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**PART #31055**

## 2004 6.0L HO Escalade/Denali SUV Catalyst-Back Exhaust System (w/Stabilitrak)

**PACKING LIST** *Before installation, use this check list to make sure all necessary parts have been included.*

| ITEM | QTY | CHECK                    | PART NUMBER | DESCRIPTION                          |
|------|-----|--------------------------|-------------|--------------------------------------|
| 1.   | 1   | <input type="checkbox"/> | 310301607   | Muffler                              |
| 2.   | 1   | <input type="checkbox"/> | 310301620   | Passenger Side Intermediate Pipe     |
| 3.   | 1   | <input type="checkbox"/> | 310301619   | Driver Side Intermediate Pipe        |
| 4.   | 1   | <input type="checkbox"/> | 310301560   | Passenger Side Over-axle Pipe        |
| 5.   | 1   | <input type="checkbox"/> | 310301561   | Driver Side Over-axle Pipe           |
| 6.   | 1   | <input type="checkbox"/> | 310301562   | Passenger Side Tailpipe              |
| 7.   | 1   | <input type="checkbox"/> | 310301563   | Driver Side Tailpipe                 |
| 8.   | 2   | <input type="checkbox"/> | 50883       | Exhaust Tips                         |
| 9.   | 1   | <input type="checkbox"/> | 15740212    | Rubber Hanger                        |
| 10.  | 1   | <input type="checkbox"/> | 307301400   | Bracket, Muffler Hanger              |
| 11.  | 1   | <input type="checkbox"/> | 307301401   | Bracket, Driver Side Tailpipe Hanger |
| 12.  | 2   | <input type="checkbox"/> | 308302904   | 3" Exhaust Clamps                    |
| 13.  | 4   | <input type="checkbox"/> | 308302902   | 2 1/2" Exhaust Clamps                |
| 14.  | 3   | <input type="checkbox"/> | 308144380   | 2 1/2" Band Exhaust Clamp            |
| 15.  | 1   | <input type="checkbox"/> | 260100100   | Passenger Side Rear Brake line       |
| 16.  | 1   | <input type="checkbox"/> | 260100101   | Driver Side Rear Brake line          |
| 17.  | 1   | <input type="checkbox"/> | 300080103   | Bolt, 3/8"-16 x 1"                   |
| 18.  | 2   | <input type="checkbox"/> | 307080125   | Bolt, 5/16"-18 x 1"                  |
| 19.  | 1   | <input type="checkbox"/> | 30000R      | Nut, 3/8"-16                         |
| 20.  | 2   | <input type="checkbox"/> | 300570100   | Nut, 5/16"-18                        |
| 21.  | 1   | <input type="checkbox"/> | 300868013   | Washer, 3/8" Flat                    |
| 22.  | 2   | <input type="checkbox"/> | 50240       | Washer, 5/16" Flat                   |
| 23.  | 1   | <input type="checkbox"/> | 30033B      | Washer, 3/8" Lock                    |
| 24.  | 2   | <input type="checkbox"/> | 300868010   | Washer, 5/16" Lock                   |
| 25.  | 1   | <input type="checkbox"/> | *****       | Instructions                         |

**Warning:** SLP recommends allowing the vehicle to cool (not running) for five hours before beginning the installation. SLP recommends wearing safety glasses for the complete installation.

## INSTALLATION INSTRUCTIONS – #31055

1. Disconnect the negative battery terminal. Raise and fully support the vehicle (a vehicle lift is recommended).

2. Remove the OEM exhaust system by first unbolting the flange at the passenger side catalytic converter outlet. Then loosen the band clamp at the driver side catalytic converter outlet. Next, disconnect all rubber hangers from the exhaust system leaving all the rubber hangers mounted to the vehicle, except for the muffler hanger which will be relocated. Remove the exhaust system. You will need to cut the OEM exhaust at the rear axle in order to remove it.

3. Identify the hanger bracket for the muffler. It is the one with two 5/16" bolt holes in it. Place one of the 5/16" flat washers onto a 5/16" bolt and put it through the top hole in the bracket so the threaded end of the bolt is pointing the same direction as the hanger end. Put the other 5/16" flat washer and a lock washer on the bolt and thread the 5/16"-18 nut on only a couple of threads.

4. Locate the 2" keyhole shaped holes on the inside of the passenger side frame rail near the front of the factory muffler location (See photo 1). Place the muffler hanger bracket up into position so the head of the bolt you placed in the bracket goes through the big end of the top keyhole into the frame. Make sure the washer goes inside the frame as well. Then slide the bracket towards the front of the vehicle so the bolt slides into the smaller slot and holds the bracket on the frame rail. Insert the lower 5/16" bolt and a flat washer through the frame and bracket using the opening on the outside of the frame. Hold the bolt head with a socket and extension through the access hole and put the remaining 5/16" flat washer, lock washer and nut on. Tighten the bolts to 25 lb/ft. If you cannot get a wrench on the upper bolt through the same hole in the frame then the bolt should be able to be tightened by hand until it is snug then using a large screw driver or pry bar apply pressure to the head of the bolt. The friction should allow the bolt to be tightened adequately. When installed it should look like Photo 2.



Photo 1



Photo 2

5. Put the factory rubber muffler hanger removed earlier onto the new muffler hanger.

6. Put the new passenger side intermediate pipe up into place on the converter outlet flange and connect it using the original hardware. Leave it loose to allow for adjustment later.

