



VE-VF Series 1  
VE03 Headers  
All models  
Installation Instructions

**XFORCE RECOMMENDS AN AUTHORISED PROFESSIONAL TO INSTALL ALL PRODUCTS**

**WARNING:** When working on any vehicle exercise extreme caution. Please allow the vehicles exhaust system to be cool enough to touch before removal. Failing to do so may result in severe burns. If working without a hoist refer to the vehicles manual to check correct lifting specifications. Always wear safety glasses, protective gloves and ensure your working in a safe area. Serious injury or death can occur if the correct safety measures are not followed.

**Attention:** Please read the instructions carefully. XFORCE will only warrant manufacturing faults. This does not extend to damage or breakage due to incorrect fitment.



## Required Tools

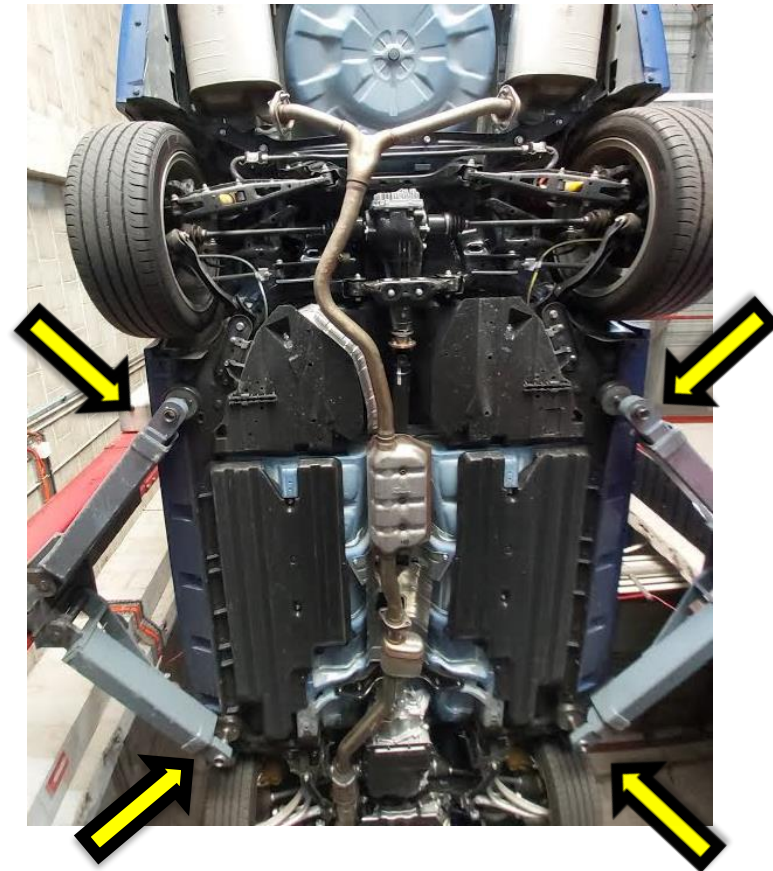
1. Spanners and Sockets required 10mm, 11mm, 13mm, 14mm, 15mm, 16mm
2. Ratchet
3. Spark plug socket
4. Extension bar
5. Long flat blade screwdriver.
6. Can of spray lubricant
7. Tube of O2 Sensor safe sealant



## Step 1

**The entire fitting process must be conducted by a professionally trained technician (this also includes hoist operation).**

Raise vehicle on a 2 post hoist making sure hoist arms are in the correct lifting positions (as per owners manual).  
Make sure that you or someone else isn't under the vehicle while hoist is moving.  
Once the Vehicle is at a workable height engage the hoist safety locks.





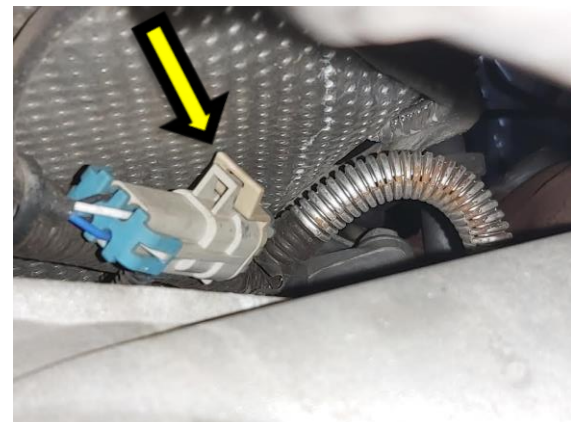
## Step 2

Disconnect Battery (in boot on the left side)

Unbolt the exhaust at the 2 bolt flanges (15mm) at the back of the cat converters.

