



INSTALLATION INSTRUCTIONS

MAKE: Cadillac
 MODEL: CTS-V
 YEAR: 2009-2015
 ENGINE: V8-6.2L (sc)

**304SS Twisted Steel
 Headers/Connection Pipes
 48-34125-YC (w/cats)
 48-34125-YN (w/o cats)**



48-34125-YC Shown

Parts Included

- (P/N: 05-45968) Right Side Header
- (P/N: 05-45969) Left Side Header
- (P/N: 05-45970) Right, Mid-Pipe w/cat
- (P/N: 05-45971) Left, Mid-Pipe w/cat
- (P/N: 05-45970) Right, Mid-Pipe w/o cat
- (P/N: 05-45971) Left, Mid-Pipe w/o cat
- (P/N: 05-45974) Extension to OE Exh.
- (P/N: 05-45975) Extension to aFe Exh.

Hardware Included

- (P/N 05-46167) Ties, Postive Locking (X1)
- (P/N 05-60167) Ties, Nylon Cable (x11)
- (P/N 05-41055) Clamp, Band; 3" (x2)
- (P/N 05-41061) Clamp, Band: 2.5" (x2)
- (P/N 03-50227) O2 Extension 28" (x4)
 (48-34125-YN: O2 Extension 28" x2)
- (P/N 05-46128) Gasket Set (x1)
- (P/N 05-41588) Clamp, V-Band (x2)
- (P/N 05-46018) O2 Sensor Plug
- ThermoWrap Heat Tape 3." x 7.5" (X1)
- ThermoWrap Heat Tape 2.5" x 3" (X4)
- ThermoWrap Heat Tape 3" x 5.5" (X2)

CAUTION: Allow time for your vehicle to cool down prior to installation. When working on or under your vehicle proceed with caution. Exhaust systems reach high temperatures and may cause serious burns. Wear protective safety equipment; eye goggles and gloves to ensure a safe installation. aFe recommends professional installation on our products.

- Step 1:** (Read Instructions prior to installation) For faster removal and installation of exhaust a trained professional is recommended for this procedure. Secure stock exhaust with jack/stands. The stock exhaust system will require cutting therefore professional assistance and proper tube cutting tools is always recommended.
- Step 2:** Remove the cross member support bracket and place this assembly in a safe place. This bracket will not be re used on the aFe POWER exhaust system.
- Step 3:** Un-bolt the flanges from the down-pipes connecting to the exhaust. Remove your stock exhaust in one piece up to the catalytic converter flanges. Take caution not to damage the factory hardware and isolation mounts as they will be reused.
- Step 4:** Place the stock exhaust on a flat surface, using a marker; measure 11" inches back from the weld on the rear catalytic converters and place a mark. Do this for both sides (as shown in Figure C), the mark will indicate your cut locations. Ensure the measurements are accurate and the mark is clearly visible. Using a saw cut both sides of the stock exhaust.
- Step 5:** Remove (right/passenger) side spark plug wires and spark plugs to avoid damaging them during installation. (5/8" spark plug socket)
- Step 6:** Un-bolt dip stick tube from the side of the engine block and pull the dip stick tube up to remove.
- Step 7:** Disconnect the (right) primary and secondary O2 sensors from the engine wiring harness. The primary connectors can be found near the rear of the cylinder heads on the engine. (Note: Make sure to label them to reinstall on vehicle.)
- Step 8:** Remove (x6) manifold bolts and remove manifold along with OEM manifold gasket.
- Step 9:** Inspect the engine head surface is clean and free of any debris before installing aFe power header.
- Step 10:** Connect the primary & secondary O2 sensor extensions provided to the engine harness. Do not connect the actual O2 sensors at this time. (Set aside in vehicle for header install.)
- Step 11:** Install (right) aFe Header with supplied (right) gasket and use OEM (x6) bolts removed from manifold in **step 8**.
- Step 12:** Torque the header bolts, starting from the center working your way outward. First pass will be 11ft lbs. of torque, second pass will be 18ft lbs.
- Step 13:** Install primary O2 sensors to the previously installed extensions. (Zip tie lines away from headers; use the fluid lines along the tunnel). **Note: If using a wide band, install sensor onto extra bung on passenger header. If not using wide band, install supplied bung plug.**
- Step 14:** Reinstall the dip stick tube.
- Step 15:** Reinstall the spark plugs and wires.





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Step 16: Use the 3" x 7.5" heat tape on the bracket covering the brake lines on the right side chassis by headers. Use the remaining heat tape to cover starter wiring close to header. You will use metal zip tie to pull starter wiring to starter away from header. Refer to **figure B**.

