



STOP READ THIS WARNING!

Make sure you test fit these exhaust components BEFORE any cutting, welding or unnecessary bending is done. Once modified, the components of the system are NOT RETURNABLE.

If you are unsure of the proper installation procedures or fitment, please contact a qualified exhaust shop or call our tech lines toll free at 800-421-3890 or visit our installation gallery at: www.pypesexhaust.com/install

One of our experienced exhaust techs will be glad to assist you in any way. Thanks and enjoy you new...

Pypes Performance Exhaust!

SCROLL DOWN FOR INSTRUCTIONS



#SGT78 #SGT79 #SGT978E #SGT980E

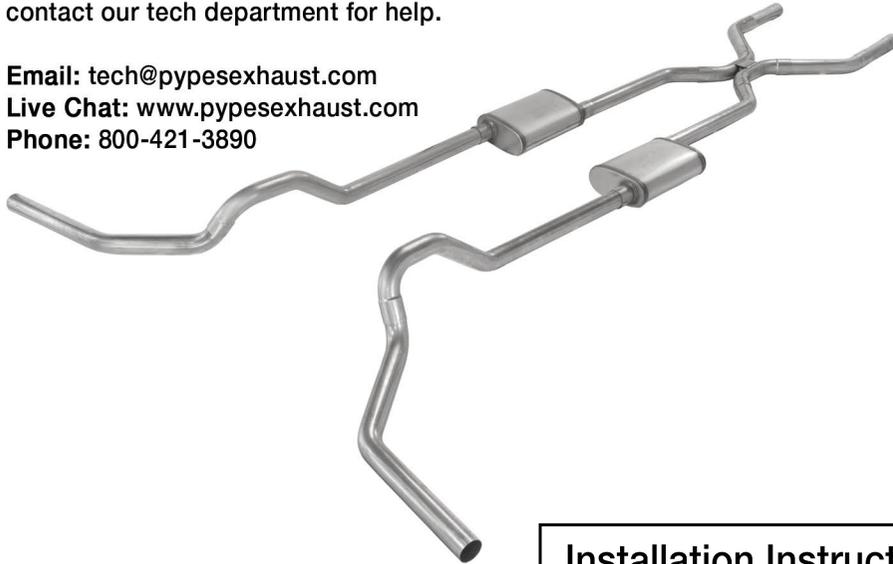
1967-74 GM Truck

2.5" Crossmember-back w/ X or H-Pipe



Thanks for purchasing your new Pypes Performance Exhaust. Please review these instructions and confirm all components were received before starting. If you find any component missing or have questions about the installation, please contact our tech department for help.

Email: tech@pypesexhaust.com
Live Chat: www.pypesexhaust.com
Phone: 800-421-3890



Bill of Materials

- 1 HVA10 H or XVA10 X
- 2 TGT10 tailpipe
- 2 muffler (optional)
- 2 PVM11 collector extension
- 2 HVH10S hanger
- 2 HVH20S hanger
- 12 HVC50 clamp
- 2 HVC37 hardware
- 2 Catalytic Converter
(SGT978E/SGT980E ONLY)

Installation Instructions

- 1 After you have inventoried the parts, place your truck on a lift or jack stands so you can work safely under your vehicle.
- 2 Remove the existing exhaust system from the headers or exhaust manifolds back. You can also remove any hangers mounted to the frame as your new kit includes factory reproduction hangers.
- 3 Begin by test installing your new side-exit tailpipes. These tailpipes are designed to run inside the rear trailing arms. Since this system uses universal style hangers, you will need to determine the approximate location to mount them. The tailpipe hangers will mount to the outside of the frame rails just behind the rear tires. The muffler hangers will get mounted to the mid crossmember where the trailing arms are attached. Custom hangers may be fabricated. Let your creativity shine.
- 4 Now, install the mufflers. The mufflers in the kit are designed to mount vertically with the logos facing left to right. The center outlet will get connected to the beginning of the tailpipes. The clamp attached to the hanger at the front side of the muffler will be the only connection clamp used.
- 5 Next, install the X or H-Pipe. This is where trimming of the tubing may be required for the optimum fit. Install the rear legs into the mufflers first. You are aiming to have the center "X" or "H" land approx. 12-16 inches behind the tailshaft of your transmission and centered under the driveshaft. Also, the center plate on the "X" or "H" has an arrow stamp which must point forward. Trim the rear legs as needed to put your "X" or "H" and mufflers in the proper location. Quick tip: If the rear suspension is unloaded, you can push the center "X" or "H" up until it just about touches the drive shaft as it will never hit once the suspension is loaded. Slide the front legs into the X or H-Pipe. They should end somewhere close to the humps in your transmission crossmember. On some applications, the front "X" or "H" legs may not be centered in the humps but line up to your headers or downpipes. This is fine as the system will not hang too low. Be extra careful when measuring and cutting. A helpful tip: Line up the front legs under the center "X" or "H" to mark your cut lines making sure to line them up with you headers or downpipes.
- 6 Continue by connecting the front legs of the X or H-Pipe to the headers utilizing the two 1ft collector extension pipes. Trimming the length will be required. Do not connect the X or H-Pipe directly to your headers. If downpipes (see downpipe instructions) are used, make sure the pipe ends close to the rear side of the transmission crossmember. If they're too long they must be trimmed. Some header applications require custom collectors due to the header not ending square and parallel to the car. For proper fit, your collectors must run parallel with your rocker panels.
- 7 Now that you have all the components loosely installed, you can make adjustments to align the system. Once you are happy with the alignment, finish tightening all the clamps. The use of air tools is recommended for this step.
- 8 Lastly, start your vehicle and check for leaks. It is not uncommon for condensation to weep from the relief cuts in the clamps for the first few heat cycles. Double-check all clamps after one week of driving.