

2021+ RAM TRX 1500

HEADER INSTALLATION INSTRUCTIONS

Thanks for purchasing a Stainless Works Header system for your 2021+ Ram TRX 1500. Our team has worked to ensure that this product is the premium in performance, quality, and fitment. We are proud to say that this system will unleash the true character of your vehicle. We encourage you to read through the following steps, and check the included Bill of Materials before beginning. Please follow these steps to ensure that your installation goes as planned.



2021+ Ram TRX 1500
(RAM21188HCAT)

a. Stainless Works recommends the use of Hi-Temp RTV sensor safe silicone gasket maker as an option or in conjunction with the use of factory gaskets. The recommended Oxygen Sensor Safe RTV is either Valco All-in-One Aluminum or Permatex Copper P/N 101BR available at NAPA, Autozone and other retailers.

b. Disconnect the battery before starting to work on the exhaust system for your vehicle. Reconnect the battery when the job is completed.

c. Your exhaust system can be installed by a weekend warrior, but the use of a lift is recommended for ease of installation. If using a jack, the vehicle must be placed on a hard level surface. Jack stands are required for safety.

d. You will assemble the components together as specified below, but only snug the clamps as you move along from front to back. After aligning all the components in the vehicle, you will tighten all the clamps working from front to back of the vehicle.



Detail a

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DISASSEMBLY

1. Disconnect the battery.
2. Raise and support the vehicle.
3. Unbolt the (16) 16 mm bolts from the front, middle and transmission skid plates. Remove the plates from under the vehicle.
4. Remove the (4) 14 mm bolts from the driver & passenger flanged inlet connections (after the OEM converters).
5. Mark the location of the (4) O2 sensors, and remove both rear sensors from the OEM exhaust.
6. Unbolt the (4) 16 mm bolts from the factory catalytic converters to the manifolds.
7. Unplug both front O2 sensors.
8. Loosen the (2) 15mm clamps after the x pipe.
9. Disengage the x pipe assembly from the OEM catback.
To simplify the header installation, we have gained easier access to the manifold bolts by removing the front tires and fender liners. These next steps will be based on this method.
10. Remove both front tires.
11. Remove the fender liners by removing (15) 8mm screws and (3) push clips per side.
12. Remove (4) 15mm bolts to disconnect the front drive shaft and move it to the side.

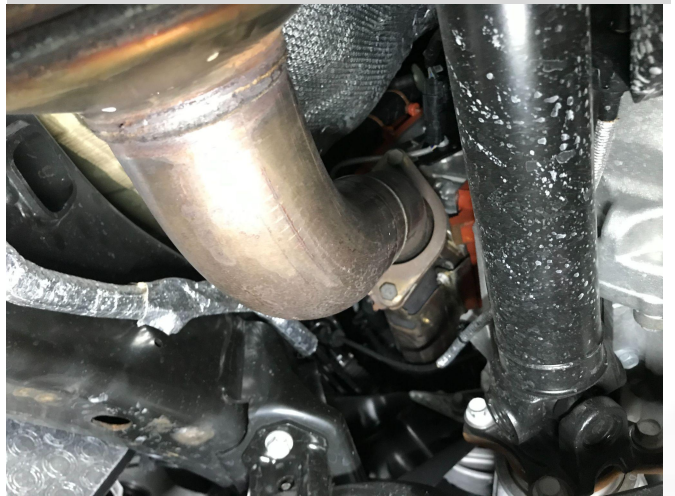
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Detail 4: Passenger flanged catback connection



Detail 6: Driver flanged connection at manifold

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PASSENGER SIDE

13.
Loosen the (4) 10 mm nuts on the heat shield & remove from vehicle.

14.
Loosen & remove the (8) 10 mm bolts from the manifold. Remove manifold from vehicle.

DRIVER SIDE

In order to install the driver side header, the axle, oil dipstick tube and motor mount must be removed

15.
Use jack stands to support the front axle.

16.
Slightly lift & support the engine until the weight of the motor is relieved from the motor mount.

17.
Unclip shift linkage from the bracket (arrow 1).

18.
Remove (2) 18 mm bolts (arrow 2).

19.
Remove (3) 18 mm bolts (arrow 1).

20.
Remove 21 mm bolt (arrow 2).

21.
Remove bracket.

22.
Remove (2) 18 mm bolts from the front axle.

23.
Remove (2) 18 mm bolts (arrow 1).

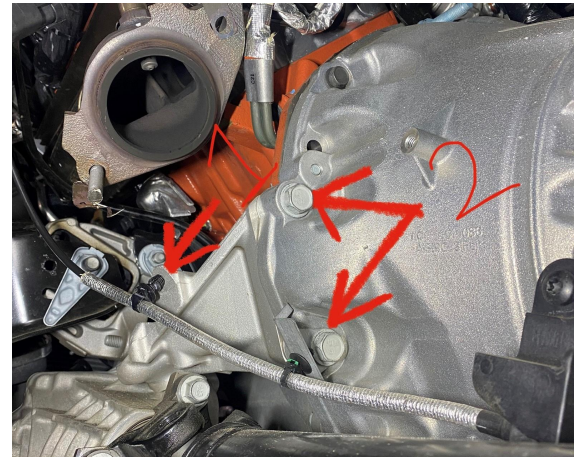
24.
Remove 21 mm bolt (arrow 2).

