



FITTING INSTRUCTIONS TO SUIT COMMODORE VN-VR **V6**

PACEMAKER HEADERS Part No PH 5019

- **LOCK STEERING COLUMN.**
- **DISCONNECT BATTERY OR USE ANTI ZAPPER.**
- **REMOVE PLUGS AND LEADS.**
- **UNBOLT AND REMOVE Y BRANCH.**
- **REMOVE STANDARD MANIFOLDS.**
- **DISCONNECT STEERING KNUCKLE BOLT AND RELEASE STEERING ARM FROM RACK.**
- **UNBOLT AND LOWER RACK.**

RH SIDE.

- **WIND LOWERED RACK TO DRIVERS SIDE.**
- **DISCONNECT No.3 PIPE FROM No.1 AND No.2.**
- **REMOVE PLASTIC CLUTCH SHROUD AND UNHOOK CLUTCH CABLE.**
- **SLOT RH HEADER (No.1 & No.2) INTO ENGINE BAY, DO NOT BOLT UP YET.**
- **REWIND RACK TO CENTRE POSITION.**
- **REPLACE RACK TO ORIGINAL POSITION AND BOLT UP TIGHT.**
- **REPLACE STEERING KNUCKLE TO ORIGINAL PLACE AND REBOLT TO TIGHT.**
- **PLACE GASKET AND SEALANT ONTO FACE OF HEAD AND BOLT UP HEADER.**
- **PLACE SEALANT ON ALL SURFACES OF No.3 PIPE.**
- **FROM UNDERNEATH THREAD No.3 PIPE UP AND INTO POSITION.**
- **PLACE BOLTS INTO CONNECTING FLANGE BUT DO NOT TIGHTEN YET.**
- **PLACE REMAINING BOLTS INTO HEAD FOR No.3 PIPE AND TIGHTEN.**
- **TIGHTEN LOWER CONNECTING FLANGE BOLTS.**
- **REASSEMBLE CLUTCH CABLE.**
- **REPLACE PLUGS & LEADS.**

LH SIDE.

- **VN-VP LH SIDE HEADER TO BE FITTED FROM UNDERNEATH VR LH SIDE CAN BE FITTED FROM THE TOP.**
- **PLACE GASKET AND SEALANT TO FACE OF HEADER AND BOLT UP.**
- **REPLACE PLUGS & LEADS.**

Y BRANCH.

- **CONNECT SUPPLIED Y BRANCH TO HEADERS USING SEALANT ON BALL SOCKET JOINTS,**
- **PLACE GASKET TO CAT AND BOLT UP.**

* **NOTE: SOME MODELS HAVE THE OXYGEN SENSOR NEAR THE LH MANIFOLD WHILE OTHERS HAVE IT NEAR THE CAT. CHOOSE THE APPROPRIATE LOCATION FOR THE SENSOR AND PLACE SUPPLIED PLUG IN OTHER.**

WARNING IF ANY PART OF THE COOLING SYSTEM IS REMOVED i.e.; HOSES AND LINES, DURING THE INSTALLATION OF THESE HEADERS, IT IS ADVISABLE TO BLEED THE COOLING SYSTEM OF ANY AIR WHEN COOLANT IS BEING REPLACED.