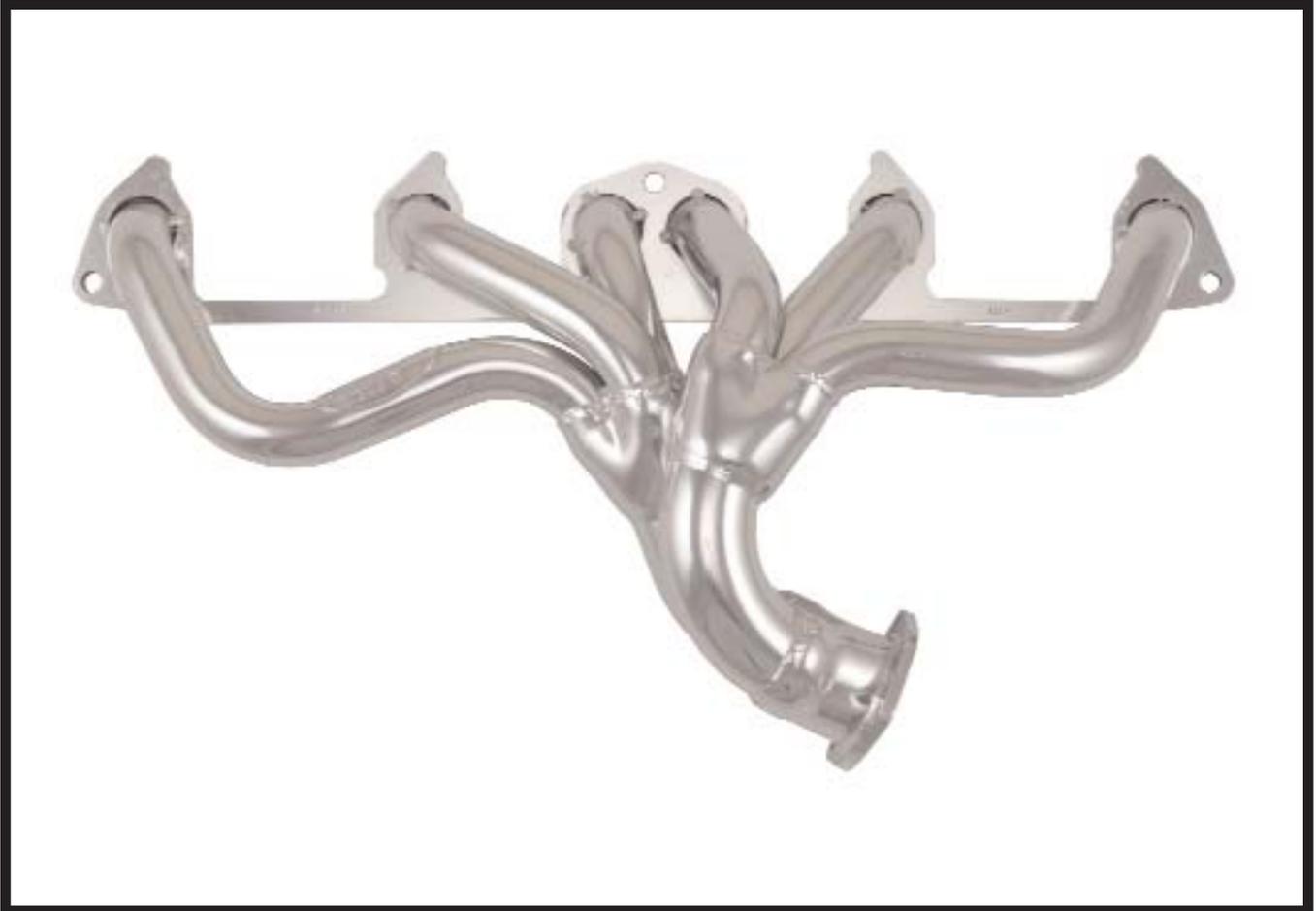


JEEP 1991-95 WRANGLER YJ, 1996-99 WRANGLER TJ, 1991-99 CHEROKEE,  
1993-99 GRAND CHEROKEE, 4.0L



## **LEGALITY NOTES**

These exhaust headers comply with California Air Resource Board regulations and are **LEGAL** for sale and/or use on pollution controlled vehicles in the state of California.

