



**M-9430-SD683/SD683C
2005 F250 V-10 6.8L 3V Headers
INSTALLATION INSTRUCTIONS**

NO PART OF THIS DOCUMENT MAY BE REPRODUCED WITHOUT PRIOR AGREEMENT AND WRITTEN PERMISSION OF FORD RACING PERFORMANCE PARTS.

Please visit www.fordracingparts.com for the most current instruction information

**!!! PLEASE READ ALL OF THE FOLLOWING INSTRUCTIONS CAREFULLY PRIOR TO INSTALLATION.
AT ANY TIME YOU DO NOT UNDERSTAND THE INSTRUCTIONS, PLEASE CALL THE FORD RACING
TECHLINE AT 1-800-367-3788 !!!**

OVERVIEW:

This kit is designed for the use in 2005 F250s with V10 6.8L 3V engines. The use of a floor hoist is recommended. If you do not have access to one, use a hydraulic floor jack and jack stands to raise the vehicle.

**!!! CAUTION: JACK STANDS MUST BE USED ON A LEVEL SURFACE AND BE SECURELY SEATED.
FAILURE TO DO SO MAY RESULT IN PERSONAL INJURY OR VEHICLE DAMAGE !!!**

!!! CHECK HEADER KIT CONTENTS BEFORE STARTING WORK ON VEHICLE !!!

PARTS INCLUDED IN KIT:

- (20) M8 x 20mm header bolts
- (4) M10 x 1.5 x 65mm exhaust studs
- (4) M10 x 1.5 stud nuts
- (1) Left header
- (1) Right header
- (2) Port gaskets
- (1) Instruction Sheet

INSTALLATION INSTRUCTIONS:

!!! PERFORM THE FOLLOWING WORK ON A COLD VEHICLE ONLY !!!

- STEP 1:** Disconnect negative battery cable.
- STEP 2:** Disconnect HEGO sensors (1 per side).
- STEP 3:** Disconnect CMS sensors (1 per side).
- STEP 4:** Remove transfer case shield (4 bolts).
- STEP 5:** Remove 4 nuts at Y-pipe flange to exhaust pipe flange.
- STEP 6:** Remove 4 nuts (2 per side) exhaust manifold to Y-pipe.
- STEP 7:** Remove exhaust Y-pipe.

Factory Ford shop manuals are available from Helm Publications, 1-800-782-4356



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- STEP 8:** Remove starter motor heat shield.
- STEP 9:** Remove 2 electrical wires to starter motor.
- STEP 10:** Remove starter motor.
- STEP 11:** Remove passenger side lower exhaust manifold nuts (4) accessible from underneath.
- STEP 12:** Remove passenger side inner fender liner.
- STEP 13:** Remove remaining passenger side exhaust manifold nuts (6) from top and thru inner fender.
- STEP 14:** Remove passenger side exhaust manifold and gaskets, removable from underneath.
- STEP 15:** Remove exhaust manifold to cylinder head studs (10) accessible from underneath.
- STEP 16:** Install header to Y-pipe studs (2 per side) onto header.
- STEP 17:** Install passenger side header and gasket from underneath.
- STEP 18:** Torque header bolts to 25NM +/- 3.8NM.
- STEP 19:** Install starter motor, torque bolts to 25 NM.
- STEP 20:** Install Starter solenoid B electric wire, torque nut to 12NM.
- STEP 21:** Install starter solenoid S electrical wire, torque nut to 6NM .
- STEP 22:** Install starter motor heat shield.
- STEP 23:** Remove driver's side lower exhaust manifold nuts (4) accessible from underneath.
- STEP 24:** Remove exhaust manifold heat shield for coolant degas bottle hose (2 bolts).
- STEP 25:** Remove driver's side inner fender liner.
- STEP 26:** Remove remaining driver's side exhaust manifold nuts (6) from top and thru inner fender.
- Note:** Pry engine mount heat shield down to gain access to manifold nut and stud.
- STEP 27:** Remove Driver's side exhaust manifold and gaskets, removable from underneath.
- STEP 28:** Remove exhaust manifold to cylinder head studs (10) accessible from underneath.
- STEP 29:** Remove oil dipstick, 2 bolts on cylinder head.

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- STEP 30:** Install driver's side header and gasket.
- STEP 31:** Torque header bolts to 25NM +/- 3.8NM.
- STEP 32:** Install oil dipstick tube, torque bolts to 9NM.
- STEP 33:** Pry engine mount heat shield up to original position.
- STEP 34:** Install driver's side inner fender liner.
- STEP 35:** Install Y-pipe.
- STEP 36:** Install header to Y-pipe nuts (2 per side), torque nuts to 40NM +/- 6NM.
- STEP 37:** Install Y-pipe to exhaust pipe nuts (4), torque nuts to 40NM +/- 6NM.
- STEP 38:** Install transfer case shield, torque bolts to 18NM (4).
- STEP 39:** Connect CMS sensors (1 per side).
- STEP 40:** Connect HEGO sensors (1 per side).
- STEP 41:** Connect negative battery cable.

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