

INSTALLATION INSTRUCTIONS: #3141/3142
1966-'75 Bronco 2.25 Dual Exhaust Kit for SS Dominator Headers



865.938.6696 www.dufftuff.com
6609 Bronco Ln.
Knoxville, TN 37921

CONTENTS: (see last page for layout)

- | | | | |
|--------------------------------------|---|---|---|
| 2 Mufflers (M1/M2) | | | |
| 1 Driver side header pipe (D1/D2) | 6 | Stainless Band Clamps (C) | 4 |
| 1 Passenger side header pipe (P1/P2) | 4 | 1/4" x 1 1/4" Self Tapping Screws (HST) | 2 |
| 2 After muffler pipes (AM1/AM2) | 2 | Long L-Brackets (HL) | 2 |
| 2 Tail pipes (T1/T2) | 4 | Male Rubber Grommets (HR) | 4 |
- 1/4 6/21

TOOLS NEEDED:

- | | | | | | |
|---------------------------|-----------------------------|----------------|---------------|-----------------------------|--------------|
| Safety glasses | 3m Painters Tape | Cut Off Wheel | Floor Jack | Chop Saw | Angle Finder |
| CRC Knock'r Loose | 3/8" Drive Ratchet | Rubber Mallet | Silver Marker | 3/8" Drive Cordless Impact | Bottle Jack |
| Tape Measure | 3/8" 1/2" 9/16" 5/8" 11/16" | Vice soft jaws | Center punch | 3/8" Drive Cordless Ratchet | |
| Silver or White Paint Pen | Wrenches and sockets | 2 Jack Stands | Drill | Vertical band saw | |

OPTIONAL TOOLS:

IMPORTANT: READ INSTRUCTIONS ALL THE WAY THROUGH BEFORE BEGINNING. Install the Driver Side (D) first, then mirror the Passenger Side (P) to the Driver Side.

SAFETY FIRST! Wear your safety glasses. Protect your head and hands as well. Make sure your vehicle is secure before starting. Automatic should be in PARK and manuals should be in 1st gear. Also be sure to chock both the front and back side of at least 1 tire. Engage the E-brake and disconnect the negative side of your battery. If you need more room to work underneath your Bronco, you can use 4 jack stands and a floor jack and raise the vehicle up higher. Place jack stands under each axle as far out board as safely possible. This is a good time to spray any bolts and nuts that attach your original exhaust system to the Bronco with CRC Knock'r Loose or some other type of rust penetrant and let them soak.

BEFORE INSTALLING: This system is intended to be used only with #3140 Stainless Long Tube Headers. In the event that you chose Flowmaster mufflers, you will find that you need to trim an inch off of the long side of your AMP, in order for the back half of the exhaust to locate properly. (We leave the tube long to accommodate all the muffler configurations that we offer.) Install the exhaust clamps loosely at first to allow yourself to manipulate/seat the pipes and mufflers. This will give you the flexibility to position each pipe so they don't make contact with the frame, transference, or fuel tank. This is a DIY exhaust kit that was designed for an Early Bronco that can be built several different ways. It may not just fall together and will require a little effort to install.

1. Remove your old exhaust. Install SS Dominator Headers #3140, then continue with these instructions to finish your exhaust system.

A. Clean your transfer case, and apply painters tape to the drivers side of the case, as well as your long arm bracket and bolt (if applicable). This is a good time to check the fluid level and top it off or drain & add new.

B. Apply painters tape to both front edges of your fuel tank, as well as the inside rear quarter of your leaf spring (leading up to your shackle) and fuel tank J Bolt (if applicable).

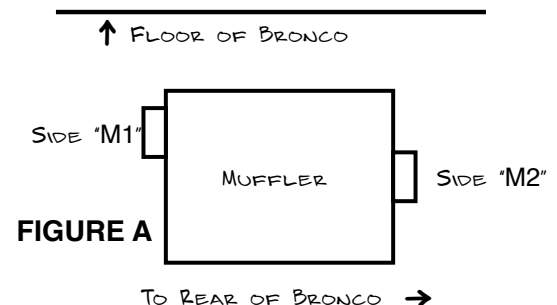
2. If you purchased system #3142, remove your 2 bolt flanges HC from your hardware box and slip them onto your intermediate pipes. (Work your way from D/P2 to D/P1)

Disregard this step if you have purchased system 3141.

3. Slide the flared end D1 over the header and utilize the Flanged/ Serrated Nut/Bolt set that was provided with the headers.

NOTE: DO NOT fully torque down these bolts, only snug them down to allow for pipe movement while the rest of your exhaust is assembled.

