

## SCC50 / SCC51

409 Stainless Steel Axle-back exhaust systems  
for 1997-2004 C5 Corvettes

**SCC50:** 2.5" System w/ Oval tips

**SCC51:** 2.5" System w/ Dual round tips



**Pypes Performance Exhaust**  
2705 Clemens Road Bldg 105A Hatfield, PA 19440  
800-421-3890 (voice) 267-638-3507 (fax)  
[www.pypesexhaust.com](http://www.pypesexhaust.com)

Thanks again for purchasing your new 304 stainless steel Pypes Performance Exhaust Axle-back system. Please be sure to confirm all the components in the kit were received in your shipment before beginning installation. These kits will include (2) mid over axle pipes, (2) Mufflers, (2) polished tailpipes/ tips, (4) band clamps and (1) bonus pack. If you find any component missing, please contact our office at 800-421-3890 for replacement. Installation of this kit will require some simple hand tools and some penetrating lubricant. For a quicker and tighter installation, air tools are recommended. Technical assistance is available both online at [www.pypesexhaust.com](http://www.pypesexhaust.com) or 800-421-3890. Also, our online Installation Gallery is a great assistant during your installation, visit [www.pypesexhaust.com/pictures.html](http://www.pypesexhaust.com/pictures.html).

1. Begin by placing the vehicle on a lift or four jack stands at maximum height to aid in an easier installation. To help ease the installation, pre-fit all the components into a complete system on your garage floor, using the diagram provided.
2. Begin by removing the four nuts which hold the rear sway bar clamps to the back of the rear axle. The sway bar will rotate downward allowing enough room to slide the mid over-axle pipes out.
3. Using a wrench, remove the existing axle back exhaust system from the flanges just in front of the rear axle.
4. Next, remove the four nuts attaching the rear muffler hangers to the underside of the bumper support. Be careful not to push the cage bolts up into the support.
5. Now carefully slide out the entire left and right sides of the original exhaust system out from under the car.
6. Begin installing the mid over axle pipes first, making sure to install the new gasket. Tighten the bolts. Slip two band clamps over the muffler end for the next step.
7. Slide the muffler hanger bracket on to the spoon on your new polished mufflers. Carefully slide the inlet of the muffler on to the mid over axle pipe and push the rear portion of the muffler up to align the hanger bracket with the exposed cage bolts. Be careful not to push the bolts up into the bumper support. Tighten all the hanger nuts and the 1" band clamps on the muffler necks.
8. Slide the 1" band clamps onto the tip necks and install them into the outlet of the muffler. Adjust and tighten the band clamps. The 1" band clamps must be tightened using a pneumatic impact wrench to insure they are as tight as possible.
9. Finish, bolting the sway bar clamps back into place. Check all the clamps and mounting points.

**Now it's time to fire up that muscle car and enjoy your new Pypes Performance Exhaust.**

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| (A) Mid Over-Axle Pipes |
| (B) Mufflers            |
| (C) Exhaust Tips        |