Unclip the front and rear O2 sensors from the wiring harness. You may need a long flat blade screwdriver to help with the front sensors.

To make things a little easier, you can also unbolt the centre from the rear mufflers and remove the centre however this isn't needed.





## Step 3

Disconnect the steering shaft from the rack using either an 11mm or 13mm socket (depends on the car as to the size). It will only go on one way so no need to mark the bolt prior to removal.

Slide the steering shaft off the rack and let it hang to the side.

Lower the car on the hoist





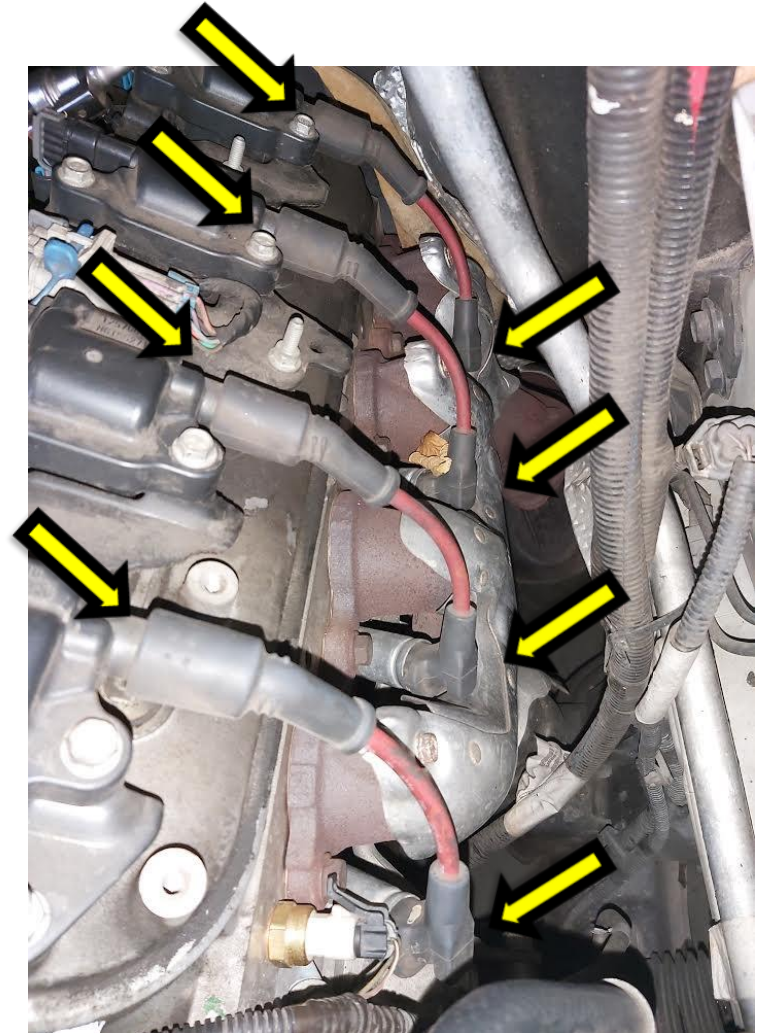


## Step 4

Remove the engine cover by lifting all 4 corners and put to the side.

Remove the 4 spark plugs leads on the left and right side of the engine, being very careful not to break them.

Then remove the spark plugs however if you're confident you won't break them, no need.





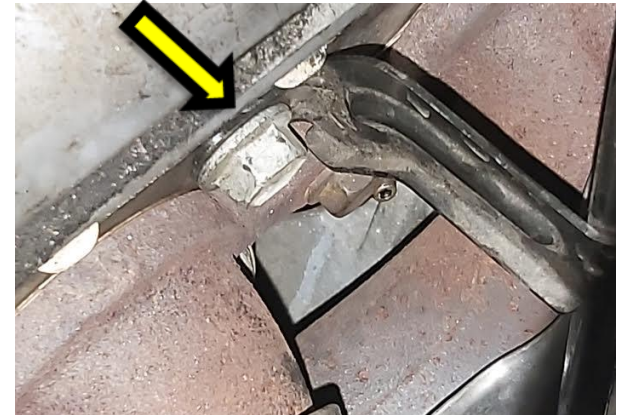
## Step 5

Remove the dipstick and dipstick tube using a 15mm socket.

Remove the 6 x 10mm or 13mm bolts from the manifold on each side and remove from underneath the car.

Once removed place the factory manifold gasket onto the cylinder head using the bolts (wound in 3-4 threads) in the front and rear holes to hold it in place. Then raise the car on the hoist.

