

DIRECTIONS FOR INSTALLING IPE COPPER EXHAUST MANIFOLD GASKETS

- Remove exhaust manifolds and clean all carbon and gasket material off from the cylinder head and manifold mounting surfaces.
- It is desirable at this time to use a honing stone on the mounting surfaces to remove small irregularities.
- Check manifold and cylinder head mounting surfaces for erosion/burn marks. If depressions are more than .020 deep, resurfacing may be necessary.
- If you are not resurfacing the manifolds, the surfaces should be coated with a spray on copper base compound, (K&W, Permatex, Loctite or equivalent), to fill the small pits. The temperature range of these products is adequate, when copper gaskets are utilized, because the manifold/cylinder head interface runs much cooler.
- Install the gaskets with the raised emboss against the manifold.
- Use grade 8 bolts, grade 8 **extra thick** flat washers, and high temperature anti-seize compound when reattaching the manifolds.
- Start by hanging the manifold/gasket from the top bolt (#5). This hole is smaller than the other four holes in the manifold, and is used for alignment.
- Install the remaining four bolts. Torque bolts evenly to compress the emboss. Start with bolts #1 through #4, which are in line, before tightening the top bolt as shown in the chart below. This is very important because all five bolts are above the center line of the manifold, and torqueing #5 first will tip the manifold and over compress the emboss at the top.



- Do not torque to the full 25 foot-pounds on the first pass. Take five passes at 5 foot-pounds per pass.
- Bring the engine up to full operating temperature, then turn off and let cool to ambient temperature.
- Re-torque the bolts in sequence to 25-foot pounds. This heating/cooling/re-torqueing may have to be repeated several times until the torque remains at 25-foot pounds.

If you have any questions or problems please call:

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