



M-9430-F542
1999-03 F150 and 2000-04 F250 5.4L 2V SS Shorty Headers
INSTALLATION INSTRUCTIONS

NO PART OF THIS DOCUMENT MAY BE REPRODUCED WITHOUT PRIOR AGREEMENT AND WRITTEN PERMISSION OF FORD RACING PERFORMANCE PARTS.

Please visit www.fordracingparts.com for the most current instruction information

!!! PLEASE READ ALL OF THE FOLLOWING INSTRUCTIONS CAREFULLY PRIOR TO INSTALLATION. AT ANY TIME YOU DO NOT UNDERSTAND THE INSTRUCTIONS, PLEASE CALL THE FORD RACING TECHLINE AT 1-800-367-3788 !!!

OVERVIEW:

This kit is designed for the use in 1999-03 F150s and 2000-04 F250s with 5.4L 2V engines. The use of a floor hoist is recommended. If you do not have access to one, use a hydraulic floor jack and jack stands to raise the vehicle.

!!! CAUTION: JACK STANDS MUST BE USED ON A LEVEL SURFACE AND BE SECURELY SEATED. FAILURE TO DO SO MAY RESULT IN PERSONAL INJURY OR VEHICLE DAMAGE !!!

!!! CHECK HEADER KIT CONTENTS BEFORE STARTING WORK ON VEHICLE !!!

PARTS INCLUDED IN KIT:

- (16) M8 x 20mm header bolts
- (4) M10 x 1.5 x 65mm exhaust studs
- (4) M10 x 1.5 stud nuts
- (1) Left header
- (1) Right header
- (2) Port gaskets
- (1) Instruction Sheet

INSTALLATION INSTRUCTIONS:

!!! PERFORM THE FOLLOWING WORK ON A COLD VEHICLE ONLY !!!

- STEP 1:** Disconnect negative battery cable.
- STEP 2:** Disconnect HEGO sensors (1 per side).
- STEP 3:** Disconnect CMS sensors (1 per side).
- STEP 4:** Remove oil dipstick tube (1 fastener on cylinder head).
- STEP 5:** Remove upper transmission dipstick tube bolt. DO NOT remove dipstick tube, leave loose.
- STEP 6:** Support transmission.
- STEP 7:** Remove nuts from transmission mount (2).

Factory Ford shop manuals are available from Helm Publications, 1-800-782-4356



M-9430-F542 1999-03 F150 and 2000-04 F250 5.4L 2V SS Shorty Headers INSTALLATION INSTRUCTIONS

NO PART OF THIS DOCUMENT MAY BE REPRODUCED WITHOUT PRIOR AGREEMENT AND WRITTEN PERMISSION OF FORD RACING PERFORMANCE PARTS.

- STEP 8:** Remove nuts from transmission cross member-to-frame bolts (6).
- STEP 9:** Remove catalytic converter heat shield bolts (1 per side).
- STEP 10:** Remove transmission cross member thru bolts (6).
- STEP 11:** Remove transmission cross member.
- STEP 12:** Remove lower exhaust manifold-to-Y-pipe nuts (2 per side).
- STEP 13:** Loosen and slide back exhaust clamp (Y-pipe-to-exhaust pipe).
- STEP 14:** Remove nut from stud at exhaust hanger (rear transmission mount).
- STEP 15:** Remove Y-pipe.
- STEP 16:** Loosen EGR tube nuts (2). Totally back off lower nut.
- STEP 17:** Remove lower exhaust manifold nuts and studs (4 per side), accessible from underneath.
- STEP 18:** Remove upper exhaust manifold nuts and studs (4 per side), accessible from top and thru inner fender.
- STEP 19:** Remove exhaust manifolds (removable from underneath).
- STEP 20:** Install header-to-Y-pipe studs (2 per side).
- STEP 21:** Install passenger side header and gasket.
- STEP 22:** Torque header bolts to 25NM +/- 3.8NM.
- STEP 23:** Install transmission dipstick bolt. Torque bolt to 20NM.
- STEP 24:** Install driver's side header and gasket (start 2 bolts, leave header loose).
- STEP 25:** Install oil dipstick tube from top. Torque bolt to 9NM.
- STEP 26:** Install remainder of header bolts.
- STEP 27:** Torque header bolts to 25NM +/- 3.8NM.
- STEP 28:** Start lower EGR tube nut, tighten both nuts.
- STEP 29:** Torque EGR tube nuts to 40NM +/- 6NM.
- STEP 30:** Install Y-pipe.

Factory Ford shop manuals are available from Helm Publications, 1-800-782-4356



M-9430-F542
1999-03 F150 and 2000-04 F250 5.4L 2V SS Shorty Headers
INSTALLATION INSTRUCTIONS

NO PART OF THIS DOCUMENT MAY BE REPRODUCED WITHOUT PRIOR AGREEMENT AND WRITTEN PERMISSION OF FORD RACING PERFORMANCE PARTS.

- STEP 31:** Install and torque header-to-Y-pipe nuts to 40NM +/- 6NM (2 per side).
- STEP 32:** Position Y-pipe-to-exhaust-pipe clamp.
- STEP 33:** Torque clamp fasteners to 47.5NM +/- 7.5NM.
- STEP 34:** Connect HEGO and CMS sensors (1 each per side).
- STEP 35:** Install transmission cross member.
- STEP 36:** Install transmission cross member thru bolts and nuts.
- STEP 37:** Torque cross member nuts to 90NM.
- STEP 38:** Install 2 transmission mount nuts.
- STEP 39:** Torque transmission mount nuts to 103NM.
- STEP 40:** Install catalytic converter heat shield bolts (1 per side).
- STEP 41:** Torque heat shield bolts to 15NM.

Factory Ford shop manuals are available from Helm Publications, 1-800-782-4356