

**KIT # 31246 409 S/S KIT**

This kit fits '78-'88 G-body GM mid-size cars, Malibu, Oldsmobile Cutlass (excluding Cutlass Supreme), Le Mans, Grand Prix, Monte Carlo, Buick Regal, all with small block V8, standard headers, and with 3" collectors at the headers.

**NOTE:** THE HEADERS ARE NOT INCLUDED IN THIS KIT!! WE RECOMMEND USAGE OF Jeg's PART # 555-30060 FOR BEST FIT OF THIS EXHAUST SYSTEM.

**NOTE:** ADDITIONALLY, YOU WILL NEED A DOUBLE-HUMP CROSS MEMBER FOR INSTALLATION OF THIS KIT. PLEASE ORDER JEG'S #550-41050 IF YOU HAVE THE TH350, OR 550-41051 FOR 700R4. THIS KIT WILL NOT FIT PROPERLY WITH THE STOCK CROSS MEMBER IN PLACE.

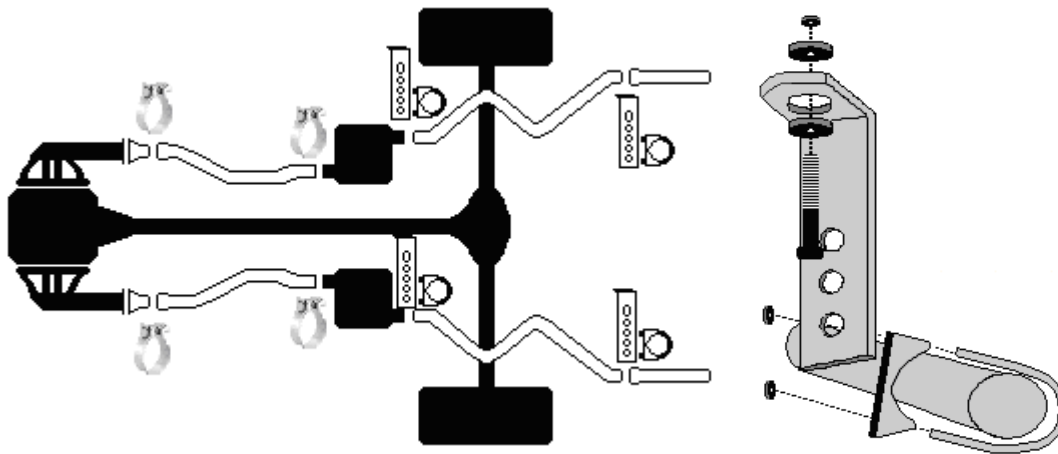
**NOTE:** THE CATALYTIC CONVERTERS ARE NOT SUPPLIED WITH THIS EXHAUST SYSTEM. THIS SYSTEM IS NOT LEGAL FOR ON-ROAD USE ON VEHICLES THAT ORIGINALLY WERE EQUIPPED WITH A CATALYTIC CONVERTER.

**NOTE:** This kit uses 409 s/s, it may have a brownish color, and a magnet will stick to it.

**DANGER WARNING:** SHOULD THE PURCHASER DECIDE TO INSTALL THIS EXHAUST PRODUCT AT HOME, BE WARNED THAT PLEASURE CAR OR LIGHT DUTY TRUCK/VAN "BUMPER" JACKS ARE INTENDED FOR EMERGENCY USE ONLY. THE USE OF FRAME CONTACT JACK STANDS IN CONJUNCTION WITH A FLOOR JACK AS MAIN SUPPORT IS HIGHLY RECOMMENDED TO MINIMIZE ACCIDENTAL DROPPING OF A VEHICLE WHILE THE INSTALLATION PROCEEDS.

**HARDWARE KIT:**

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| 4) SLB7 HANGERS, s/s                     | 2) 3" to 2-1/2" COLLECTORS, 409 S/S        |
| 4) SNAPPER GROMMETS                      | 1) RIGHT EXTENSION PIPE--#2468712, 409 S/S |
| 2) 5/16" X 1-1/4" lag screws s/s # 74509 | 1) LEFT EXTENSION PIPE--#2468711, 409 S/S  |
| 4) 2-1/2" s/s clamps # mc9212ss          | 1) LEFT TAIL PIPE--#2468713, 409 S/S       |
| 2) CF300-3SS S/S 3" FLANGES              | 1) RIGHT TAIL PIPE--#2468714, 409 S/S      |
| 6) 3/8" NUTS S/S # 70712                 | 2) TAIL PIPE EXTENSIONS--#2468715, 409 S/S |
| 6) 3/8" LOCKWASHERS S/S # 71067          |  |
| 6) 3/8" X 1-1/4" BOLTS S/S # 70107       |  |
| 2) #MP48005 3" COLLECTOR GASKETS         |  |
| 4) 5/16" X 1-1/2" BOLTS S/S # 70059      |  |
| 4) 5/16" NUTS S/S # 70711                |  |
| 4) A25BF s/s accusual clamps             |  |



Hanger consists of a metal strap, grommets, hardware and clamp (see illustration).



**Performance Products**

**1-800-345-4545 jegs.com**

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**INSTALLATION INSTRUCTIONS:**

NOTE: DO NOT TIGHTEN ANY CLAMPS OR NUTS UNTIL THE LAST STEP!!

