



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**

IMPORTANT read the following instructions carefully before proceeding.

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 column heat shield from sway bar support and remove (do not discard) and replace bolts to the sway bar
- Unbolt steering shaft from the rack and place up and out of the way (to the top of the support bracket)
- 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 the 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

Note: now is the time to assemble the steering shaft heat shield

- Gently grind off the rivet heads holding the factory heat shield to the factory bracket
- Redrill the 3 lower holes (around 6 mm) as to **dia 1** in the heat shield to match the new **PACEMAKER HEADERS** bracket
- Assemble heat shield using the nuts bolts and washes provided

Important: place the exposed thread to the outside and away from the shaft

- Slide assembled heat shield up and over steering rack joint and then slide steering shaft down and back into position
- Replace bolt and tighten the steering shaft
- Bolt new heat shield into place

Note: this bracket is designed to be a little flexible and can be gently massaged to create the best possible clearance

- 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
- Remove the 4 top bolts to the manifold



From underneath

- Unplug o2 sensors
- Unbolt the engine pipe and cat assembly and remove
- Unbolt starter and hang out off the way (note the starter is mounted to the bell housing by 2 dowel pins)
- Remove the remaining bolts to the manifold and remove the manifold
- Place the 4 lower bolts along with washes and gaskets onto the cylinder head face

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Continued

- Slot header into engine bay and before locating the header into position, return starter to its original position
- Hang off the lower hooks found along the header
- 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

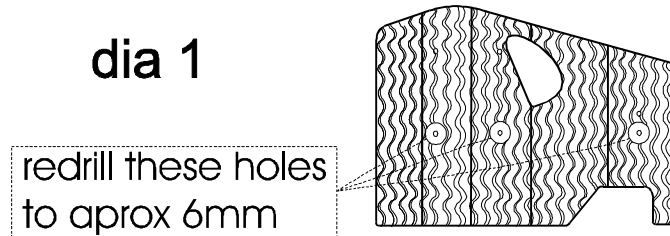
Steering rack boot shields

Note: the RH shield is cut to clear the steering rack snout

- Lower the sway bar down and out of the way
- Place provided steering boot heat shields to headers and shape over the rubber boot creating an air space between the header and the boot
- Using the washers, bolt up the heat shields to tight
- Replace sway bar back into position and tighten up

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

Unfolded steering shaft heat shield after it has been removed from the bracket



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

