



# **MAX FLOW DODGE ELBOW**

C44083

# **APPLICATION**

1994–2002 DODGE RAM TRUCKS W/5.9L CUMMINS DIESEL ENGINES WITH MANUAL & AUTOMATIC TRANSMISSIONS STOCK DODGE CUMMINS HX & HY SERIES TURBO Thank you and congratulations on the purchase of a Pacbrake replacement Dodge elbow to increase exhaust flow. Read the entire installation manual carefully to ensure you can complete the installation once started. Check that your Pacbrake kit is correct for the application and contains all the necessary parts as shown in the photo.

### **IMPORTANT:**

This kit is designed for trucks with 4" aftermarket exhaust system, therefore it includes an exhaust adapter to fit 4" O.D. exhaust pipe. Should the vehicle have an exhaust pipe diameter other than 4" O.D. contact Pacbrake factory with the exhaust pipe O.D. to order a replacement exhaust adapter.

Trucks with exhaust systems other than 4" O.D. require a different exhaust adapter. Contact Pacbrake @ 1.800.663.0096.

Disconnect the negative battery terminals on both batteries.

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## INSTALLATION INSTRUCTIONS-

# 1 Exhaust Elbow Installation:

All vehicles, remove the two capscrews that attaches the cast elbow to the header pipe.

**1994-1998 vehicles,** remove the V clamp between the elbow and the turbo charger. Remove the cast elbow. Removal of the 5 bolt flange is required. 5 new fasteners will be supplied.

**1999-2002 vehicles,** remove the 5 capscrews securing the elbow to the turbo charger. Remove the cast elbow, 5 new fasteners will be supplied.





From below the vehicle, remove the header pipe by removing the exhaust clamp at the header pipe connection to the intermediate pipe. Once the header pipe is removed from the vehicle, loosely install the elbow back onto the header pipe. Loosely assemble the Pacbrake elbow to the adapter for measuring purposes. Lay the two assemblies side by side to determine the correct location to cut the header pipe. The Pacbrake elbow provided is expanded to fit over a 4" O.D exhaust header pipe. Consider this in your measurement. Cut the header pipe to length.



At the turbo charger check the gasket surface for imperfections. If okay, install the new gasket and replacement elbow provided. Replace the 5 capscrews removed earlier with the supplied 12 point fasteners. Torque the capscrews to 110 in-lbs in a star pattern, then re-torque to 220 in-lbs in a star pattern. After a road test, re-torque to all 5 capscrews 220 in-lbs.



Install the shortened header pipe into the rear Pacbrake flange and intermediate exhaust pipe. Adjust the assembly to attain maximum clearance and a good pipe fit. Trim the firewall insulation to attain a minimum clearance of 6" to the exhaust header pipe. Tack weld the Pacbrake adapter to the header pipe, remove the "V" clamp and then the header pipe for welding. Re-install the header pipe and torque the "V" clamp to 12 ft-lbs. Re-install the original exhaust clamp at the connection between the header to intermediate pipe.



- **5** Reconnect both negative battery terminals.
- Provided in the Pacbrake elbow is a 1/8" NPT tapped hole. This port can be used to install a pyrometer or an exhaust system back-pressure gage if necessary. A 1/8" NPT plug is provided to plug the port if necessary.