4. Remove a stainless band clamp C from your hardware kit and



assemble. Remove a muffler from its box and use **FIGURE A** to correctly identify each end.

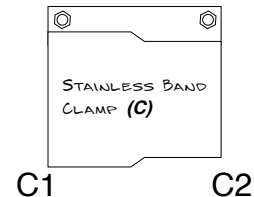
A. Slide the small end of the clamp **C2** over your intermediate pipe **D2**.

If you purchased optional Heatshield Products Muffler blankets (#3076) or Brake Line Sleeve (#3075) Install them now.

B. Slide **D2** in to **M1** and support the muffler with a floor jack or jack stand. Place a rag over Jack to prevent scratching muffler.

Note: We strongly recommend using a floor jack or bottle jack, to allow for height adjustment while setting your mounting brackets in place

C. Before proceeding see **Figure B**, Slide stainless band clamp end **C1** over **M1** and snug down. Follow **Figure B** to ensure the clamp is properly oriented when it comes time to attach the mounting bracket at step 8D.



5. With your muffler supported, take your after muffler pipe out. **NOTE: These are symmetrical, what side they go on does not matter.**

A. Put another stainless clamp together **C**. Slide **C2** over **AM1**

6. Insert **AM1** into **M2**

PRO TIP: If you have an aftermarket fuel tank, you may find it easier to install the after muffler pipe and the muffler itself at the same time. A helper will make this process even easier.

NOTE: You may have to remove up to 1" off of AM1 to fit around the fuel tank with some of our muffler options

A. The goal is to clock the After Muffler Pipe so that the bend is as high as possible without making contact with the side of the fuel tank.

B. This is to give you clearance for the breather hose, 4" bump stops, and, in the event of going airborne or hitting big bumps, not bottoming out the axle on the After Muffler Pipe.

C. Sometimes it is necessary to cut length off the end of the gas tank strap J-Bolts to allow the pipe to pass by.

E. Do not remove too much from the J-Bolt or it will make it difficult to reinstall the tank if you ever have to drop it.

F. Slide **C1** over **M2** and again snug the clamp down, leaving ability to adjust the pipe.

7. Remove another band clamp **C** and assemble.

A. Slip **C2** over **AM2**

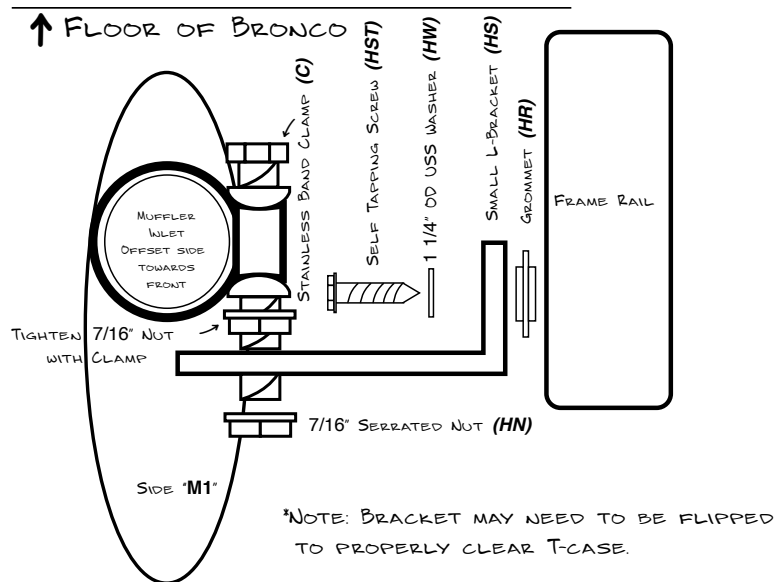
B. Take out your Tail Pipe and slip **T1** over **AM2**

C. Slide **C1** over **T1** and snug down.

D. Follow **Figure C** to ensure that the clamp **C** is correctly oriented.

DRIVER SIDE FROM FRONT SHOWN,
MIRROR FOR PASSENGER SIDE

FIGURE B



F. Support with a floor jack or jack stand just past the clamp. Place rag over jack to prevent scratching the tail pipe.

8. Take out of your hardware bag, a short L bracket **HS**, 7/16 serrated nut **HN**, self tapping screw **HST**, 1 1/4 USS washer **HW**, and rubber grommet **HR**.

A. **HR** has a small extrusion that fits directly into the short leg of **HS**.

B. Go to the clamp directly in front of the muffler that you assembled in step 4. Follow **FIGURE B** to correctly install your mounting bracket.

C. We suggest using a floor jack to lift the whole system up as high as possible without contacting the side of the frame, the transfer case, or E-Brake cables.