The Executive Order (“E.O.”) number for this part number, allowing for the legal use of this product, is D-540-5. Refer to this number during any required smog testing.

The installation of exhaust headers onto any vehicle must be performed in accordance with all governmental regulations that pertain to the particular vehicle receiving the headers. Please call your Doug Thorley Headers distributor if there are any questions regarding the legality of the installation.

## HDX-634Y

### H/D TRI-Y HEADER SYSTEM

**JEEP 1991-95 WRANGLER YJ, 1996-99 WRANGLER TJ, 1991-99 CHEROKEE,  
1993-99 GRAND CHEROKEE, 4.0L**

#### PARTS INCLUDED

Ref.	Part Number	Description	Qty
1)	00-901-00036	Header Assembly	1
2)	00-901-00037	Adapter Assembly	1
3)	07-31-37507	Head Gasket	1
4)	07-31-37496	Gasket, Donut, 2-1/2" I.D.	1
5)	01-1061612-2-27	Hex Head Bolt, 3/8-16x1-1/2"	3
6)	01-4006-27	Flat Washer, 3/8"	6
7)	01-310616-27	Hex Nut, 3/8-16	3

#### TOOLS REQUIRED

Ref.	Description	Ref.	Description
1)	3/8" Drive Ratchet and Extensions	6)	8mm, 10mm, 12mm, 14mm Sockets
2)	7/8" Box wrench or O2 Sensor Socket	7)	8mm, 10mm, 12mm, 14mm Wrenches
3)	9/16" Box Wrench and Socket	8)	5/8" Spark Plug Socket
4)	Welder	9)	Pliers
5)	Sawsall	10)	WD40 or equivalent

#### WARRANTY NOTES

- 1) The utmost care is taken at Doug Thorley Headers ("DTH") to maintain the highest standards of quality. However, DTH cannot control the installation of the product. For this reason the warranty covers only the replacement of the components, it does not cover labor for the installation.
- 2) The use of any type of "header wrapping" immediately voids the warranty. Using any sort of wrapping material on the headers destroys the tubing's ability to dissipate heat, causing very rapid deterioration of the composition of the metal and the subsequent failure of the headers.
- 3) Retain all paperwork pertaining to the purchase of your DTH product. Save your receipt!  
**Your limited warranty is not valid without a receipt of purchase.**

#### INSTALLATION NOTES

- 1) It is important that you read the entire instruction sheet before beginning any installation.
- 2) Due to restricted room in the engine compartment your headers may come close to certain body and chassis components, this is normal for an installation of this type. However, a careful inspection must be completed to ensure that the distances and placement are reasonable and logical, especially with regard to electrical, fuel, and brake components.
- 3) Because of car-to-car variations, DTH strongly recommends that these headers be installed by an experienced installation shop that has welding and fabrication capabilities.

**HDX-634Y**

**H/D TRI-Y HEADER SYSTEM**

**JEEP 1991-95 WRANGLER YJ, 1996-99 WRANGLER TJ, 1991-99 CHEROKEE,  
1993-99 GRAND CHEROKEE, 4.0L**

**INSTALLATION PROCEDURE**

***WARNING! Do not rely on bumper jacks or chassis jacks for support during header installation. The subject vehicle should be raised and supported with jacking equipment and jack stands or ramps intended for undercarriage auto maintenance. It is extremely dangerous to work under an improperly raised and/or supported vehicle.***

***Make certain there is ample clearance around components such as brake lines, brake proportioning valves, fuel lines, hoses and pumps, and electrical components and wires. In some cases it may be necessary to relocate items that may be adversely affected by exhaust system heat.***

*NOTE: These procedures are documented on factory standard-equipped vehicles with original configuration compliance. Any modification of the subject vehicle may dictate modification to these procedures.*

