



Empowering Racers Since 1989

ZOOMIE HEADER WELD-UP KIT Installation Instructions

READ COMPLETELY BEFORE STARTING:

Your vehicle *must* be raised to a minimum of 36 inches to allow proper working clearance.

- A floor hoist is strongly recommended.
- If a hoist is not available, we *strongly* urge the use of heavy-duty axle stands as a safety measure.

CAUTION: Do *NOT* support the vehicle using a bumper jack under *any* circumstances.

INSTALLATION PROCEDURE:

TUBE IDENTIFICATION: #1 (78 Deg) / #2 (81 Deg) / #3 (84 Deg) / #4 (87 Deg)

1. Mount Header Flange:

Bolt the header flange plate securely to the cylinder head (Pipes are numbered 1 through 4).

2. Install Tube #1:

Insert Tube #1 into the #1 (first) cylinder position. Trim or shorten the tube so the first bend is at the desired length and position.

3. Fit Cover Tube:

Slide the cover tube over Tube #1. Hold it up to the flange and mark the correct angle. Cut the cover tube so it sits flush against the flange.

4. Tack Weld Tube #1 Assembly:

Tack weld the inner tube to the inside of the flange (Heli-arc/TIG welding recommended). Tack weld the cover tube to the outside of the flange.

5. Repeat for Remaining Tubes:

Repeat the same procedure for Tubes #2, #3, and #4: position, trim, fit cover tube, mark, cut, and tack weld.

6. Final Welding:

Once all tubes are installed and angles are verified, fully weld all joints. Ensure clean, complete welds for durability and performance.

7. Right-Side Header:

Repeat all steps beginning with Tube #1 for the right-side header assembly.

FINAL NOTES:

Double-check all clearances before final welding. Ensure proper alignment for optimal performance and fitment. Professional welding is recommended for best results.