Step 17: Remove (left/driver) side spark plug wires and spark plugs to avoid damaging them during installation. (5/8" spark plug socket)

Step 18: Disconnect the (left) primary and secondary O2 sensors from the engine wiring harness. The primary connectors can be found near the rear of the cylinder heads on the engine. (Note: Make sure to label the O2 sensors front and rear so they are reinstalled in the correct location.)

Step 19: Remove (x2) bolts that secures the steering shaft to the rack (11mm socket on extension). Compress the steering shaft to disengage it from the rack and push it off to the side.

NOTE: DO NOT ROTATE THE STEERING SHAFT – DAMAGE CAN RESULT!

Step 20: Remove (x6) manifold bolts and remove manifold along with OEM manifold gasket.

Step 21: Inspect the engine head surface is clean and free of any debris before installing aFe power header.

Step 22: Connect the primary & secondary O2 sensor extensions provided to the engine harness. Do not connect the actual O2 sensors at this time. (Set aside in vehicle for header install.)

Step 23: Install (right) aFe Header with supplied gasket and the (x6) OE bolts removed from manifold in **step 20**.

Step 24: Repeat **Step 12**.

Step 25: Reinstall the steering shaft.

Step 26: Install left & right connection pipes with (x2) v-band clamps and (x2) 3" band clamps provided. Do not fully tighten, align with exhaust system first. The connector pipes will slide into adapter tubes you have already installed on OEM exhaust.

Step 27: Place the 2.5" band clamps that are included in the kit over the reduced side of the 6" adapter tubes and install the adapter tubes onto the aFe power connection pipes. Reinstall the OE exhaust the adapters will slide over the stock exhaust system. Please Note: The 6" (05-45974) adapter tubes will not be used when installing; aFe power Cat-Back Exhaust with aFe Power Long Tube headers combination, will use adapter tubes (05-45975).

Step 28: Install secondary O2 sensors into connection pipes and plug into extensions. Zip ties these away from the exhaust. Also, its good timing to zip tie away the primary O2 sensors wiring from the mid pipes.

Step 29: Tighten all band clamps and V-band clamps.

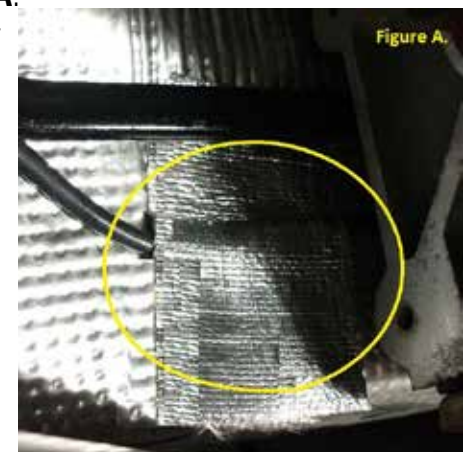
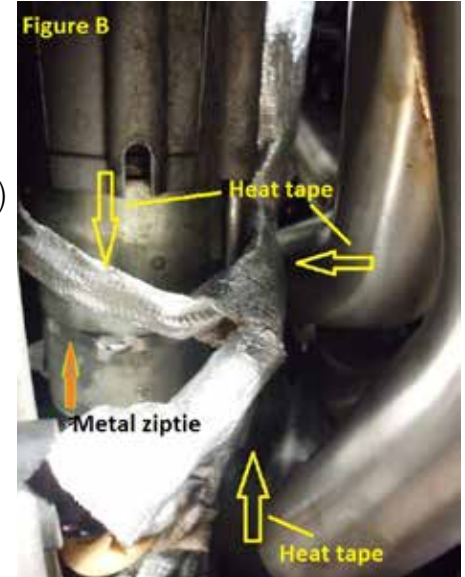
Step 30: Secure O2 wiring by left mid pipe with 3"x2.5" heat tape. Refer to **figure A**.

Step 31: Double check all work and ensure everything is tight. No wires dangling or touching exhaust.

Step 32: Reconnect battery.

Step 33: Start the vehicle and check for any leaks.

Step 34: Congratulations, Your system is now complete and fully installed! It is recommended to re-tighten all clamps and bolts after 50-100 miles.



RACE ONLY DISCLAIMER

This is a Race Only product that is to be used solely for competition, it cannot be used on vehicles that are operated on public streets, roads or highways. Its use is limited to closed-course and open-course racing that is formally sanctioned by a recognized racing organization. Any other use, including recreational off-road use, could be in violation of local, state and federal laws. A competition acknowledgement / liability release form must be filled out and submitted.