- 1) Disconnect the battery.
- 2) Disconnect the stock head pipe, retaining all hardware.
- 3) Disconnect the oxygen sensor bracket from the oil pan stud and disconnect the coupler at the oxygen sensor bracket/oil pan stud junction.
- 4) Disconnect the air horn hose from the intake manifold and the throttle body and set it aside (on some models there is a second hose into the air cleaner box. If this hose is present, disconnect it from the air cleaner box only, and move it out of the way). Retain all hardware for reinstallation.  
*NOTE: It is recommended that you cover the air duct on the throttle body unit to prevent contamination.*
- 5) Remove the air cleaner top and the air filter. Remove the two bolts at the base of the air cleaner box and remove the air cleaner box.  
*NOTE: On some models the lower air cleaner base is riveted in place. On these models the air cleaner box can remain in place during the header installation. Do not attempt to remove the rivets.*
- 6) Disconnect the PVC hose from the intake manifold and swing it out of the way.
- 7) Disconnect the two fuel lines. Use 5/16" fuel line caps (not supplied) to seal the end of the fuel lines during the header installation.
- 8) Label and disconnect all vacuum lines.

**HDX-634Y**

**H/D TRI-Y HEADER SYSTEM**

**JEEP 1991-95 WRANGLER YJ, 1996-99 WRANGLER TJ, 1991-99 CHEROKEE,  
1993-99 GRAND CHEROKEE, 4.0L**

- 9) Disconnect the throttle cable, cruise control, and kick-down cable by squeezing the tabs at the brackets and sliding the cables out. Mark the cables for reinstallation.
- 10) Remove the fuel line bracket from the intake manifold, retaining all hardware.
- 11) Disconnect the electrical sensors from the throttle body and the intake manifold.
- 12) Label (to ensure correct replacement) and remove the injector wires from the injectors on the intake manifold.  
*NOTE: Do not pull on the injector wires themselves. Pull from the base of the wires only.*
- 13) Disconnect the thermostat wire from the thermostat. Remove the power brake vacuum line from the intake manifold.
- 14) Remove the power steering pump by first loosening the set screws at the pump, then loosening the belt tensioner. Remove the belt from the power steering pulley only, leaving it in place on the other pulleys.
- 15) Remove the power steering bracket from the intake manifold.
- 16) Remove and retain the intake manifold bolts and nuts. Remove the intake manifold.
- 17) Remove the exhaust manifold. Clean all traces of carbon deposits from the cylinder head exhaust port surfaces.
- 18) Insert the supplied conical gasket into the header collector, ensuring that the thicker part of the conical gasket faces the front of the header. Attach the adapter loosely to the header using the supplied 3/8" hardware.
- 19) Install the header using only the center nut and washer, and finger-tighten to hold the header in place. Do not fully tighten at this time.
- 20) Reinstall the intake manifold using the original hardware. Do not fully tighten at this time.
- 21) With the header and adapter assembly loosely bolted together, measure and mark the stock headpipe so that the adapter can slide into it. Cut the stock headpipe accordingly.
- 22) Disassemble the adapter from the header and weld it into the stock headpipe.
- 23) After the headpipe and adapter has cooled down, loosely bolt the assembly back to the header using the supplied 3/8" hardware.

HDX-634Y

H/D TRI-Y HEADER SYSTEM

JEEP 1991-95 WRANGLER YJ, 1996-99 WRANGLER TJ, 1991-99 CHEROKEE,  
1993-99 GRAND CHEROKEE, 4.0L

- 24) Tighten all intake manifold and header bolts to 40 ft. lbs.. in the sequence shown in Fig. 1.  
Then tighten the hardware at the headpipe connection.
- 25) Reconnect the oxygen sensor and reinstall the oxygen sensor bracket to the oil pan stud.
- 26) Reattach all vacuum lines, electrical lines, and injector wires.
- 27) Remove the fuel line caps from Step 8 and reattach the fuel lines by pushing them into position.  
*Note: The fuel lines will lock in place when properly connected.*
- 28) Reattach the power steering bracket to the intake manifold.
- 29) Reattach the power steering pump to the bracket ensuring that the serpentine belt is properly located on the pulley.
- 30) Tighten the serpentine belt to the factory specifications using the belt tensioner.  
Once the proper tension is achieved, tighten the set screws.
- 31) Reinstall the air box and the air filter.  
Replace the top of the air cleaner box and reconnect all remaining hoses.
- 32) Reconnect the battery. Start the engine and check for leaks.
- 33) Allow the engine to run for thirty minutes, then re-torque all the bolts on the header and intake flange to 40 ft. lbs..