**MAKE SURE IT IS FITTED IN THE CORRECT POSITION AND DIRECTION**, This is indicated on the gasket.





## Step 6

Fit the cats to the headers on the ground or a bench using the supplied gaskets and bolts (15 and 16mm). Make sure they are tight and that left and right cat is on the correct header, so that the rotation of the 2 bolt flange is as per the pictures. Then fit the front O2 sensors to the headers.



Left header



Right Header







## Step 7

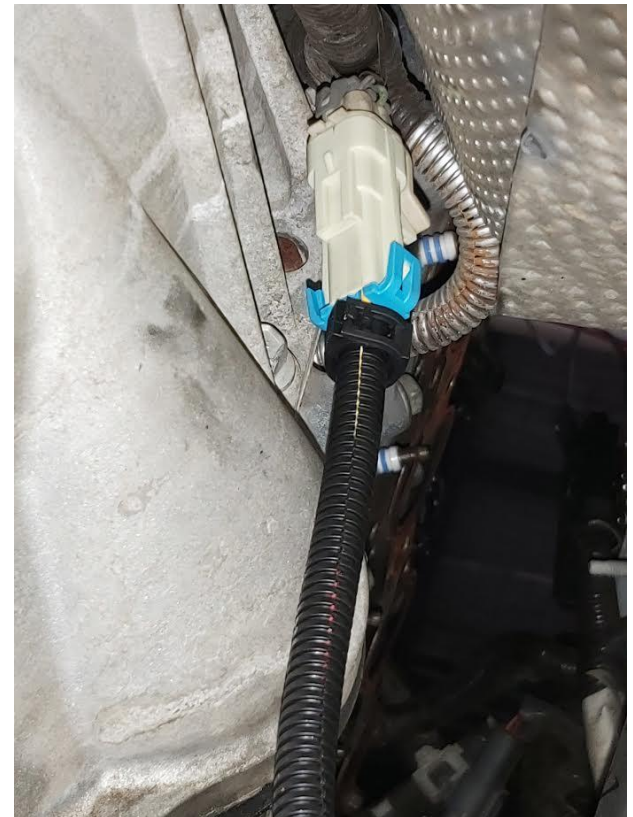
**BEFORE YOU DO ANYTHING INSTALL THE O2 EXTENSIONS TO THE ENGINE HARNESS.** Otherwise it will be impossible to install them once the header is fitted.

Slide the right hand header into the engine bay from underneath making sure you move the steering shaft up at the same time so the header has sufficient space.

Hang the header onto the bolts holding the gasket in place then repeat necessary steps on the left side.

Lower the car to the ground, fit the dipstick tube before other bolts are fitted then put the rest of the bolts into the headers. Tighten one of the middle bolts firm so that the header is hard up onto the cylinder head **DO NOT** tighten the others.

Now raise the car for the next step.





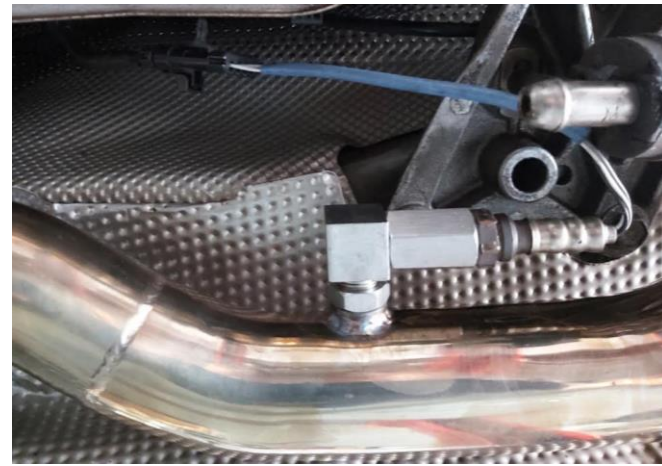
## Step 8

Fit the O2 sensors to the header and connect to the harness extensions, fit the 90 deg angle fittings to the rear sensor holes and fit the rear sensors into the fittings. **ONLY USE THESE IF THE CAR ISN'T BEING TUNED.** Refit the steering shaft to the steering rack, it will only go on one way. Fit to the standard or Xforce cat back, lower the car and tighten the header bolts. Refit the dipstick, plugs and leads.

Left



Right





## Step 9

Re check every step **ESPECIALLY** the **STEERING** to make sure you haven't missed anything

Re Fit the engine cover

Start the car, check for leaks and now enjoy your new XFORCE PERFORMANCE EXHAUST.

**Note:** When you first start your vehicle after the installation of your new XFORCE Performance Exhaust System, there may be some smoke and fumes coming from the system. This is a protective oil based coating used in the manufacturing of mandrel bent performance exhaust tubing. This is not a problem and will disappear within a very short period of time after the exhaust has reached normal operating temperatures.

