OEM bracket attached with the 2 front exhaust manifold bolts on some models, it may be necessary to remove the power steering pump pulley. This requires the use of a special power steering pulley puller, such as K-D 2897 or equivalent.
4. Disconnect spark plug wires and remove spark plugs.
5. 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.

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

DISASSEMBLY - RIGHT SIDE

1. Disconnect spark plug wires and remove spark plugs.
2. Remove bolts and exhaust manifold from top side.
3. 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 accessory bracket which mounts to the first two bolt holes on left side with 2-3/4" ferry bolts, lock washers, and 1-1/2" spacers supplied. Use the spacers

only between the manifold flange and the accessory bracket; use a 3/8" lockwasher under the head of the ferry bolt.

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. Install new 90° spark plug terminals on wire #1.
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.

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 dip stick 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. Install new 90° spark plug terminals on wire #6.

CROSSOVER PIPE ASSEMBLY

1. Cut O.E.M. exhaust pipe approximately 1/2" to 3/4" in front of catalytic converter.
2. Bolt catalytic converter back into vehicle with front in original location.
3. Install T.E.S. pipe into catalytic converter inlet and bolt to T.E.S. manifold using donut gaskets provided.
4. With everything in place tack weld T.E.S. to catalytic converter. **NOTE:** T.I.G. welding is desirable but gas welding can be used.
5. After tack welding, remove assembly and complete weld.
6. Re-install assembly and tighten all bolts.
7. Check all wires and lines for adequate clearance.

FINAL INSPECTION

1. Check all hydraulic, vacuum, and fuel lines to ensure there is adequate clearance to T.E.S. components.
2. Re-connect battery.
3. At this point it 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 off engine and let cool. Tighten all bolts again.

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