- 1) RAISE AND SUPPORT THE AUTOMOBILE IN A SAFE AND SUITABLE MANNER--SUPPORT WITH JACK STANDS ONTO THE FRAME.
- 2) REMOVE THE OLD EXHAUST SYSTEM AFTER THE HEADERS. REMOVE THE OLD HANGERS AND BRACKETS IF DESIRED. NEW UNIVERSAL HANGERS ARE INCLUDED IN THIS KIT TO REPLACE THE ORIGINAL HANGERS. IF YOU HAVE NOT DONE SO YET, INSTALL THE DOUBLE-HUMP CROSS MEMBER JEG'S # 550-41050, OR MODIFY YOUR EXISTING CROSS MEMBER.
- 3) INSTALL THE 3" TO 2-1/2" COLLECTORS TO THE HEADERS USING THE MP48005 GASKETS AND CF300-3SS FLANGES. TIGHTEN ONLY ENOUGH TO HOLD IN PLACE, USING THE 3/8" X 1-1/4" BOLTS AND NUTS. ON CERTAIN MODELS IT MAY BE NECESSARY TO TRIM ABOUT 1-1/2" OFF OF THE HEADER COLLECTORS FOR PROPER LENGTH OF THE SYSTEM.
- 4) INSTALL THE LEFT AND RIGHT EXTENSION PIPES TO THE COLLECTORS USING 2-1/2" ACCUSEAL CLAMPS. BE SURE TO LEAVE ADEQUATE CLEARANCE BETWEEN THE FLOOR BOARDS, DOUBLE-HUMP CROSS MEMBER, AND THE DRIVE SHAFT. THE INLET ON BOTH EXTENSION PIPES IS THE I.D. OR EXPANDED END. THE LEFT EXTENSION PIPE HAS A LONGER STRAIGHT SECTION ON THE INLET END THAN THE RIGHT EXTENSION PIPE.
- 5) INSTALL THE MUFFLERS (OFFSET/OFFSET, NOT INCLUDED) ONTO THE FRONT EXTENSION PIPES USING 2-1/2" ACCUSEAL CLAMPS. ROTATE THE FRONT EXTENSION PIPES TO CLEAR THE DRIVESHAFT, CROSS MEMBER, FRAME, FLOOR, AND GENERAL CLEARANCE. WE RECOMMEND PUTTING A CROSS PATTERN SLOT ON THE INLETS OF THE MUFFLERS FOR PROPER SEALING.
- 6) MOUNT THE HANGER BRACKETS IF NECESSARY TO THE FRAME USING THE SLB7 STRAP WITH THE GROMMETS AND 5/16" X 1-1/2" BOLTS AND NUTS (OR LAG SCREWS) DIRECTLY ABOVE THE OUTLET OF THE MUFFLERS, CONNECT THE HANGERS TO THE OUTLET OF THE MUFFLERS USING 2-1/2" CLAMPS.
- 7) INSTALL THE LEFT AND RIGHT TAIL PIPES TO THE MUFFLERS USING THE SAME 2-1/2" CLAMPS USED IN STEP 6). NOTE: ON THE RIGHT SIDE, BE AWARE OF THE FUEL LINES. BE SURE TO HAVE ADEQUATE CLEARANCE AND NO LEAKS.
- 8) INSTALL THE LEFT AND RIGHT TAIL PIPE EXTENSIONS TO THE TAIL PIPES USING 2-1/2" CLAMPS. USE THESE 2-1/2" CLAMPS TO CONNECT THE TAIL PIPES, THE TAIL PIPE EXTENSIONS, AND AN SLB7 HANGER AND GROMMET AT THE REAR ON BOTH SIDES. YOU WILL NEED TO DRILL A HOLE IN THE FRAME FOR THE HANGERS. CUT THE TAIL PIPES TO YOUR DESIRED LENGTH AND LOOK.
- 9) MAKE SURE THAT ALL THE PARTS OF THE SYSTEM ARE CLEAR OF FRAME AND CROSS MEMBERS, ALL HOSES, SUSPENSION, AND BRAKE AND FUEL LINES. STARTING AT THE COLLECTORS, TIGHTEN ALL CONNECTIONS AND NUTS. MAKE SURE ALL PARTS ARE CLEAR AND WILL NOT LEAK OR RATTLE. AFTER SEVERAL DAYS OF DRIVING RETIGHTEN ALL BOLTS.

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**BUILD SHEET FOR: 2-1/2" HEADER DUAL KIT**

**PART #'S: 8458710, 31246—409 SS KIT**

- \_\_\_\_\_ 2) 3" to 2-1/2" COLLECTORS, 409 SS
- \_\_\_\_\_ 1) right ext. pipe, slotted inlet--#2468712, 409 SS
- \_\_\_\_\_ 1) left ext. pipe, slotted inlet--#2468711, 409 SS
- \_\_\_\_\_ 1) LEFT TAIL PIPE--#2468713, 409 SS
- \_\_\_\_\_ 1) RIGHT TAIL PIPE--#2468714, 409 SS
- \_\_\_\_\_ 2) TAIL PIPE EXTENSIONS #2468715, 409 SS
- \_\_\_\_\_ 1) HARDWARE KIT

INSPECTED BY: \_\_\_\_\_

DATE: \_\_\_\_\_

INSPECTED BY: \_\_\_\_\_

DATE: \_\_\_\_\_