

KIT # 21583001 = 1-5/8" primary to 3" collector, #21753501 = 1-3/4" primary to 3-1/2" collector, # 22004001 = 2" primary to 4" collector

This kit was designed to turn your custom headers into a merge style collector, or take your existing headers & transform them into a merge style collector header.

**DANGER WARNING:** SHOULD THE PURCHASER DECIDE TO INSTALL THIS EXHAUST PRODUCT AT HOME, BE WARNED THAT PLEASURE CAR OR LIGHT DUTY TRUCK/VAN "BUMPER" JACKS ARE INTENDED FOR EMERGENCY USE ONLY. THE USE OF FRAME CONTACT JACK STANDS IN CONJUNCTION WITH A FLOOR JACK AS MAIN SUPPORT IS HIGHLY RECOMMENDED TO MINIMIZE ACCIDENTAL DROPPING OF A VEHICLE WHILE THE INSTALLATION PROCEEDS.

**HARDWARE KIT: For part #21583001**

- 2) Four hole merge rings # 21583002
- 2) Merge cones # 21753503
- 2) Collectors # 21583003

**HARDWARE KIT: For part #21753501**

- 2) Four hole merge rings # 21753502
- 2) Merge cones # 21753503
- 2) Collectors # 21753504

**HARDWARE KIT: For part #22004001**

- 2) Four hole merge rings # 22004002
- 2) Merge cones # 21753503
- 2) Collectors # 22004003

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**INSTALLATION INSTRUCTIONS:**

Note: If you need a three bolt style flange on the end of collectors these are available separately for 3" and 3-1/2"

- 1) Make sure you have the correct size merge ring & collector for your application, then cut the collector off your original header as shown in diagram. Make sure you cut as close to the weld as possible but cut far enough back that you remove the weld.
- 2) De-bur the inside of the cut off primary tubes so that flow is not restricted & de-bur the outside to help aid in the installation of the merge ring.
- 3) Install the merge ring on the primary tubes of header. For aid in installation you can use a flat blade screw driver to gently spread the tubes apart enough to get the ring started use caution not to damage the primary tubes as most are made out of 18 gauge and will bend easy. Once ring is started gently tap the ring till its flush with the primary tubes.
- 4) Take the flat merge cone, & bend it around into a pyramid shape this works best in a vise with a hammer and lightly work it around then finish bending with two pair of pliers. ( note tang on top can be broken off before bending to aid in shaping).
- 5) Weld merge ring onto the primary tubes Make certain to weld all the way around primary tubes & without any pin holes or you will have an exhaust leak.
- 6) Tack the pyramid cone end, and make sure to weld all corners. Line up nice or it will disturb your exhaust flow. Then weld the cone to the center of the merge ring, you will need to form this piece around your primary tubes to make sure it doesn't cover up any primary tubes for a smooth flow.
- 7) Install collector onto primary tubes make sure collector is square & level with primary tubes, a common carpenters square will work fine for this & tack into place.
- 8) Form the collector around the merge ring with a ball peen hammer.
- 9) Weld the collector on & repeat on the other side.

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Build Sheet For: Easy merge header collector kit  
Part # 21583001-#21753501&#22004001

\_\_\_\_\_ 2) Merge rings

\_\_\_\_\_ 2) Merge cones

\_\_\_\_\_ 2) collectors

Inspected by: \_\_\_\_\_

Date: \_\_\_\_\_

Inspected by: \_\_\_\_\_

Date: \_\_\_\_\_