D. When you have everything in position. Mark your hole, remove the hardware, use a center punch, and then screw your self tapper into place.

E. Following **FIGURE B**, go ahead and attach your hardware to the clamp and tighten everything down **EXCEPT** the serrated nut **HN**. You will do this last.

9. Move to the rear of your Bronco, at the **T1/AM2** connection.
PRO TIP: We found that the long L-bracket needed to be offset from center of the frame to properly clear the leaf spring and fuel tank J-Bolt.

A. Take out of your hardware bag, a long L-bracket **HL**, 7/16" serrated nut **HN**, self tapping screw **HST**, 1/4" USS washer **HW**, and rubber grommet **HR**.

B. Follow **FIGURE C** and mark your hole in the bottom of the frame, remove your hardware, use a center punch, and screw your self tapper into place.

C. Reassemble your hardware and tighten down everything **EXCEPT** the 7/16" serrated nut **HN**.

10. Repeat steps 2 - 9, for the passenger side (**P**) pipes.

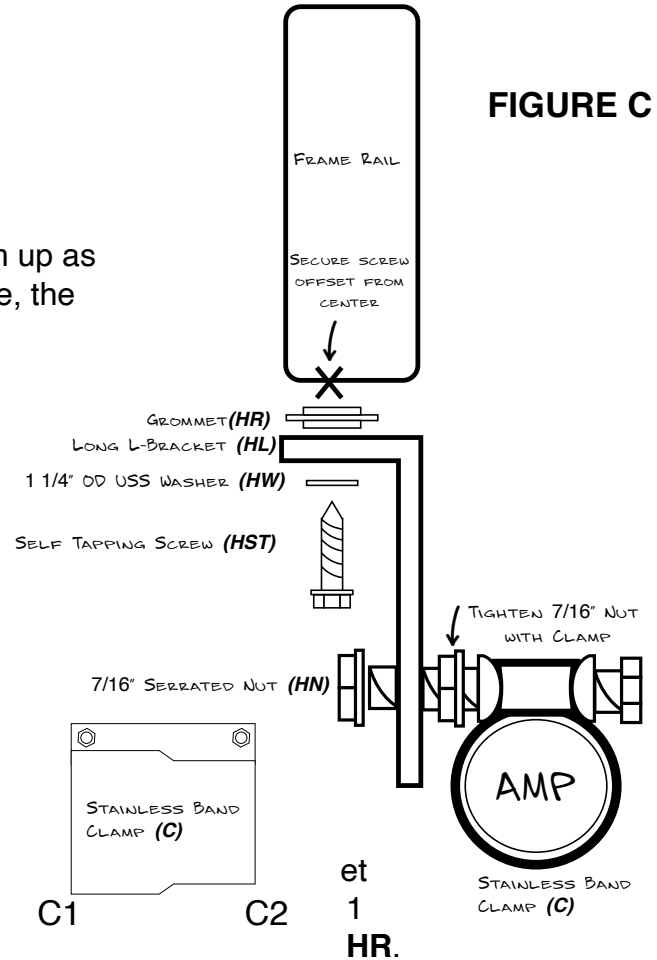
11. Stand back from the Bronco. Make sure both pipes are level and both are at the same height at the body and at the end of the tail pipe.

A. Here you can make small adjustments by massaging the pipes and/or the L brackets until the entire system is symmetrical.

B. You can move the exhaust closer or farther away from the frame at the body mount based on where **HL** is positioned.

NOTE: We make the 90° tail pipes long to accommodate for wide tires and keep exhaust fumes out of the cab. You can easily trim the pipes to a length you prefer. The easiest and best way to get a straight cut is with a chop saw. To prevent scratching the pipe, wrap with 3m painters tape first.

DRIVER SIDE SHOWN.
MIRROR FOR PASSENGER SIDE
VIEW IS FROM THE BACK LOOKING
TO THE FRONT OF THE BRONCO



C. Finish out your new exhaust with a set of polished tips from duffuff.com (3094-Straight or 3094-Angle)

12. Inspect your entire exhaust, make sure that you have plenty of clearance around all pipes and the muffler.

A. Once you are sure of this, you can apply exhaust paste where needed, and tighten down all of your clamps. Start from the front and work your way to the rear.

PRO TIP: If you are using an impact driver to tighten down your clamps the pipes will move on you. We suggest getting them tight by hand.

B. While tightening down your exhaust clamps, make sure the pipes do not move out of position and contact anything, a silver sharpie can help here (mark the clamp and the pipe at the same time)

C. Finally, tighten down the 7/16" Serrated nuts **HN**

D. Remove the painters tape where you applied it in step 1B.

13. Start your Bronco and check for leaks using a spray bottle with soapy water to spray every joint, if leaking you will see bubbles. - Do not touch the pipes or you will burn yourself.

