

# Installation Manual



## 44083 KIT

1994–2002 Dodge Ram Trucks w/5.9L Cummins Diesel Engines

*With Manual & Automatic Transmissions*

*Stock Dodge Cummins HX & HY Series Turbo\**

*Cast iron elbow designed to replace the restrictive stock Dodge elbow and increase your exhaust flow!*

\* See application guide for proper fitment.

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**Thank you and congratulations on the purchase of a Replacement Dodge Elbow to increase exhaust flow. Please read the entire manual prior to starting the installation to ensure you can complete it once started.**

**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 800.663.0096 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.**

**KIT LAYOUT**



**KIT CONTENTS**

**Please make sure all the items shown in the above kit layout are provided in your kit before starting the installation.**

KIT CONTENTS		QTY	PART #
<b>A</b>	Elbow	1	C3336
<b>B</b>	4" Adapter	1	C11342
<b>C</b>	Exhaust Clamp	1	C11350
<b>D</b>	Turbo Adapter Gasket	1	C14097
<b>E</b>	Hexhead Capscrew M8 - 1.25 x x20mm	5	C10491
<b>F</b>	Hexhead Plug 1/8 NPT	1	C11630

**BEFORE STARTING THE INSTALLATION:**

1. Ensure the application information is correct for the make, model and year of the vehicle you are installing the kit on.
2. Disconnect the negative battery terminals on both batteries.

**1 EXHAUST ELBOW INSTALLATION:**

**For all vehicles:** disconnect the negative battery terminals on both batteries. 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.

- 2 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 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 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.

- 3 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.**



1



2



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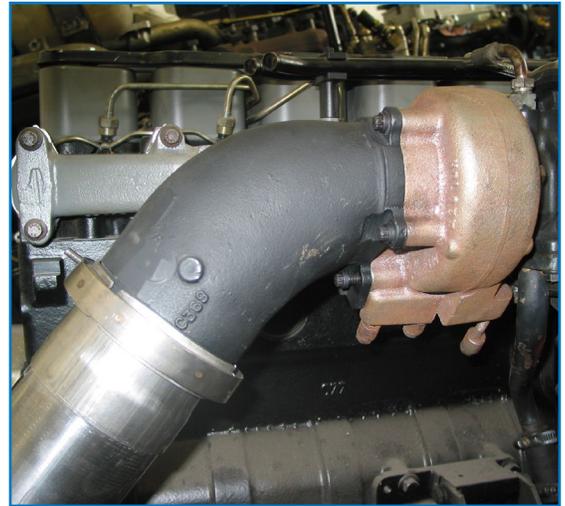
- 4 Install the shortened header pipe into the rear flange and intermediate exhaust pipe. Adjust the assembly to attain maximum clearance and a good pipe fit.

Trim the firewall insulation to attain a minimum clearance of 6" to the exhaust header pipe.

Tack weld the 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.



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

A 1/8" NPT plug is provided to plug the port if not used.

***Congratulations!***  
***You have completed the installation***