



## 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](http://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



## SGF42 | SGF44

1967-79 GM F-bodies

**SGF42:** 2.5" w/H-pipe, qtr exit tails

**SGF44:** 3" w/H-pipe, qtr exit tails

Stainless Steel Header/Crossmember-back System



**Pypes Performance Exhaust**  
2705 Clemens Rd B103 Hatfield, PA 19440  
www.pypesexhaust.com 800-421-3890

Thanks again for purchasing your new stainless steel Pypes Performance Exhaust. Please take the time now to review these installation instructions and confirm that all the components in the kit were received in your shipment before you begin dis-assembly. If you find a component missing or have questions about the installation please contact our technical department at [tech@pypesexhaust.com](mailto:tech@pypesexhaust.com) or through our live chat room found on the home page of the Pypes website at [www.pypesexhaust.com](http://www.pypesexhaust.com).



### BILL OF MATERIALS

A	Manifold
B	Header
C	Downpipes
D	Collector Reducer
E	Collector Extensions
F	H pipe Assembly
G	Muffler
H	Tailpipes

**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.

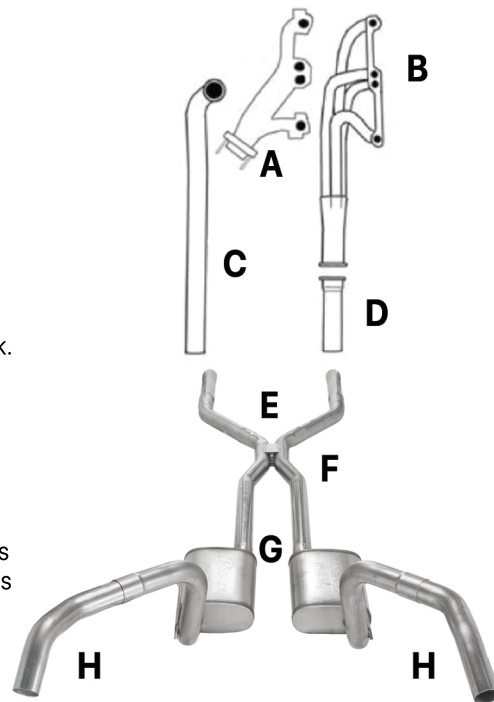
**2.** First, remove the existing exhaust system from the headers or exhaust manifolds back. You can also remove any hanger mounted to the frame as your new kit includes wire form style hangers.

**3.** Now it's time to install your new components. Begin by test installing your new tailpipes. These tailpipes have been designed in two pieces to ease installation. The expanded joint will be just above the rear near the gas tank. The kit includes some sleek wire form hangers which will get mounted to the under body and frame in the locations of the welded wire forms on the tailpipes. Do not install the hanger mounts until the system has been set into place as this will determine the height of the system. Once the tailpipes are in place, slide the mufflers on. Inlets close to the driveshaft and outlets near the spring perches.

**4.** Next, it's time to install the h-pipe. This is where trimming of the tubing may be required for the optimum fit. Install the rear "H" member into the mufflers first. You are aiming to have the center "H" land approx. 8-12 inches behind the tail shaft of your transmission and centered under the driveshaft. Also, the center plate on the "H" has an arrow stamp which must point forward. Trim the rear legs as needed to put your "H" in the proper location. Quick tip: If the rear suspension is unloaded, you can push the center "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 h-pipe. They should end somewhere close to the humps in your transmission cross-member. On some applications, the front "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 "H" to mark your cut lines making sure to line them up with you headers or down pipes. Note: Convertible owners will require their body brace to be lowered and rotated, then use our RPE631FA body brace spacer kit to make the exhaust fit properly.

**5.** Last, finish the system by connecting the front legs of the h-pipe to the headers (collector reducers) utilizing the two 1ft collector extension pipes, if needed. Trimming the length will be required. Do not connect the h-pipe directly your headers. If using a downpipe (see downpipe instructions) are used, make sure the end close to the rear side of the transmission cross member. If they are 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 system fit, you collectors must run parallel with your rocker panels.

**6.** Finish the system by making all your final adjustments to position the mufflers and piping. Now tighten all the clamps or for the best fit weld all the slip joints. The stain- less steel can be welded with your standard mig welder.



**FIRE IT UP!**