A. If you discover leaks, turn off your bronco and tighten hardware in that area until the leaks have stopped. Exhaust paste #3058 may be required at some joints that don't seal

14. Now is time to take a test drive, get the Bronco up to operating temperature, listen for any leaks, abnormal sounds, or vibrations.

A. Allow Bronco to cool completely and recheck the tightness on all of your clamps.

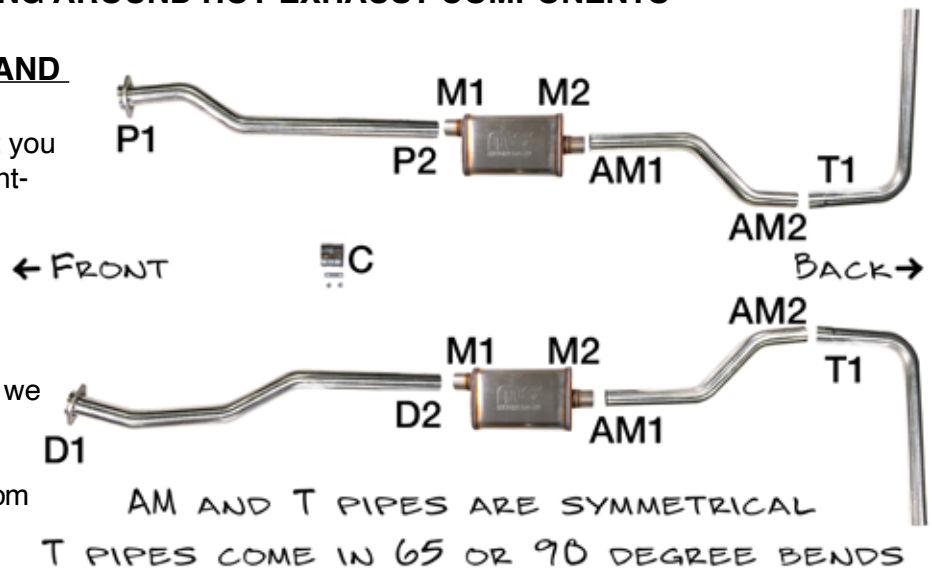
WARNING: BE CAREFUL WHEN WORKING AROUND HOT EXHAUST COMPONENTS

FINAL NOTES: ENJOY YOUR BRONCO AND YOUR AWESOME NEW EXHAUST.

If you decide to go off-roading, we suggest that you remove the tail pipes while the clamp and mounting bracket are still installed. The tail pipes are designed to be installed and removed several times or replaced if they are crushed on the trail.

If you ever want to try a different style tail pipe, we offer 2 different options.

We also offer 2 types of tips. Checkout duffuff.com for all of our exhaust options.



Thank you for choosing James Duff!



Exhaust Paste #3058



Replacement Stainless Band Clamp #AP9665



Heatshield Products Muffler Armor #3076



Heatshield Products Lava Wrap #3077/3079



Exhaust Tip #3094-Straight #3094-Angle

LIMITED WARRANTY

James Duff Inc. warrants our products to the original purchaser to be free from defects in materials and workmanship. Warranty periods begin at the date of purchase and varies by product. Shocks have a limited lifetime warranty. Headers, Radiators and Suspension Products, Power Brake Boosters and Master Cylinders have a one year warranty. Adapters and soft goods such as upholstery, vinyl and rubber products have a 90 day warranty. All warranties are to the original purchaser with proof of purchase only. Such obligations under this warranty shall be limited to the repair or replacement, at JDI's discretion, of any assembly or part which upon examination by JDI proves to be defective. Any costs of removal, installation, re-installation or freight charges are expressly excluded from this warranty. This warranty covers only manufacturers defects, and does not cover product finish or damage resulting from abuse, misuse, negligence, racing, alteration, accident or damage in transit. All returns must be pre-authorized by JDI and accompanied with a Return Goods Authorization Number (RGA) and a dated proof of purchase. Returns must be made within 90 days of purchase, packaged sufficiently to prevent damage in shipment and sent prepaid to JDI, 6609 Bronco Lane, Knoxville, TN 37921. Returns without an RGA# will be refused. This warranty is expressly in lieu of all other warranties, expressed or implied, including the implied warranties of merchantability and fitness for use. This warranty gives you specific legal rights including other rights that vary from state to state. Some states do not allow limitations on how long an implied warranty lasts, or do not allow the exclusion of limitation of incidental or consequential damages, so the above limitations and/or exclusions may not apply to you.

4/4 6/21