25.
Carefully lower the front axle to gain better access to the remaining bolts.

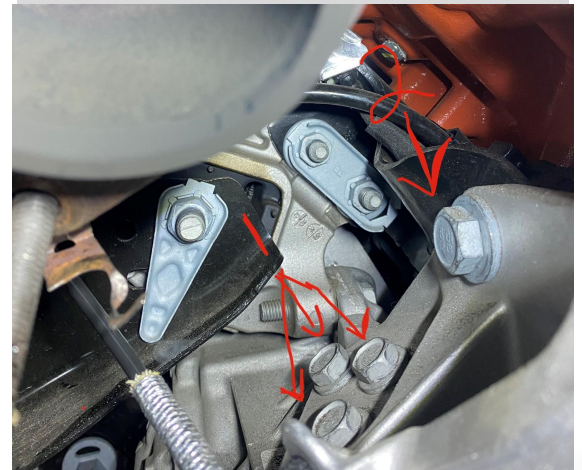
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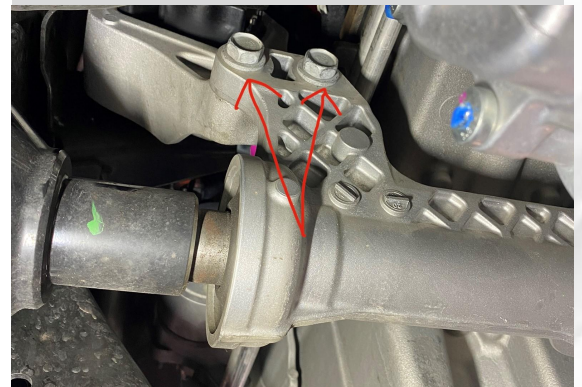
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Detail 17 & 18



Detail 19 & 20



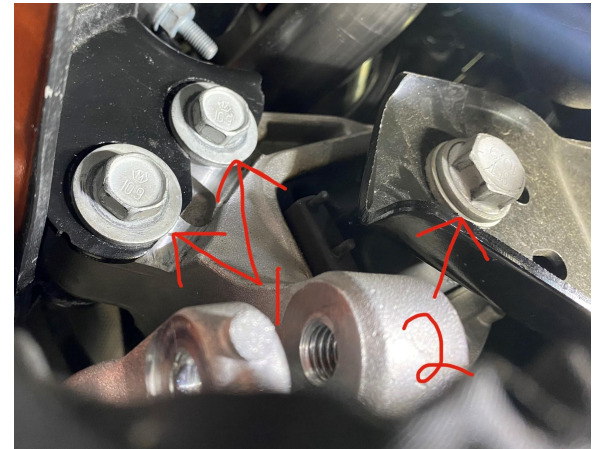
Detail 22

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26. Remove the last (2) 18 mm bolts holding the motor mount to the front axle; remove mount from vehicle.
27. Remove (4) 15 mm bolts and bracket.
28. Unbolt the (3) 10 mm bolts holding the oil dipstick tube; remove tube from vehicle.
29. Unbolt & remove manifold heat shield.
30. Loosen & remove the (8) 10 mm bolts from the drivers side manifold; remove manifold from vehicle.

ASSEMBLY

1. Install O2 extensions. The 12" long extensions are used on driver and passenger rear sensors.
2. Use the RTV to create a seal on the mating side of each header flange.
3. Install headers using the supplied bolt kit. The front bolt on the driver side will require the use of the provided spacer and the factory stud.
4. Reinstall the dipstick tube through the header..
5. Reinstall all other removed engine components.
6. Reinstall fender liners and front tires.
7. Install the high flow cats to the header outlets using (2) 3" clamps.
8. Install x pipe using (2) 3" clamps.



Detail 23 & 24



Detail 4

9. Reinstall O2 sensors into bungs and secure the wires.

10. Adjust and tighten the system from front to back.

11. Be sure to have adequate clearance around all wires, hoses, and lines. If anything is in contact with the exhaust system it will melt. Make sure to have at least ½" of clearance and wrap any suspect areas with DEI thermal barrier wrap.

12. After double checking for clearance and making sure all lines, wires and hoses are secured, drive the vehicle for 10-20 miles and re-check all clamps and clearances. Your system may be tack welded at the joints/ clamps to reduce shifting of the system during heating and cooling cycles. Make certain to disconnect the battery before performing any welding.

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