

## SGT73 | SGT74 | SGT75 | SGT76

### 1963-66 Chevrolet Truck Crossmember Back

**SGT73:** 2.5" Rear Exit with X-pipe

**SGT74:** 2.5" Rear Exit with H-pipe

**SGT75:** 2.5" Side Exit with X-pipe

**SGT76:** 2.5" Side Exit with H-pipe



**Pypes Performance Exhaust**  
2705 Clemens Rd B103 Hatfield, PA 19440  
[www.pypesexhaust.com](http://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 disassembly. 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).



1. Place the vehicle on a lift or (4) jack stands at maximum height. This will aid in an easier installation. Preassemble the system using the picture shown on the right as reference.
2. Remove the existing exhaust system along with any hangers bolted to the frame and discard, they will not be reused.
3. Begin your installation by installing the tailpipes using the HVH10S and HVH20S universal hangers. Note that tail pipes are NOT the same because of the way they snake through the suspension. Part numbers are sequenced so that the odd numbers are the driver side and even numbers are the passenger side (TGT12-1 driver TGT12-2 passenger). Location of the muffler hangers are (HVH20S) are generally in the crossmember in front of the differential. Location of the HVH10S tail pipe hangers will vary depending on your tail pipe choice.
4. Next, install the mufflers. The mufflers in the kit are designed to mount vertically with the logos facing left and right. Set the offset so it's at the top and slide them on the beginning of the tailpipes. Use HVC50 clamps to loosely secure the tailpipe connections and mufflers.
5. The X or H mid-pipe is next. Depending on your bed length you may have to trim the mid-pipe for length and width. Please note the arrow on the mid-pipe points forward toward the front of the vehicle. Normal location for the mid-pipe junction is just behind the center support crossmember. Next, install the OP9214 front legs so the mid-pipe lines up with the humps in the transmission cross member. Use six HVC50 clamps to loosely secure these components.
6. Continue connecting your system to either the factory manifolds or your headers. For factory manifolds we offer optional manifold downpipes to make this connection effortless. For header some fabrication maybe required depending on the exit location of the headers. Pypes offers a wide variety of optional solutions to aid in this style of connection.
7. Finish by aligning the system. It's best to start at the front and work your way to the rear tightening the clamps in steps until you achieve the final desired routing of your system. Start your vehicle and check for leaks. It's common for condensation to weep from the tubing joints but no air leaks should exist. Drive your vehicle and recheck for alignment and leaks after the first 100 miles making any adjustments necessary.

**ENJOY YOUR NEW PYPES PERFORMANCE EXHAUST!**