



Corporate Office: PerTronix Inc. 440 E. Arrow Highway, San Dimas, California 91773 \* Phone 909.599.5955 • FAX 909.599.6424

## Installation Instructions and Warranty Information

### Part #1680S 2000-04 Ford Focus 2.0L Zetec



This Product has been granted a California Air Resources Board (CARB) "E.O" (Executive Order) Exemption, or is considered a Direct Replacement or Consolidated Replacement part. It is 50 State Legal when installed on the appropriate vehicle per the Manufacturer Application guide and Installation Instructions.

Read all instructions carefully before attempting installation.



#### **WARNING**

This product can expose you to chemicals which are known to the State of California to cause cancer and birth defects or other reproductive harm. For more information go to [www.P65Warnings.ca.gov/product](http://www.P65Warnings.ca.gov/product)

PerTronix© thanks you for choosing JBA HEADERS, the best fitting, highest quality header on the market. In order to realize the full potential of our good fit, please read and understand these instructions completely prior to starting work.

Check to make sure you received the proper parts for your application. The header number will be stamped on the engine flange. If you are unsure you have received the proper parts call before you start work.

Be sure to work safe! Whenever you work under the vehicle be sure that it is located on level, solid ground and is supported by adequate safety stands! Remember: Hot asphalt will not support most jack stands!

Many factors affect the installation of headers, some of which are broken or aftermarket motor mounts, accidents that impact the configuration of the frame, and/or the installation of different engines or aftermarket cylinder heads.

Attention Customers breaking in new engines: Due to the extreme heat generated during the break-in process, the appearance of the ceramic coating may be altered in certain areas. The protection characteristics and thermal barrier properties of the coating is never compromised. It is recommended that a cast iron manifold or old set of headers be used for this process.

Notice: The coating of these headers can be marred or scratched during installation. If the header needs to be returned and is damaged, you will be charged for recoat.

JBA uses sealing beads on all its headers. We have found that when installed correctly, the raised bead around each port increases the pressure exerted on the gasket directly adjacent to the port and effectively prevents leaking gaskets. It is normal for the flange to be raised off the cylinder head the thickness of the sealing bead. It is important when installing the header, to install all bolts loosely, then tighten evenly to ensure the flat installation of the flange. The torque sequence from one flange to another will vary, but generally every bolt on a header should be first fit snug, starting from the inside of the flange working out, alternating from top to bottom so that the bolt connects the flange to the manifold to the point where they barely touch. Second, using the same inside-out pattern, tighten each bolt until finished. This method will help prevent leakage and will give the user the best possible performance out of their pair of headers.

1. Place vehicle in a location where the floor is solid and flat, with adequate lighting. Do not attempt to work on a hot engine. Heat causes metal to expand and makes removal of fasteners difficult at best. Disconnect the battery cables from the battery. Raise the front of the vehicle to obtain adequate access to the bottom exhaust manifold flanges. Use large-base jack stands to support the vehicle. Do not rely on the jack! Block the tires to prevent the vehicle from rolling off the jack stands.

2. Spray WD-40 or some type of penetrating oil on all accessible fasteners and fittings before attempting to remove them.

#### REMOVAL OF THE CATALYTIC CONVERTER ASSEMBLY

3. From underneath the vehicle, disconnect the exhaust system from the catalytic converter assembly by unbolting the (2) nuts attaching the two and then loosening the support bracket at the rear of the converter assembly. Do not discard the bolts removed. You will need them to re-install the exhaust system.

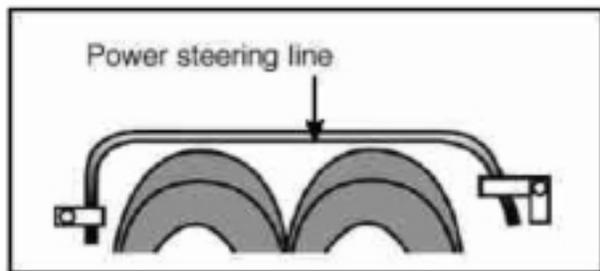
4. Next, remove the catalytic converter band bracket from the catalytic converter by removing the (2) 10mm head bolts attaching it. Keep the bolts handy you will need them to reinstall the bracket.
5. Disconnect the (2) O2 sensors by unplugging them .It is not necessary to remove them from the catalytic converter assembly.
6. From the underneath the vehicle, disconnect the EGR tube from the catalytic converter assembly.
7. Remove the heat shield covering the factory exhaust manifold by unscrewing the (4) attaching fasteners.
8. Remove the 3 nuts attaching the catalytic converter to the factory exhaust manifold. Retain the nuts for later use.

**CAUTION:** When the three nuts are removed, the cat assembly will fall from the vehicle. Avoid any sudden impact with catalytic converter.

#### REMOVAL OF THE EXHAUST MANIFOLD

9. Remove the screws from the clamps attaching the power steering line to the support bracket at the front of the motor. - See illustration.

10. Now remove the (6) bolts and (3) nuts attaching the exhaust manifold to the head and then remove the manifold.



11. With the manifold out of the way, remove the (3) remaining studs from the head using a female Torx head socket.

12. Using a scraper or wire brush, remove any debris or carbon deposits from the head surface. Use caution making sure not to damage the head surface. **INSTALL THE NEW HEADER**

13. Install the new JBA Header using the supplied gasket and fasteners. Apply a small amount of anti-seize to the threads of the bolts and torque to 23 ft/lbs.

14. Re-install the catalytic converter assembly by reversing steps 3 through 8. Be sure to inspect the factory gasket on the upper cat flange. If it is damaged replace it with the supplied gasket.

**NOTE:** It may be necessary to loosen the rear converter support bracket for adjustment when re-installing the catalytic converter.

15. With the header properly installed, re-attach the power steering line to the front of the motor.

16. Reconnect the battery.

17. Re-check everything!

18. Start the engine, check for leaks and test drive. Then let engine cool and then re-torque the header bolts.

19. Periodically check and retighten the header bolts.

Parts List:

- (1) Driver's Side Header Assembly
- (1) Passenger's Side Header Assembly
- (2) Header flange gaskets
- (16) 8mm-1.25 x 25mm Header fasteners w/lock washers (Torque to 13 ft/lbs)
- (4) 7/16 -14 x 2.5 "Collector bolts w/nuts (Torque to 35 ft./lbs)
- (1) CARB EO Sticker

 440 E. Arrow Hwy. San Dimas, CA 91773 (909) 599-5955	This vehicle is equipped with: <b>Dougs Headers # D66XX</b> <b>JBA Headers # 16XXS</b>
	Legal for sale and installation in California <b>CARB EXECUTIVE ORDER</b> <b>D-57-27, D-57-31</b>

**WARNING**

This label is required to aid in passing the California smog check program. This label must be installed in an underhood location that is readily visible.

**LIMITED ONE YEAR WARRANTY**

All JBA HEADERS and exhaust products are guaranteed, to the original purchaser, to be free of defects in materials and workmanship for one year. This warranty covers the replacement or repair of the product only and does not cover the cost of removal and installation, customer applied aftermarket coatings or any discoloration or corrosion of finished surfaces.

Damage or product failure resulting from collision, improper installation, off-road use, road hazards, the use of exhaust insulating wrap or like products or rust occurring after installation, is not covered by the warranty. The warranty extends only to the original purchaser.

Should a part become defective it should be returned to the original selling retailer and must be accompanied with the sales receipt. If there is no retailer in your area, call the factory for a return authorization and return your part prepaid to the factory for inspection. PerTronix reserves the rights to replace or repair the alleged defective part and return the part freight collect.



