



FITTING INSTRUCTIONS TO SUIT

FG XR-8 GT & GTP fitted with the **Boss 5.4 Litre 4 valve V8 engine** **PACEMAKER HEADERS** part no. **PH 4???** / **PH 4???**

IMPORTANT read the following instructions carefully before proceeding. You will need the aid of a hoist as it is necessary to support the engine while the engine mount spacer plate is removed during the install

RH SIDE

From the top

- Place an anti zapper across battery terminals
- Unbolt coolant bottle and place to the front of the vehicle
- Unbolt fuse box including earth strap and place to the front of the vehicle (be careful as the earth strap is live)
- Remove the 4 top bolts to the manifold

From underneath

- Unplug O2 sensors
- Unbolt steering shaft from the rack and place up and out of the way
- Unbolt the engine pipe and cat assembly and remove

Note: it will be necessary to loosen the L H side at the cat to remove the RH side, but it is important to retighten LH side after

- Remove the remaining bolts to the manifold and remove the manifold and unscrew the O2 sensor and place to one side

Important: for your convenience, PACEMAKER HEADERS have provided new bolts with regular hex heads to be used in conjunction with the washers found with the standard bolts.

- Place the 4 lower bolts along with washes and gaskets onto the cylinder head face
- Slot header into engine bay and hang off the lower hooks found along the header
- Replace remaining top bolts and tighten up header
- Slide steering shaft down and back into position
- Replace bolt and tighten the steering shaft
- Strip off and remove the forward heat shield from around engine pipe and cut 20 mm before the weld as to **dia. 2**
- Replace engine pipe up and into position behind header and rebolt to the factory Y branch

Note: it is not necessary to use the provided gasket just yet

- Weld into place but do not remove to finish as yet
- Replace the O2 sensors and plug back into loom
- **Finish reassembly of the RH side**

LH SIDE

From the top

- Unclip and unscrew snorkel and remove
- Remove the dip stick tube bolts from the rocker cover and the block.

Note: dipstick cannot be removed without damaging it just yet

- Undo all of the manifold bolts (except perhaps one to hold header still)
- Undo the nut from on top of the engine mount

From underneath

- Unplug o2 sensors

Note: PACEMAKER HEADERS recommends the use of a 4 posted hoist for the next procedure

- Locate the eyelet cast into the block up by front Left hand corner.
- Using a trolley jack and a straight bar, place the bar onto the trolley jack and into the eyelet to support the engine
- Using the trolley jack, lift engine approximately 25-30 mm
- Remove the three remaining bolts securing the engine mount spacer plate.
- Unbolt the engine pipe and cat assembly and remove



Page 2 of 2

FITTING INSTRUCTIONS TO SUIT
BA XR-8 GT & GTP fitted with the **Boss 5.4 Litre 4 valve V8 engine**

PACEMAKER HEADERS part no. **PH 4008**

Continued

- Unbolt starter and hang out off the way **Note: PH 4??? only**
- Undo the last manifold bolt and remove manifold, dip stick and engine mount spacer plate all at once
- Place the 4 lower bolts along with washes and gaskets onto the cylinder head face
- Thread dip stick tube into header and slot header into engine bay hanging header off the lower hooks found along the header
- Place engine mount spacer plate back into position
- Juggle engine mount spacer plate into position while locating the dip stick tube back into position

Note: This procedure will need to be done in unison to each other

Replace starter bolts and bolt up tight

-
- Replace remaining header bolts and tighten up header
- Strip off and remove the forward heat shield from around engine pipe and cut 20 mm before the weld as to **dia. 2**
- Replace engine pipe up and into position behind header and rebolt to the factory Y branch

Note; it is not necessary to use the provided gasket just yet

- Weld into position
- Unbolt the new RH and LH cat converter assemblies and complete the weld
- Return the finished cat converter assemblies to their new position, using gaskets and sealant to finish
- Replace the O2 sensors and plug back into loom
- Finish reassembly of the LH side

Important: check all clearances around headers including steering shaft trans lines and heat shields and adjust where necessary.

Engine Pipe & Cat. Converter After Forward Heat Shield Has Been Removed