7. Place a 2.5" band exhaust clamp on to the inlet of the driver side intermediate pipe and slide the pipe onto the converter outlet. Loosely tighten the clamp.

8. Place a 3" exhaust clamp onto both of the 3" inlet stubs of the new muffler. Put the muffler up into place with the hanger pointed upwards, slipping it over the outlet end of the intermediate pipe fully, and engaging the rubber insulator over the hanger welded onto the muffler. Tighten the 3" clamps only enough to hold the muffler in place.

9. Next remove both rear axle brake lines. Then loosen the retaining bolt for the rear axle housing brake line bracket and rotate the bracket 90 degrees counter-clockwise (when viewed from below the vehicle) so that it is positioned with the rubber brake hose outlets facing the driver side as shown in photo 3.



Photo 3

10. Install both the new driver and passenger side rear axle brake lines.

11. Locate the "auto leveling suspension" air compressor on the outside of the driver side rear frame rail just behind the rear wheel. It is covered by a rubber shield. Photo 4 shows it with this shield removed. Remove the shield by prying all the plastic retaining pins off the bracket

12. Loosen the 3 nuts retaining the compressor bracket to the frame. The holes bolts are in are key hole shaped just like ones for the muffler bracket. Slide the pump and bracket rearward to release the bolt heads from the frame.

13. Rotate the rear of the compressor upwards until the rear lower retaining bolt can be inserted into the upper frame hole. The front bolt remains where it is, while the upper bolt will no longer be used. Insert the bolt heads into the frame and slide it forward to engage the small end of the key hole. Torque the nuts to xx ft/lbs.

14. Reinstall the rubber shield.

## INSTALLATION INSTRUCTIONS CONT. - #31055

15. Place a 2.5" exhaust clamp (2-bolt) onto the inlet end of the passenger side over-axle pipe (The passenger side over-axle pipe is the only 2.5" pipe with no hanger). Put the pipe up into place, slipping the inlet end, with clamp, over the passenger side outlet stub on the muffler. Tighten the 2.5" clamp only enough to hold the pipe in place.

16. Slide the passenger side tailpipe (the passenger side tailpipe has only one bend and a hanger) and 2.5" clamp onto the passenger side over axle pipe and tighten just enough to hold in position.

17. Now install the driver side over-axle pipe (The driver side over-axle pipe has 3 bends). Slide the a two bolt 2.5" exhaust clamp onto the driver side over-axle pipe inlet. Place the pipe up over the axle and onto the muffler outlet. Then slide the hanger into the factory rubber isolator.

18. Locate the hole on the outside of the driver side rear frame rail. Take the driver side tail pipe hanger bracket and hook the bracket over the top of the frame rail aligning the bolt hole with the hole in the frame (see photo 4). Through the opening in the rear of the frame rail insert the 3/8"-16 bolt with a 3/8" flat washer through the frame and the bracket. Then place the other 3/8" flat washer and the lock washer on the bolt and thread the 3/8" nut onto it. Tighten to 25 lb/ft and slide the rubber exhaust hanger included in the kit onto the hanger.

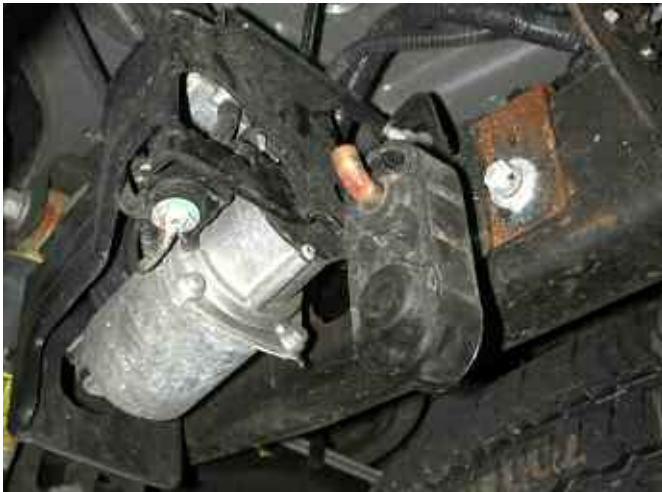


Photo 4

19. Now place the last 2.5" exhaust clamp onto the inlet end of the driver side tailpipe (the driver side tailpipe has 2 bends and a hanger) and connect it to the driver side over-axle pipe. Then insert the hanger into the rubber isolator installed in step 13 making sure the hanger hangs vertically. Do NOT fully tighten the slip joint or hanger yet.

20. Place a 2.5" Torca band clamp onto each exhaust tip and install the two tips on each tail pipe outlet. Do NOT tighten clamps yet.

21. Starting at the intermediate pipe and working rearward, adjust all the pipes until the tips are located as desired and all the pipes have enough clearance from all suspension, brake lines, fuel tank, driveline, and body parts. Tighten the two bolts at the converter outlet flange first, and work rearward tightening each clamp and hanger. Check tip alignments once all clamps are tightened. Re-adjust as necessary.

22. After the pipes are all in position wrap the large cable tie around the entire auto leveling compressor assembly and rubber shield to prevent the rubber shield from sagging down and melting on the hot tailpipe.

23. Lower vehicle and connect negative battery terminal. Check brake line for possible contact with over-axle pipe and adjust as necessary.

24. Bleed the rear brakes and top off the master cylinder with brake fluid.

25. Start engine and check for leaks. Test drive the vehicle and readjust as necessary.